



Application

Use HSS, HSS-Co5 and HSS-TiN coated drills for:

- Steel and stainless steel
- Alloyed and unalloyed cast iron (up to strength of 13,000 psi)
- Grey, malleable, ductile and die-cast iron
- Sintered iron, nickel silver, graphite
- Short chipping aluminum alloys
- · Brass and bronze

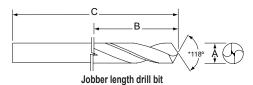
Jobber Length Drill Bits

These high performance twist drills are suitable for all normal drilling in conventional materials. Drill bits are available in High Speed Steel (HSS), High Speed Steel with 5% Colbalt alloy (HSS-Co5) and Titanium Nitride-coated High Speed Steel (HSS-TiN).

- Point Cut: 1/8" dia. with split point DIN 1412 C
- Point angle: 118° HSS & HSS-TiN / 135° HSS-Co5
- Helix angle: 20° to 30°
- Right hand cutting

Features The HSS groun

The HSS ground twist drill is made of heavyduty high-speed steel. The fully ground twist drill has a more precise concentricity. HSS-Co5 drills are ideally suited for materials that are especially difficult to drill such as stainlesss steel and for higher chip loading. HSS-TiN models add a titanium nitride coating to increase the surface hardness to approximately 2300 HV and the heat resistance to 1100°F (600°C). This also provides longer tool life with increased cutting speeds.



*Point angle for HSS-Co5 bits is 135°

	Jobber Length Drill Bits - Fractional Sizes							
	Part # High Speed Steel	Pcs /Pkg	Price	Drill Size) (in.)	Ø Size (A) (in.)	Flute Length (B) (in.)	Overall Length (C) (in.)	For Tapping Use With
	<u>214802</u>	10	\$5.50	5/64	0.0781	1	2	
	<u>214803</u>	10	\$6.00	3/32	0.0938	1 1/4	2-1/4	
	<u>214804</u>	10	\$6.75	7/64	0.1094	1 1/2	2-5/8	
	<u>214805</u>	10	\$7.75	1/8	0.1250	1-5/8	2-3/4	
	<u>214806</u>	10	\$8.25	9/64	0.1406	1-3/4	2-7/8	
	214807	10	\$8.25	5/32	0.1562	2	3-1/8	
	214808	10	\$9.00	11/64	0.1719	2-1/8	3-1/4	
onal	214809	10	\$11.00	3/16	0.1875	2-5/16	3-1/2	
Fractional	214810	10	\$12.00	13/64	0.2031	2-7/16	3-5/8	
F	214811	10	\$13.00	7/32	0.2188	2-1/2	3-3/4	
	214813	10	\$14.00	1/4	0.2500	2-3/4	4	
	214814	10	\$17.00	17/64	0.2656	2-7/8	4-1/8	
	214815	10	\$18.00	9/32	0.2813	2-15/16	4-1/4	
	214817	10	\$19.00	5/16	0.3125	3-3/16	4-1/2	265038UNC
	214819	10	\$26.00	11/32	0.3438	3-7/16	4-3/4	
	214821	10	\$31.00	3/8	0.3750	3-5/8	5	
	214822	10	\$32.00	25/64	0.3906	3-3/4	5-1/8	
	214825	5	\$21.50	7/16	0.4375	4-1/16	5-1/2	
	214829	5	\$27.00	1/2	0.5000	4-1/2	6	

	Jobber Length Drill Bits - Number and Letter Sizes							
	Part # High Speed Steel	Pcs/Pkg	Price	Drill Size (Gauge)	Ø Size A (in. dec.)	Flute Length B (in.)	Overall Length C (in.)	For Tapping Use With
٦.	<u>2149007</u>	10	\$12.00	7	0.2010	2	3-3/8	<u>265014UNC</u>
Number	2149021	10	\$9.00	21	0.1590	1-5/8	2-15/16	<u>265100UNF</u>
	2149025	10	\$8.25	25	0.1495	1-5/8	2-15/16	<u>265100UNC</u>
	2149029	10	\$7.75	29	0.1360	1-9/16	2-7/8	265080UNC, 265080UNF
	2149036	10	\$8.25	36	0.1065	1-1/4	2-3/8	265060UNC
Letter	214900F	10	\$14.50	F	0.2570	2-3/8	4	265516UNC





Drill Bit Sets				
Part #	Price	Description		
<u>101026USRO</u>	\$76.00	Three-piece Step Drill Bit Set High Speed Steel, bright finish, spiral fluted with split point. Drill size 1: 6 steps from 3/16" to 1/2" with 1/16" increments. Shank size 1/4" Drill size 2: 13 steps from 1/8 to 1/2" with 1/32" increments. Shank size 1/4" Drill size 3: 9 steps from 1/4" to 3/4" with 1/16" increments. Shank size 3/8"		
101026USERO	\$109.00	Three-piece Step Drill Bit Set HSS-Co5 spiral fluted with split point. Drill size 1: 6 steps from 3/16" to 1/2" with 1/16" increments. Shank size 1/4" Drill size 2: 13 steps from 1/8 to 1/2" with 1/32" increments. Shank size 1/4" Drill size 3: 9 steps from 1/4" to 3/4" with 1/16" increments. Shank size 3/8"		
<u>101026USTRO</u>	\$120.00	Three-piece Step Drill Bit Set HSS-TiN coated spiral fluted with split point. Drill size 1: 6 steps from 3/16" to 1/2" with 1/16" increments. Shank size 1/4" Drill size 2: 13 steps from 1/8 to 1/2" with 1/32" increments. Shank size 1/4" Drill size 3: 9 steps from 1/4" to 3/4" with 1/16" increments. Shank size 3/8"		
214850RO	\$40.50	21-piece jobber Length Drill Set Fractional sizes 1/16" to 3/8" in increments of 1/64" High-speed steel, 118 degrees point		
<u>214851RO</u>	\$66.00	29-piece jobber Length Drill Set Fractional sizes 1/16" to 1/2" in increments of 1/64" High-speed steel, 118 degrees point.		