

# HIGH SPEED STEEL EXTRA LENGTH (LONG BOY) DRILLS

ICS USA

GENERAL PURPOSE

118° POINT



High Speed Steel Straight Shank Extra Length Long Boy Drills with a 118° point are designed for drilling very deep holes in ferrous or non-ferrous metals or drilling in difficult to reach locations. Straight shank extra length drills are preferred for drilling small to medium diameter deep holes as they do not require as much rotational power for drilling that a large deep hole would require. They are also known as Contractor's Long Boy Drills or simply as Long Boy Drills.

## Fractional Sizes (Straight Shank) 1/16" to 1-1/4" Dia.

		HIGH SPEED STEEL						
SIZE	DEC. EQUIV.	6" OVERALL LENGTH 4" FLUTE LENGTH	8" OVERALL LENGTH 5" FLUTE LENGTH	9" OVERALL LENGTH 6" FLUTE LENGTH	10" OVERALL LENGTH 7" FLUTE LENGTH	12" OVERALL LENGTH 9" FLUTE LENGTH	18" OVERALL LENGTH 14" FLUTE LENGTH	24" OVERALL LENGTH 18" FLUTE LENGTH
		OXIDE FINISH 118° POINT	OXIDE FINISH 118° POINT	OXIDE FINISH 118° POINT	OXIDE FINISH 118° POINT	OXIDE FINISH 118° POINT	OXIDE FINISH 118° POINT	OXIDE FINISH 118° POINT
		LBD06L	LBD08L	LBD09L	LBD10L	LBD12L	LBD18L	LBD24L
1/16	.0625	10.48	-	-	-	-	-	-
5/64	.0781	9.24	-	-	-	-	-	-
3/32	.0938	8.22	15.60	-	-	-	-	-
7/64	.1094	7.48	15.60	-	-	-	-	-
1/8	.1250	7.00	15.60	-	16.98	17.80	-	-
9/64	.1406	7.00	13.96	-	18.66	19.52	-	-
5/32	.1562	7.00	13.96	-	18.30	19.30	-	-
11/64	.1719	8.58	14.48	-	19.12	20.22	-	-
3/16	.1875	8.14	14.48	-	20.48	20.22	42.50	-
13/64	.2031	-	15.54	-	20.48	21.62	42.50	-
7/32	.2188	-	15.88	-	20.48	21.62	42.50	-
15/64	.2344	-	15.88	-	21.06	22.40	42.50	-
1/4	.2500	-	15.88	-	21.06	22.40	44.04	82.22
17/64	.2656	-	16.44	-	22.18	23.30	47.04	-
9/32	.2812	-	16.44	-	22.18	23.30	47.04	-
19/64	.2969	-	16.82	-	22.70	23.94	47.04	-
5/16	.3125	-	16.82	-	22.70	23.94	47.04	84.58
21/64	.3281	-	17.94	-	24.36	25.62	49.90	-
11/32	.3438	-	17.94	-	24.36	25.62	49.90	-
23/64	.3594	-	18.58	-	24.96	26.12	49.90	-
3/8	.3750	-	18.58	-	24.96	26.12	55.88	108.20
25/64	.3906	-	20.30	-	27.06	28.92	54.18	-
13/32	.4062	-	20.30	-	27.06	28.92	54.18	-
27/64	.4219	-	-	25.64	28.72	32.94	58.36	-
7/16	.4375	-	24.24	25.64	31.06	32.94	58.36	126.42
29/64	.4531	-	26.98	27.06	30.88	34.34	66.78	-
15/32	.4688	-	26.98	-	30.88	34.34	66.78	-
31/64	.4844	-	26.98	28.94	31.58	38.36	69.98	-
1/2	.5000	-	26.98	28.94	31.58	34.10	69.98	117.02
17/32	.5321	-	-	-	-	45.72	79.06	-
9/16	.5625	-	-	-	-	45.72	80.40	156.42
19/32	.5938	-	-	-	-	49.34	83.18	-
5/8	.6250	-	-	-	-	51.60	87.30	170.30
21/32	.6562	-	-	-	-	59.28	96.50	-
11/16	.6875	-	-	-	-	59.28	103.36	198.74
23/32	.7188	-	-	-	-	64.34	112.96	-
3/4	.7500	-	-	-	-	66.80	119.74	229.32
25/32	.7812	-	-	-	-	81.12	133.60	239.90
13/16	.8125	-	-	-	-	86.44	138.70	245.78
7/8	.8750	-	-	-	-	103.74	143.06	264.60
15/16	.9375	-	-	-	-	121.14	150.50	276.36
1	1.0000	-	-	-	-	124.66	159.54	294.00
1-1/8	1.1250	-	-	-	-	-	194.04	315.18
1-3/16	1.1875	-	-	-	-	-	234.68	351.62
1-1/4	1.2500	-	-	-	-	-	281.90	422.78