

# Drill Bits

**214816**

## Application

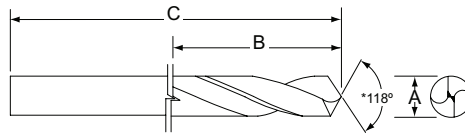
Use HSS, HSS-Co5 and HSS-TiN coated drills for:

- 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% 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

**Jobber length drill bit**

## 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.

**\*Point angle for HSS-Co5 bits is 135°**

### Jobber Length Drill Bits - Fractional Sizes

|            | Part #<br>High Speed<br>Steel | Pcs<br>/Pkg | Price | Drill Size )<br>(in.) | Ø Size (A)<br>(in.) | Flute Length<br>(B)<br>(in.) | Overall Length<br>(C)<br>(in.) | For<br>Tapping<br>Use With |
|------------|-------------------------------|-------------|-------|-----------------------|---------------------|------------------------------|--------------------------------|----------------------------|
| Fractional | <a href="#">214802</a>        | 10          |       | 5/64                  | 0.0781              | 1                            | 2                              |                            |
|            | <a href="#">214803</a>        | 10          |       | 3/32                  | 0.0938              | 1 1/4                        | 2-1/4                          |                            |
|            | <a href="#">214804</a>        | 10          |       | 7/64                  | 0.1094              | 1 1/2                        | 2-5/8                          |                            |
|            | <a href="#">214805</a>        | 10          |       | 1/8                   | 0.1250              | 1-5/8                        | 2-3/4                          |                            |
|            | <a href="#">214806</a>        | 10          |       | 9/64                  | 0.1406              | 1-3/4                        | 2-7/8                          |                            |
|            | <a href="#">214807</a>        | 10          |       | 5/32                  | 0.1562              | 2                            | 3-1/8                          |                            |
|            | <a href="#">214808</a>        | 10          |       | 11/64                 | 0.1719              | 2-1/8                        | 3-1/4                          |                            |
|            | <a href="#">214809</a>        | 10          |       | 3/16                  | 0.1875              | 2-5/16                       | 3-1/2                          |                            |
|            | <a href="#">214810</a>        | 10          |       | 13/64                 | 0.2031              | 2-7/16                       | 3-5/8                          |                            |
|            | <a href="#">214811</a>        | 10          |       | 7/32                  | 0.2188              | 2-1/2                        | 3-3/4                          |                            |
|            | <a href="#">214813</a>        | 10          |       | 1/4                   | 0.2500              | 2-3/4                        | 4                              |                            |
|            | <a href="#">214814</a>        | 10          |       | 17/64                 | 0.2656              | 2-7/8                        | 4-1/8                          |                            |
|            | <a href="#">214815</a>        | 10          |       | 9/32                  | 0.2813              | 2-15/16                      | 4-1/4                          |                            |
|            | <a href="#">214817</a>        | 10          |       | 5/16                  | 0.3125              | 3-3/16                       | 4-1/2                          | <a href="#">265038UNC</a>  |
|            | <a href="#">214819</a>        | 10          |       | 11/32                 | 0.3438              | 3-7/16                       | 4-3/4                          |                            |
|            | <a href="#">214821</a>        | 10          |       | 3/8                   | 0.3750              | 3-5/8                        | 5                              |                            |
|            | <a href="#">214822</a>        | 10          |       | 25/64                 | 0.3906              | 3-3/4                        | 5-1/8                          |                            |
|            | <a href="#">214825</a>        | 5           |       | 7/16                  | 0.4375              | 4-1/16                       | 5-1/2                          |                            |
|            | <a href="#">214829</a>        | 5           |       | 1/2                   | 0.5000              | 4-1/2                        | 6                              |                            |

### Jobber Length Drill Bits - Number and Letter Sizes

|        | Part #<br>High Speed<br>Steel | Pcs/Pkg | Price | Drill Size<br>(Gauge) | Ø Size<br>A<br>(in. dec.) | Flute Length<br>B<br>(in.) | Overall Length<br>C<br>(in.) | For Tapping<br>Use With                               |
|--------|-------------------------------|---------|-------|-----------------------|---------------------------|----------------------------|------------------------------|-------------------------------------------------------|
| Number | <a href="#">2149007</a>       | 10      |       | 7                     | 0.2010                    | 2                          | 3-3/8                        | <a href="#">265014UNC</a>                             |
|        | <a href="#">2149021</a>       | 10      |       | 21                    | 0.1590                    | 1-5/8                      | 2-15/16                      | <a href="#">265100UNF</a>                             |
|        | <a href="#">2149025</a>       | 10      |       | 25                    | 0.1495                    | 1-5/8                      | 2-15/16                      | <a href="#">265100UNC</a>                             |
|        | <a href="#">2149029</a>       | 10      |       | 29                    | 0.1360                    | 1-9/16                     | 2-7/8                        | <a href="#">265080UNC</a> , <a href="#">265080UNF</a> |
|        | <a href="#">2149036</a>       | 10      |       | 36                    | 0.1065                    | 1-1/4                      | 2-3/8                        | <a href="#">265060UNC</a>                             |
| Letter | <a href="#">214900F</a>       | 10      |       | F                     | 0.2570                    | 2-3/8                      | 4                            | <a href="#">265516UNC</a>                             |

# Drill Bits

**214214RO**

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