



Tools – Black & Gold Jobber Length Drill Bits



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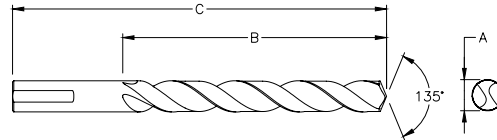
Application

Use black & gold HSS-Co5 drills for:

- Alloyed and unalloyed steel (up to strength of 1200 N/mm2)
- Steel resistant to rust and acid
- Cast iron
- Aluminum
- Aluminum alloys
- Copper
- Brass and bronze

Black & Gold Drills

These high performance twist drills are suitable for all normal drilling in conventional materials. High Speed Steel bits with 5% Cobalt alloy (HSS-Co5) and a black oxide surface treatment on the bevel decreases cutting forces and increases wear resistance of the bit.



Jobber length drill bit

Features

RUKO black & gold drills 5/32 and larger feature a 3-surface shank that helps align the bit in the chuck and eliminates bit spinning to provide ideal power transmission. A 135° cutting edge precisely aligns the bit and helps prevent drill bit walking. The black oxide surface treatment on the bevel increases wear resistance, preventing cold welding and edge build up and helps reduce current draw on the machine. The 40° helix angle enables fast chip removal and allows a high cutting speed with bit stability.

- Point Cut: from 1/16" dia. with split point DIN 1412 C
- Shank: 5/32 and larger, three-surface shank
- Point angle: 135°
- Helix angle: 40°
- Right hand cutting

Jobber Length Drill Bits - Fractional Sizes

Part # Black and Gold HSS-Co5	Pcs/ Pkg	Price	Drill Size (Gauge) (in.)	Ø Size (A) (in.)	Flute Length (B) (in.)	Overall Length (C) (in.)	For Tapping Use With
228801	10	Retired	1/16	0.0625	7/8	1-7/8	
228802	10	Retired	5/64	0.0781	1	2	
228803	10	Retired	3/32	0.0938	1 1/4	2-1/4	
228804	10	Retired	7/64	0.1094	1 1/2	2-5/8	
228805	10	Retired	1/8	0.1250	1-5/8	2-3/4	
228806	10	Retired	9/64	0.1406	1-3/4	2-7/8	
228807	10	Retired	5/32	0.1562	2	3-1/8	
228808	10	Retired	11/64	0.1719	2-1/8	3-1/4	
228809	10	Retired	3/16	0.1875	2-5/16	3-1/2	
228810	10	Retired	13/64	0.2031	2-7/16	3-5/8	
228811	10	Retired	7/32	0.2188	2-1/2	3-3/4	
228812	10	Retired	15/64	0.2344	2-5/8	3-7/8	
228813	10	Retired	1/4	0.2500	2-3/4	4	
228814	10	Retired	17/64	0.2656	2-7/8	4-1/8	
228815	10	Retired	9/32	0.2813	2-15/16	4-1/4	
228816	10	Retired	19/64	0.2969	3-1/16	4-3/8	
228817	10	Retired	5/16	0.3125	3-3/16	4-1/2	265038UNC
228818	10	Retired	21/64	0.3281	3-5/16	4-5/8	
228819	10	Retired	11/32	0.3438	3-7/16	4-3/4	
228820	10	Retired	23/64	0.3594	3-1/2	4-7/8	
228821	10	Retired	3/8	0.3750	3-5/8	5	
228822	10	Retired	25/64	0.3906	3-3/4	5-1/8	
228823	10	Retired	13/32	0.4062	3-7/8	5-1/4	
228824	5	Retired	27/64	0.4219	3-15/16	5-3/8	
228825	5	Retired	7/16	0.4375	4-1/16	5-1/2	
228826	5	Retired	29/64	0.4531	4-3/16	5-5/8	
228827	5	Retired	15/32	0.4688	4-5/16	5-3/4	
228828	5	Retired	31/64	0.4844	4-3/8	5-7/8	
228829	5	Retired	1/2	0.5000	4-1/2	6	

Fractional