

# **Guide to Understanding Nachi Catalog Index**

# Visual Index

	Mark	Explanation	Mark	Explanation
Coating	<b>G</b>	G (TiN) Coating	<b>N</b>	Normal Helix Flutes ~ 30°
	<b>UG</b>	UG (TiCN multi layer) Coating	<b>H</b>	High Helix Flutes 40° - 45°
	<b>SG</b>	SG (TiCN multi layer) Coating	<b>L</b>	Low Helix Flutes 15° - 20°
	<b>AG</b>	AG (TiAlN multi layer) Coating	<b>★</b>	Point Angle of Drills
	<b>AQ</b>	AQ (TiAlN multi layer) Coating	<b>DL</b>	Drill Length is from Center Point
	<b>X's</b>	X's (TiAlN multi layer) Coating	<b>DL</b>	Drill Length is from Corner Point
	<b>GS</b>	GS (TiAlN multi layer) Coating	<b>AD</b>	Oil-hole Drills
	<b>DLC</b>	DLC Coating	<b>FLUTE</b>	Three Flutes Drills
	<b>DIA</b>	Diamond Coating	<b>TR</b>	Shape of Lip Relief is Conical
	Tool Materials	<b>HSS</b>	High Speed Steels	<b>TR</b>
<b>HSS Co</b>		Cobalt High Speed Steels	<b>TR</b>	Shape of Lip Relief is Three Rake
<b>FMX</b>		Fine Melting HSS	<b>ST</b>	S-type Thinning
<b>FAX</b>		High Grade Powder HSS	<b>NT</b>	Notch Thinning
<b>PREMIER</b>		Vanadium HSS	<b>ST</b>	X-type Thinning
<b>HSS-V</b>		Vanadium HSS	<b>ST</b>	
<b>HSS-E</b>		Cobalt/Vanadium HSS	<b>ST</b>	XH-type Thinning
<b>Overlays</b>		Tungsten Carbide	<b>TR</b>	2Rake Relief & X-type Thinning
			<b>TR</b>	2Rake Relief & XR-type Thinning
			<b>TR</b>	3 Flutes Drills & 3F-type Thinning

	Mark	Explanation	Mark	Explanation	
Tolerance of Drills Dia.	<b>js6</b>	Tolerance of Drills Diameter is js6	Flutes of End Mills	<b>4F</b>	4 Flutes Radius End mills (Center Cut)
	<b>h7</b>	Tolerance of Drills Diameter is h7		<b>2FN</b>	2 Flutes Ball Nose End mills (Center Cut)
	<b>h8</b>	Tolerance of Drills Diameter is h8		<b>4FN</b>	4 Flutes Ball Nose End mills (Center Cut)
Flutes of End Mills	<b>SH</b>	Sharp corner Type End mills	<b>6FN</b>	6 Flutes Ball Nose End mills (Center Cut)	
	<b>2F</b>	2 Flutes Square End mills (Center Cut)	Type of Taps	<b>CT</b>	Cutting Taps
	<b>3F</b>	3 Flutes Square End mills (Center Cut)		<b>FT</b>	Forming Taps
	<b>4F</b>	4 Flutes Square End mills (Center Cut)	Flutes of Taps	<b>ST</b>	Straight Flutes Taps
	<b>4FX</b>	4 Flutes Square for X's-mill Hard (Center Cut)		<b>SP</b>	Spiral Pointed Taps
	<b>5F</b>	5 Flutes Square End mills (Center Cut)		<b>NH</b>	Normal Helix Flutes Taps
	<b>6F</b>	6 Flutes Square End mills (Center Cut)		<b>HH</b>	High Helix Flutes Taps
	<b>6FX</b>	6 Flutes Square for X's-mill Hard & X's-mill Multi Flutes (Center Cut)		<b>L</b>	Low Helix Flutes Taps
	Chamfer of Taps	<b>8FX</b>	8 Flutes Square for X's-mill Hard & X's-mill Multi Flutes (Center Cut)	<b>NB</b>	Chamfer Length is 2.5P to 3P
		<b>4FH</b>	4 Flutes Square End mills (with Center Hole)	<b>P</b>	Chamfer Length is 4P to 5P (for through hole)
		<b>5FH</b>	5 Flutes Square End mills (with Center Hole)	<b>B</b>	Chamfer Length is 1.5P (for blind hole)
		<b>6FH</b>	6 Flutes Square End mills (with Center Hole)	<b>2.5P</b>	Chamfer Length is 2.5P
		<b>8FH</b>	Multiple Flutes (over 8) Square End mills (with Center Hole)	<b>3.5P</b>	Chamfer Length is 3.5P
		<b>2FR</b>	2 Flutes Radius End mills (Center Cut)	<b>TAPE</b>	Cutting Taps for Taper Pipe

