



Tools – Jobber Length Drill Bits



214816

Jobber Length Drills

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% Cobalt 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

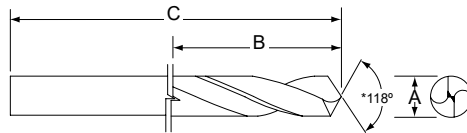
Features

The HSS ground twist drill is made of heavy-duty 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 stainless 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.

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 bit

*Point angle for HSS-Co5 bits is 135°

Jobber Length Drill Bits - Fractional Sizes

Part # High Speed Steel	Pcs /Pkg	Price	Part # Titanium Coated	Pcs/ Pkg	Price	Part # Cobalt 5	Pcs/ Pkg	Price	Drill Size (Gauge) (in.)	Ø Size (A) (in.)	Flute Length (B) (in.)	Overall Length (C) (in.)	For Tapping Use With
214801	10		250801T	10		215801	10		1/16	0.0625	7/8	1-7/8	
214802	10		250802T	10		215802	10		5/64	0.0781	1	2	
214803	10		250803T	10		215803	10		3/32	0.0938	1 1/4	2-1/4	
214804	10		250804T	10		215804	10		7/64	0.1094	1 1/2	2-5/8	
214805	10		250805T	10		215805	10		1/8	0.1250	1-5/8	2-3/4	
214806	10		250806T	10		215806	10		9/64	0.1406	1-3/4	2-7/8	
214807	10		250807T	10		215807	10		5/32	0.1562	2	3-1/8	
214808	10		250808T	10		215808	10		11/64	0.1719	2-1/8	3-1/4	
214809	10		250809T	10		215809	10		3/16	0.1875	2-5/16	3-1/2	
214810	10		250810T	10		215810	10		13/64	0.2031	2-7/16	3-5/8	
214811	10		250811T	10		215811	10		7/32	0.2188	2-1/2	3-3/4	
214812	10		250812T	10		215812	10		15/64	0.2344	2-5/8	3-7/8	
214813	10		250813T	10		215813	10		1/4	0.2500	2-3/4	4	
214814	10		250814T	10		215814	10		17/64	0.2656	2-7/8	4-1/8	
214815	10		250815T	10		215815	10		9/32	0.2813	2-15/16	4-1/4	
214816	10		250816T	10		215816	10		19/64	0.2969	3-1/16	4-3/8	
214817	10		250817T	10		215817	10		5/16	0.3125	3-3/16	4-1/2	265038UNC
214818	10		250818T	10		215818	10		21/64	0.3281	3-5/16	4-5/8	
214819	10		250819T	10		215819	10		11/32	0.3438	3-7/16	4-3/4	
214820	10		250820T	10		215820	10		23/64	0.3594	3-1/2	4-7/8	
214821	10		250821T	10		215821	10		3/8	0.3750	3-5/8	5	
214822	10		250822T	10		215822	10		25/64	0.3906	3-3/4	5-1/8	
214823	10		250823T	10		215823	10		13/32	0.4062	3-7/8	5-1/4	
214824	5		250824T	5		215824		Retired	27/64	0.4219	3-15/16	5-3/8	
214825	5		250825T	5		215825	5		7/16	0.4375	4-1/16	5-1/2	
214826	5		250826T	5		215826	5		29/64	0.4531	4-3/16	5-5/8	
214827	5		250827T	5		215827	5		15/32	0.4688	4-5/16	5-3/4	
214828	5		250828T	5		215828	5		31/64	0.4844	4-3/8	5-7/8	
214829	5		250829T	5		215829	5		1/2	0.5000	4-1/2	6	



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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
Number	2149003	10		3	0.2130	2-1/4	3-3/4	265014UNF
	2149007	10		7	0.2010	2	3-3/8	265014UNC
	2149014	10		14	0.1820	1-11/16	3-1/8	265120UNF
	2149016	10		16	0.1770	1-7/8	3-1/8	265120UNC
	2149021	10		21	0.1590	1-5/8	2-15/16	265100UNF
	2149025	10		25	0.1495	1-5/8	2-15/16	265100UNC
	2149029	10		29	0.1360	1-9/16	2-7/8	265080UNC , 265080UNF
	2149033	10		33	0.1130	1-5/16	2-3/8	265060UNF
	2149036	10		36	0.1065	1-1/4	2-3/8	265060UNC
	2149037	10		37	0.1040	1-1/4	2-1/4	265050UNF
	2149038	10		38	0.1015	1-1/4	2-1/4	265050UNC
	2149042	10		42	0.0935	1-1/4	2-1/4	265040UNF
	2149043	10		43	0.0890	1-1/16	2-1/16	265040UNC
Letter	214900F	10		F	0.2570	2-3/8	4	265516UNC
	214900I	10		I	0.2720	2-3/4	4-1/4	265516UNF
	214900Q	10		Q	0.3320	3	4-5/8	265038UNF
	214900R	10		R	0.3390	3-7/16	4-3/4	231018NPT

