

Legacy

High Performance Solid Carbide Drills



- Premium Submicron Carbide
 - PVD TiAlN Coated
 - Available In Short, Long, and Extra-Long Lengths
 - Coolant Through Design



High Performance Design for a Wide Range of Applications

The Legacy provides high performance in a wide variety of materials. It is ideally suited to perform in all general engineering steels, high-alloy and tool steels, cast iron, as well as many stainless steel applications. This reduces inventory needed to machine a broad range of materials.

Double Margin Design

Four margins greatly enhance tool stability. This improves hole geometry and straightness. Stability is provided when inclusions, cross holes, irregular exits, and incline exits are encountered.

Flute Design

The flute design is well matched to the point and provides rapid chip removal enabling high penetration rates.

Lower Thrust Point Design

The 140° point is designed to lower thrust requirements making the tool more versatile in varied work environments.

Coolant-Through Design

Coolant is delivered directly to the point which enables higher cutting speeds and chip loads.

Factory Reconditioning

The high performance experienced with a new tool can be restored through reconditioning to factory tolerances.

In presence of
James O'Connell
John Burgess

Inventor:
Stephen A. Morse

Legacy

Short Length

High Performance Solid Carbide

Coolant-Through Drills

For Steel and Cast Iron

Drill and Shank Diameter Tolerances			
Drill Diameter (D)	Tolerance m7	Shank Diameter (d)	Tolerance h6
3<D≤6 .1181<D≤.2362	+0.004/+0.016 +.0002/+0.006	6 .2362	0.000/-0.008 .0000/-0.0003
6<D≤10 .2362<D≤.3937	+0.006/+0.021 +.0002/+0.008	8 - 10 .3150 - .3937	0.000/-0.009 .0000/-0.0004
10<D≤18 .3937<D≤.7087	+0.007/+0.025 +.0003/+0.010	12 - 18 .4724 - .7087	0.000/-0.011 .0000/-0.0004
18<D .7087<D	+0.008/+0.029 +.0003/+0.011	20 .7874	0.000/-0.013 .0000/-0.0005

Foret à haut rendement au carbure

Broca de carburo de alto rendimiento



Speeds & Feeds: Page 13

List 5400S Short Coolant Through

INCH	FRACTION	SIZE		DEC. EQUIV.	FLUTE LENGTH	OAL MM	SHANK DIA.	SHANK LENGTH	MAX DOC	EDP NO.	
		LETTER	WIRE								
5/32			21	4mm	.1562	24	66	6	36	17	52200
				.1575	24	66	6	36	17	52201	
				.1590	24	66	6	36	17	52202	
				.1654	24	66	6	36	17	52203	
				.1772	24	66	6	36	17	52204	
3/16			3	4.8mm	.1875	28	66	6	36	20	52205
				.1890	28	66	6	36	20	52206	
				.1969	28	66	6	36	20	52207	
				.2130	28	66	6	36	20	52208	
				.2165	28	66	6	36	20	52209	
7/32		A		5.8mm	.2188	28	66	6	36	20	52210
				.2210	28	66	6	36	20	52211	
				.2283	28	66	6	36	20	52212	
				.2340	28	66	6	36	20	52213	
				.2362	28	66	6	36	20	52214	
				.2420	34	79	8	36	24	52215	
1/4		C		6.5mm	.2500	34	79	8	36	24	52216
				.2559	34	79	8	36	24	52217	
				.2570	34	79	8	36	24	52218	
				.2660	34	79	8	36	24	52219	
				.2677	34	79	8	36	24	52220	
9/32		E		7mm	.2720	34	79	8	36	24	52221
				.2756	34	79	8	36	24	52222	
				.2770	34	79	8	36	24	52223	
				.2812	41	79	8	36	29	52224	
				.2953	41	79	8	36	29	52225	
				.2969	41	79	8	36	29	52226	
5/16		F		8mm	.3125	41	79	8	36	29	52227
				.3150	41	79	8	36	29	52228	
				.3230	47	89	10	40	35	52229	
				.3230	47	89	10	40	35	52229	

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Legacy

Short Length High Performance Solid Carbide Coolant-Through Drills For Steel and Cast Iron



Low Thrust Point Design.
Honed Cutting Edges

Foret à haut rendement au carbure

Broca de carburo de alto rendimiento



(continued)

