

# HIGH SPEED STEEL JOBBER LENGTH DRILLS

ICS WIS

GENERAL PURPOSE

118° POINT



## Letter Sizes (Straight Shank) "A" to "Z" Dia.

SIZE	DECIMAL EQUIVALENT	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL			TiN COAT	PACKAGE QUANTITY
				OXIDE FINISH		BRIGHT FINISH	GOLD FINISH	
				JDR	JDG	JDP	JDT	
A	.234	2-5/8	3-7/8	2.52	2.70	2.70	5.98	12
B	.238	2-3/4	4	2.52	2.70	2.70	5.98	12
C	.242	2-3/4	4	2.52	2.70	2.70	5.98	12
D	.246	2-3/4	4	2.52	2.70	2.70	5.98	12
E	.250	2-3/4	4	2.52	2.70	2.70	5.98	12
F	.257	2-7/8	4-1/8	3.14	3.32	3.32	9.26	12
G	.261	2-7/8	4-1/8	3.14	3.32	3.32	9.26	12
H	.266	2-7/8	4-1/8	3.14	3.32	3.32	9.26	12
I	.272	2-7/8	4-1/8	3.14	3.32	3.32	9.26	12
J	.277	2-7/8	4-1/8	3.62	3.84	3.84	9.74	12
K	.281	2-15/16	4-1/4	3.62	3.84	3.84	9.74	12
L	.290	2-15/16	4-1/4	4.04	4.28	4.28	10.18	12
M	.295	3-1/16	4-3/8	4.24	4.50	4.50	10.44	12
N	.302	3-1/16	4-3/8	4.24	4.50	4.50	10.44	6
O	.316	3-3/16	4-1/2	4.38	4.64	4.64	10.54	6
P	.323	3-5/16	4-5/8	4.90	5.22	5.22	11.12	6
Q	.332	3-7/16	4-3/4	4.90	5.22	5.22	11.12	6
R	.339	3-7/16	4-3/4	4.90	5.22	5.22	11.12	6
S	.348	3-1/2	4-7/8	5.30	5.64	5.64	17.40	6
T	.358	3-1/2	4-7/8	5.66	6.02	6.02	17.78	6
U	.368	3-5/8	5	6.14	7.20	7.20	18.30	6
V	.377	3-5/8	5	6.34	6.74	6.74	18.50	6
W	.386	3-3/4	5-1/8	6.78	7.20	7.20	18.96	6
X	.397	3-3/4	5-1/8	7.38	7.84	7.84	19.60	6
Y	.404	3-7/8	5-1/4	7.80	8.30	8.30	20.06	6
Z	.413	3-7/8	5-1/4	8.42	8.98	8.98	20.74	6

# HIGH SPEED STEEL 3/8" SHANK JOBBER LENGTH DRILLS

ICS WIS

GENERAL PURPOSE

118° POINT



## Letter Sizes (Straight Shank) "W" to "Z" Dia.

SIZE	DECIMAL EQUIVALENT	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL			PACKAGE QUANTITY
				OXIDE FINISH		GOLD FINISH	
				JDRTS	JDGTS	JDPTS	
W	.386	3-3/4	5-1/8	8.40	8.82	8.82	6
X	.397	3-3/4	5-1/8	9.00	9.48	9.48	6
Y	.404	3-7/8	5-1/4	9.42	9.92	9.92	6
Z	.413	3-7/8	5-1/4	10.06	10.58	10.58	6

## Quick Reference for General/Special Purpose Letter Size Drills

DRILL TYPE	DRILL SETS	STUB LENGTH	JOBBER LENGTH	REDUCED SHANK	TAPER LENGTH	TAPER SHANK	EXTRA LENGTH
PAGE NO. OF ITEMS AVAILABLE							
High Speed Steel	25	14	25, 49-58	25	79, 87	98	112
Cobalt	65	19	-	-	83	-	112
TiN Coated	65	-	25	-	-	-	-
Carbide Tipped	-	-	53	-	-	-	-
Solid Carbide	-	-	54	-	-	-	-