## Drills / Visual Index

### List 7572P STUB LENGTH SG-ESS / METRIC SIZES

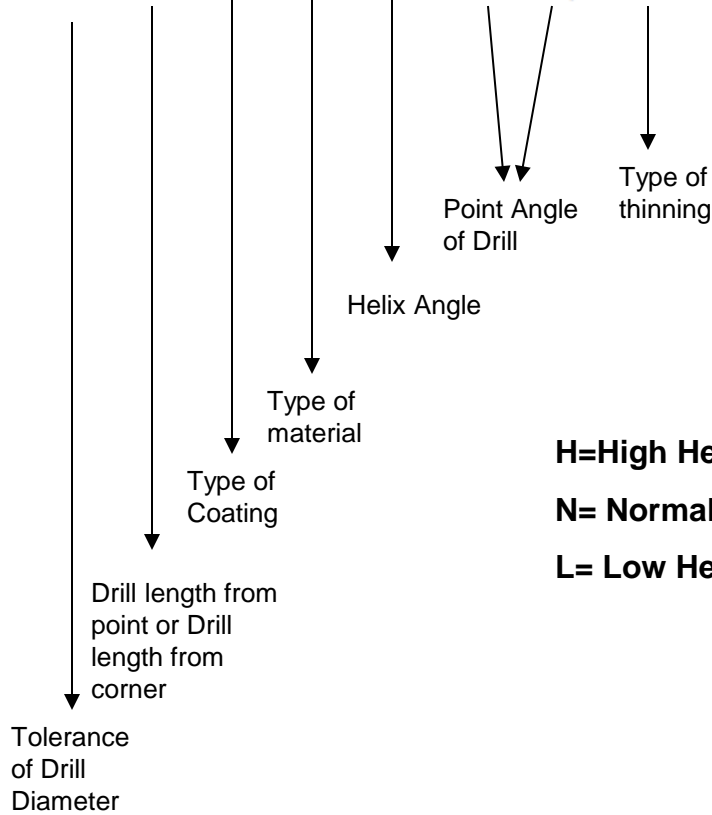


Specs/Sizes  
Speeds/Feeds

P48  
P100

Specs/  
sizes

Speeds &  
Feeds



**H=High Helix (40° )**  
**N= Normal Helix (30° )**  
**L= Low Helix (15° )**

# Drill Diameter Tolerance

## Tolerance of Drill Diameter

Unit : 0.001mm

Diameter (mm)		Under 3.0 D≤3	Above 3.0 Under 6.0 3<D≤6	Above 6.0 Under 10 6<D≤10	Above 10 Under 18 10<D≤18	Above 18 Under 30 18<D≤30	Above 30 Under 50 30<D≤50	Above 50 Under 80 50<D≤80	Above 80 Under 120 80<D≤120
Tighter    Looser	js6	±3	±4	±4.5	±5.5	±6.5	±8	±8.5	±11
	h6	0 -6	0 -8	0 -9	0 -11	0 -13	0 -16	0 -19	0 -22
	h7	0 -10	0 -12	0 -15	0 -18	0 -21	0 -25	0 -30	0 -35
	h8	0 -14	0 -18	0 -22	0 -27	0 -33	0 -39	0 -46	0 -54

**Thank You**