



# HIGH SPEED STEEL METRIC JOBBER LENGTH DRILLS

ICS WIS

GENERAL PURPOSE

118° POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL	TECHNICAL	
			SPECS	DATA	SHANK
<b>JDM</b>	 OXIDE FINISH	For general purpose and production machine drilling in ferrous or non-ferrous metals. Thicker web construction for extended drill life. Relief ground and twist fluted for maximum strength and rigidity.	M2	118° Point Std. Spiral Thicker Web	Str. 3/8 1/2
<b>JDMP</b>	 BRIGHT POLISHED FINISH	For portable or machine drilling in ferrous or non-ferrous metals. Polished ground flutes reduce loading when drilling soft materials like aluminum, brass, etc.	M2	118° Point Std. Spiral Thicker Web	Str. 3/8 1/2

## Metric Sizes (Straight Shank) .30mm to 5.40mm Dia.

SIZE mm	DEC. EQUIV.	FLUTE LENGTH mm	OVERALL LENGTH mm	HIGH SPEED STEEL	
				OXIDE FINISH 118°POINT	BRIGHT FINISH 118°POINT
				JDM	JDMP
.30	.0118	3	19	2.26	
.32	.0126	4	19	1.90	
.35	.0138	4	19	1.90	
.38	.0150	4	19	1.90	
.40	.0157	5	20	1.76	
.42	.0165	5	20	1.76	
.45	.0177	5	20	1.76	
.48	.0189	5	20	1.76	
.50	.0197	6	22	1.62	
.52	.0204	6	22	1.62	
.55	.0217	7	24	1.62	
.58	.0228	7	24	1.62	
.60	.0236	7	24	1.62	
.62	.0244	8	26	1.62	
.65	.0256	8	26	1.62	
.68	.0267	9	28	1.54	
.70	.0276	9	28	1.54	
.72	.0283	9	28	1.54	
.75	.0295	9	28	1.54	
.78	.0307	10	30	1.44	
.80	.0315	10	30	1.44	
.82	.0322	10	30	1.44	
.85	.0335	10	30	1.44	
.88	.0346	11	32	1.44	
.90	.0354	11	32	1.44	
.92	.0362	11	32	1.44	
.95	.0374	11	32	1.44	
.98	.0385	12	34	1.18	
1.00	.0394	12	34	1.18	1.28
1.05	.0413	12	34	1.18	
1.10	.0433	14	36	1.18	
1.15	.0452	14	36	1.18	
1.20	.0472	16	38	1.18	1.28
1.25	.0492	16	38	1.18	
1.30	.0512	16	38	1.18	
1.35	.0531	18	40	1.18	
1.40	.0551	18	40	1.18	
1.45	.0570	18	40	1.18	
1.50	.0591	18	40	1.18	1.28
1.55	.0610	20	43	1.18	
1.60	.0630	20	43	1.18	
1.65	.0650	20	43	1.18	
1.70	.0669	20	43	1.18	
1.75	.0689	22	46	1.18	
1.80	.0709	22	46	1.18	
1.85	.0728	22	46	1.18	
1.90	.0748	22	46	1.18	
1.95	.0767	24	49	1.18	
2.00	.0787	24	49	1.18	1.28
2.05	.0807	24	49	1.18	

SIZE mm	DEC. EQUIV.	FLUTE LENGTH mm	OVERALL LENGTH mm	HIGH SPEED STEEL	
				OXIDE FINISH 118°POINT	BRIGHT FINISH 118°POINT
				JDM	JDMP
2.10	.0827	24	49	1.18	
2.15	.0846	27	53	1.18	
2.20	.0866	27	53	1.18	1.28
2.25	.0886	27	53	1.18	
2.30	.0906	27	53	1.18	
2.35	.0925	27	53	1.18	
2.40	.0945	30	57	1.18	1.28
2.45	.0964	30	57	1.18	
2.50	.0984	30	57	1.18	1.28
2.55	.1003	30	57	1.18	
2.60	.1024	30	57	1.18	
2.65	.1043	30	57	1.18	
2.70	.1063	33	61	1.30	
2.75	.1083	33	61	1.30	
2.80	.1102	33	61	1.30	1.54
2.85	.1122	33	61	1.30	
2.90	.1142	33	61	1.30	
2.95	.1161	33	61	1.30	
3.00	.1181	33	61	1.30	1.54
3.10	.1220	36	65	1.30	
3.15	.1240	36	65	1.30	
3.20	.1260	36	65	1.30	1.54
3.25	.1280	36	65	1.30	1.54
3.30	.1299	36	65	1.44	1.54
3.40	.1339	39	70	1.44	
3.50	.1378	39	70	1.44	1.66
3.55	.1397	39	70	1.44	
3.60	.1417	39	70	1.44	
3.70	.1457	39	70	1.44	1.66
3.75	.1476	39	70	1.54	1.90
3.80	.1496	43	75	1.54	
3.90	.1536	43	75	1.54	
4.00	.1575	43	75	1.54	1.90
4.10	.1614	43	75	1.54	
4.20	.1654	43	75	1.54	1.90
4.25	.1673	43	75	1.72	1.90
4.30	.1693	47	80	1.72	
4.40	.1732	47	80	1.72	
4.50	.1772	47	80	1.72	1.90
4.60	.1811	47	80	1.72	
4.70	.1850	47	80	1.72	
4.75	.1870	47	80	2.02	1.90
4.80	.1890	52	86	2.02	2.20
4.90	.1929	52	86	2.02	
5.00	.1969	52	86	2.02	2.20
5.10	.2008	52	86	2.02	
5.20	.2047	52	86	2.02	2.20
5.25	.2067	52	86	2.02	
5.30	.2087	52	86	2.02	
5.40	.2126	57	93	2.68	

\* Metric Bright Polished drills (JDMP) below 3.00mm are not split point.

NOTE: Metric Jobber Length Drills are manufactured to metric ISO/DIN 338RN, BSS 328 specifications.