Jobber Length Drill Bits - Metric Sizes									
	Part # High Speed Steel	Pcs/Pkg	Price	Part # Cobalt 5	Pcs/Pkg	Price	Drill Size A (mm)	Flute Length B (mm)	Overall Length C (mm)
Metric	214010	10		215010	10		1.0	12.0	34.0
	214015	10		215015	10		1.5	18.0	40.0
	214020	10		215020	10		2.0	24.0	49.0
	214025	10		215025	10		2.5	30.0	57.0
	214030	10		215030	10		3.0	33.0	61.0
	214033	10		215033	10		3.3	36.0	65.0
	214035	10		215035	10		3.5	39.0	70.0
	214040	10		215040	10		4.0	43.0	75.0
	214042	10		215042	10		4.2	43.0	75.0
	214045	10		215045	10		4.5	47.0	80.0
	214050	10		215050	10		5.0	52.0	86.0
	214055	10		215055	10		5.5	57.0	93.0
	214060	10		215060	10		6.0	57.0	93.0
	214065	10		215065	10		6.5	63.0	101.0
	214068	10		215068	10		6.8	69.0	109.0
	214070	10		215070	10		7.0	69.0	109.0



Tools – Jobber Length Drill Bits

Jobber Length Drill Bits - Metric Sizes Continued									
Metric	Part # High Speed Steel	Pcs/Pkg	Price	Part # Cobalt 5	Pcs/Pkg	Price	Drill Size A (mm)	Flute Length B (mm)	Overall Length C (mm)
	214075	10		215075	10		7.5	69.0	109.0
	214080	10		215080	10		8.0	75.0	117.0
	214085	10		215085	10		8.5	75.0	117.0
	214090	10		215090		Retired	9.0	81.0	125.0
	214095	10		215095	10		9.5	81.0	125.0
	214100	10		215100	10		10.0	87.0	133.0
	214102	10		215102	10		10.2	87.0	133.0
	214105	5		215105	5		10.5	87.0	133.0
	214110	5		215110	5		11.0	94.0	142.0
	214115	5		215115	5		11.5	94.0	142.0
	214120	5		215120	5		12.0	101.0	151.0
	214125	5		215125	5		12.5	101.0	151.0
	214130	5		215130	5		13.0	101.0	151.0

Tools – Drill Bit Sets

**214214RO**

Drill Bit Sets		
Part #	Price	Description
<u>101026USRO</u>		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"
<u>101026USERO</u>		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>		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"
<u>214214RO</u>		19-piece jobber Length Drill Set Metric sizes 1.0 to 10.0 mm in increments of 0.5 mm High-speed steel, 118 degrees point
<u>214215RO</u>		25-piece jobber Length Drill Set Metric sizes 1.0 to 13.0 mm in increments of 0.5 mm High-speed steel, 118 degrees point
<u>215214RO</u>		19-piece jobber Length Drill Set Metric sizes 1.0 to 10.0 mm in increments of 0.5 mm High-speed steel Cobalt 5 alloy, 135 degrees point
<u>215215RO</u>		25-piece jobber Length Drill Set Metric sizes 1.0 to 13.0 mm in increments of 0.5 mm High-speed steel Cobalt 5 alloy, 135 degrees point
<u>214850RO</u>		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>		29-piece jobber Length Drill Set Fractional sizes 1/16" to 1/2" in increments of 1/64" High-speed steel, 118 degrees point.
<u>215850RO</u>		21-piece jobber Length Drill Set Fractional sizes 1/16" to 3/8" in increments of 1/64" High-speed steel Cobalt 5 alloy, 135 degrees point
<u>215851RO</u>		29-piece jobber Length Drill Set Fractional sizes 1/16" to 1/2" in increments of 1/64" High-speed steel Cobalt 5 alloy, 135 degrees point.
<u>250850TRO</u>		21-piece jobber Length Drill Set Fractional sizes 1/16" to 3/8" in increments of 1/64" TiN-coated high-speed steel, 118 degrees point
<u>250851TRO</u>		29-piece jobber Length Drill Set Fractional sizes 1/16" to 1/2" in increments of 1/64" TiN-coated high-speed steel, 118 degrees point