List 5400S Short Coolant Through

INCH	FRACTION	SIZE			DEC. EQUIV.	FLUTE LENGTH	OAL MM	SHANK DIA.	SHANK LENGTH	MAX DOC	EDP NO.		
		LETTER	WIRE	METRIC									
	21/64	Q			.3281	47	89	10	40	35	52230		
					.3320	47	89	10	40	35	52231		
				8.5mm	.3346	47	89	10	40	35	52232		
				9mm	.3543	47	89	10	40	35	52233		
					.3594	47	89	10	40	35	52234		
	23/64	U			.3680	47	89	10	40	35	52235		
				9.5mm	.3740	47	89	10	40	35	52236		
				.3810	3/8	.3750	47	89	10	40	35	52237	
					25/64		.3810	47	89	10	40	35	52238
							.3906	47	89	10	40	35	52239
		10mm	.3937	47	89	10	40	35	52240				
	13/32				.4062	55	102	12	45	40	52241		
				10.5mm	.4134	55	102	12	45	40	52242		
				27/64		.4219	55	102	12	45	40	52243	
						.4331	55	102	12	45	40	52244	
						.4375	55	102	12	45	40	52245	
	7/16			11.5mm	.4528	55	102	12	45	40	52246		
				15/32		.4688	55	102	12	45	40	52247	
						.4724	55	102	12	45	40	52248	
						.4921	60	107	14	45	43	52249	
				.5050	1/2				.5000	60	107	14	45
	.5050	60	107					14	45	43	52251		
13mm	.5118	60	107					14	45	43	52252		
13.5mm	.5315	60	107					14	45	43	52253		
14mm	.5512	60	107					14	45	43	52254		
	9/16				.5625	65	115	16	48	45	52255		
				14.5mm	.5709	65	115	16	48	45	52256		
				15mm	.5906	65	115	16	48	45	52257		
				5/8		.6250	65	115	16	48	45	52258	
						.6299	65	115	16	48	45	52259	
.6330	3/4				.6330	73	123	18	48	51	52260		
					.7500	79	131	20	50	55	52261		

LEGACY High Performance Carbide Drills

Legacy

Long Length High Performance Solid Carbide Coolant-Through Drills For Steel and Cast Iron

Drill and Shank Diameter Tolerances			
Drill Diameter (D)	Tolerance m7	Shank Diameter (d)	Tolerance h6
3<D≤6 .1181<D≤.2362	+0.004/+0.016 +.0002/+0.006	6 .2362	0.000/-0.008 .0000/-0.0003
6<D≤10 .2362<D≤.3937	+0.006/+0.021 +.0002/+0.008	8 - 10 .3150 - .3937	0.000/-0.009 .0000/-0.0004
10<D≤18 .3937<D≤.7087	+0.007/+0.025 +.0003/+0.010	12 - 18 .4724 - .7087	0.000/-0.011 .0000/-0.0004
18<D .7087<D	+0.008/+0.029 +.0003/+0.011	20 .7874	0.000/-0.013 .0000/-0.0005

Foret à haut rendement au carbure

Broca de carburo de alto rendimiento



Speeds & Feeds: Page 13

List 5400L Long Coolant Through

INCH	SIZE			DEC. EQUIV.	FLUTE LENGTH	OAL MM	SHANK DIA.	SHANK LENGTH	MAX DOC	EDP NO.	
	FRACTION	LETTER	WIRE								
5/32			21	3.5mm	.1378	36	74	6	36	29	52280
				.1562	36	74	6	36	29	52281	
				4mm	.1575	36	74	6	36	29	52282
				.1590	36	74	6	36	29	52283	
				4.2mm	.1653	36	74	6	36	29	52284
3/16			3	4.5mm	.1772	36	74	6	36	29	52285
				.1875	44	82	6	36	35	52286	
				4.8mm	.1890	44	82	6	36	35	52287
				.1969	44	82	6	36	35	52288	
				5mm	.2130	44	82	6	36	35	52289
7/32			2	5.5mm	.2165	44	82	6	36	35	52290
				.2188	44	82	6	36	35	52291	
				.2210	44	82	6	36	35	52292	
				5.8mm	.2283	44	82	6	36	35	52293
				.2340	44	82	6	36	35	52294	
1/4			C	6mm	.2362	44	82	6	36	35	52295
				.2420	44	82	6	36	35	52296	
				E	.2500	53	91	8	36	43	52297
				6.5mm	.2559	53	91	8	36	43	52298
				.2570	53	91	8	36	43	52299	
9/32			J	6.8mm	.2677	53	91	8	36	43	52300
				.2660	53	91	8	36	43	52301	
				I	.2720	53	91	8	36	43	52302
				7mm	.2756	53	91	8	36	43	52303
				.2770	53	91	8	36	43	52304	
19/64				7.5mm	.2812	53	91	8	36	43	52305
				.2812	53	91	8	36	43	52306	
				.2953	53	91	8	36	43	52307	
5/16				.2969	.2969	53	91	8	36	43	52307
				.3125	.3125	53	91	8	36	43	52308
				8mm	.3150	53	91	8	36	43	52309

