



## **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

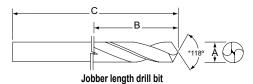
## **Jobber Length Drill Bits**

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 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	
nal	214809	10	\$11.00	3/16	0.1875	2-5/16	3-1/2	
Fractional	<u>214810</u>	10	\$12.00	13/64	0.2031	2-7/16	3-5/8	
F	<u>214811</u>	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							
Number	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
	2149007	10	\$12.00	7	0.2010	2	3-3/8	<u>265014UNC</u>
	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	<u>265516UNC</u>





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.		