



# 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	FINISH	
				OXIDE FINISH	BRIGHT FINISH
				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	FINISH	
				OXIDE FINISH	BRIGHT FINISH
				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.