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Legacy

Long Length High Performance Solid Carbide Coolant-Through Drills For Steel and Cast Iron



Low Thrust Point Design.
Honed Cutting Edges

Foret à haut rendement au carbure

Broca de carburo de alto rendimiento



(continued)

List 5400L Long Coolant Through

INCH	FRACTION	SIZE		WIRE	METRIC	DEC. EQUIV.	FLUTE LENGTH	OAL MM	SHANK DIA.	SHANK LENGTH	MAX DOC	EDP NO.
		LETTER										
	21/64					.3281	61	103	10	40	49	52310
		P				.3230	61	103	10	40	49	52311
		Q				.3320	61	103	10	40	49	52312
					8.5mm	.3346	61	103	10	40	49	52313
					9mm	.3543	61	103	10	40	49	52314
	23/64					.3594	61	103	10	40	49	52315
		U				.3680	61	103	10	40	49	52316
					9.5mm	.3740	61	103	10	40	49	52317
	3/8					.3750	61	103	10	40	49	52318
.3810						.3810	61	103	10	40	49	52319
					10mm	.3937	61	103	10	40	49	52320
	13/32					.4062	71	118	12	45	56	52321
					10.5mm	.4134	71	118	12	45	56	52322
	27/64					.4219	71	118	12	45	56	52323
					11mm	.4331	71	118	12	45	56	52324
	7/16					.4375	71	118	12	45	56	52325
					11.5mm	.4528	71	118	12	45	56	52326
	15/32					.4688	71	118	12	45	56	52327
					12mm	.4724	71	118	12	45	56	52328
					12.5mm	.4921	77	124	14	45	60	52329
.5050	1/2					.5000	77	124	14	45	60	52330
						.5050	77	124	14	45	60	52331
					13mm	.5118	77	124	14	45	60	52333
					13.5mm	.5315	77	124	14	45	60	52334
					14mm	.5512	77	124	14	45	60	52335
	9/16					.5625	83	133	16	48	63	52336
					14.5mm	.5709	83	133	16	48	63	52337
					15mm	.5906	83	133	16	48	63	52338
	5/8					.6250	83	133	16	48	63	52339
					16mm	.6299	83	133	16	48	63	52340
.6330						.6330	93	143	18	48	71	52341
	3/4					.7500	101	153	20	50	77	52342

LEGACY High Performance Carbide Drills

Legacy

**Extra Long Length
High Performance Solid Carbide
Coolant-Through Drills
For Steel and Cast Iron**

Drill and Shank Diameter Tolerances			
Drill Diameter (D)	Tolerance m7	Shank Diameter (d)	Tolerance h6
3<D≤6 .1181<D≤.2362	+0.004/+0.016 +.0002/+0.006	6 .2362	0.000/-0.008 .0000/-0.0003
6<D≤10 .2362<D≤.3937	+0.006/+0.021 +.0002/+0.008	8 - 10 .3150 - .3937	0.000/-0.009 .0000/-0.0004
10<D≤18 .3937<D≤.7087	+0.007/+0.025 +.0003/+0.010	12 - 18 .4724 - .7087	0.000/-0.011 .0000/-0.0004
18<D .7087<D	+0.008/+0.029 +.0003/+0.011	20 .7874	0.000/-0.013 .0000/-0.0005

Foret à haut rendement au carbure

Broca de carburo de alto rendimiento



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List 5400XL Extra Long Coolant Through

INCH	SIZE			DEC. EQUIV.	FLUTE LENGTH	OAL MM	SHANK DIA.	SHANK LENGTH	MAX DOC	EDP NO.	
	FRACTION	LETTER	WIRE METRIC								
5/32				.1562	49	87	6	36	41	52360	
3/16			21	.1590	56	94	6	36	48	52361	
			3	5mm	.1875	56	94	6	36	48	52362
					.1969	56	94	6	36	48	52363
					.2130	56	94	6	36	48	52364
			5.5mm	.2165	56	94	6	36	48	52365	
7/32			2	.2188	56	94	6	36	48	52366	
				.2210	56	94	6	36	48	52367	
				A	.2340	56	94	6	36	48	52368
					6mm	.2362	56	94	6	36	48
1/4			6.5mm	C	.2420	67	105	8	36	57	52370
				E	.2500	67	105	8	36	57	52371
				F	.2559	67	105	8	36	57	52372
					.2570	67	105	8	36	57	52373
17/64				.2656	67	105	8	36	57	52374	
			7mm	H	.2660	67	105	8	36	57	52375
				I	.2677	67	105	8	36	57	52376
					.2720	67	105	8	36	57	52377
				J	.2756	67	105	8	36	57	52378
					.2770	72	110	8	36	61	52379
9/32			7.5mm	.2812	72	110	8	36	61	52380	
				.2953	72	110	8	36	61	52381	
19/64				.2969	72	110	8	36	61	52382	
5/16			8mm	.3125	72	110	8	36	61	52383	
				.3150	72	110	8	36	61	52384	
21/64			8.5mm	P	.3230	80	122	10	40	68	52385
				Q	.3281	80	122	10	40	68	52386
					.3320	80	122	10	40	68	52387
					.3346	80	122	10	40	68	52388
11/32				.3438	80	122	10	40	68	52389	

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Legacy

Extra Long Length High Performance Solid Carbide Coolant-Through Drills For Steel and Cast Iron



Low Thrust Point Design.
Honed Cutting Edges

Foret à haut rendement au carbure

Broca de carburo de alto rendimiento



(continued)

List 5400XL Extra Long Coolant Through

INCH	FRACTION	SIZE		METRIC	DEC. EQUIV.	FLUTE LENGTH	OAL MM	SHANK DIA.	SHANK LENGTH	MAX DOC	EDP NO.
		LETTER	WIRE								
				9mm	.3543	80	122	10	40	68	52390
	23/64	U			.3594	80	122	10	40	68	52391
					.3680	80	122	10	40	68	52392
				9.5mm	.3740	80	122	10	40	68	52393
	3/8				.3750	80	122	10	40	68	52394
.3810					.3810	80	122	10	40	68	52395
	25/64				.3906	80	122	10	40	68	52396
				10mm	.3937	80	122	10	40	68	52397
	13/32				.4062	94	141	12	45	79	52398
				10.5mm	.4134	94	141	12	45	79	52399
	27/64				.4219	94	141	12	45	79	52400
				11mm	.4331	94	141	12	45	79	52401
	7/16				.4375	94	141	12	45	79	52402
				11.5mm	.4528	94	141	12	45	79	52403
	29/64				.4531	94	141	12	45	79	52404
				12mm	.4724	94	141	12	45	79	52405
				12.5mm	.4921	108	155	14	45	91	52406
.5050	1/2				.5000	108	155	14	45	91	52407
					.5050	108	155	14	45	91	52408
				13mm	.5118	108	155	14	45	91	52409
				13.5mm	.5315	108	155	14	45	91	52410
				14mm	.5512	108	155	14	45	91	52411
	9/16				.5625	121	171	16	48	101	52412
				14.5mm	.5709	121	171	16	48	101	52413
				15mm	.5906	121	171	16	48	101	52414
	5/8				.6250	121	171	16	48	101	52415
				16mm	.6299	121	171	16	48	101	52416
.6330					.6330	135	185	18	48	113	52417
	11/16				.6875	135	185	18	48	113	52418
				18mm	.7087	135	185	18	48	113	52419
	3/4				.7500	148	200	20	50	124	52420

LEGACY High Performance Carbide Drills