






HIGH SPEED STEEL JOBBER LENGTH DRILLS

ICS USA

HEAVY DUTY

135° SPLIT POINT

| ITEM NO. | ILLUSTRATION | CUTTING APPLICATION | STEEL SPECS | TECHNICAL DATA |
|--------------|---|---|-------------|--|
| JDHB |  OXIDE FINISH | For portable or machine drilling in hard steels, stainless steels and other hard materials. Mfr. to NAS 907-B specs. | M2, M7 | 135° Split Pt. Std. Spiral Hvy. Duty Web |
| JDHP |  BRIGHT POLISHED FINISH | This drill was specifically designed for welders who need to drill stainless steel and aluminum without the fear of oxide contaminating their weld. Saves on cleanup time and machining cost. | M2, M7 | 135° Split Pt. Std. Spiral Hvy. Duty Web |
| JDHGF |  GOLD FINISH | For portable or machine drilling in hard steels, stainless steels and other hard materials. Mfr. to NAS 907-B specs. Designed as an alternative to black oxide. Gold oxide film reduces friction between the tool and the work. Does not smear metal. | M2, M7 | 135° Split Pt. Std. Spiral Hvy. Duty Web |
| JDHDF |  BLACK/GOLD FINISH | This drill was designed for drilling work hardening 300 series stainless steels (except 303). Special thin web will penetrate work hardening stainless fast enough to cut beneath the chip which is hardening from deformation. | M2, M7 | 135° Split Pt. Std. Spiral Hvy. Duty Web |
| JDHT |  GOLD TITANIUM FINISH | This combination of titanium nitride coating with the heavy duty design enhances chip flow, finished hole quality and up to 700% more drill life. | M2, M7 | 135° Split Pt. Std. Spiral Hvy. Duty Web |

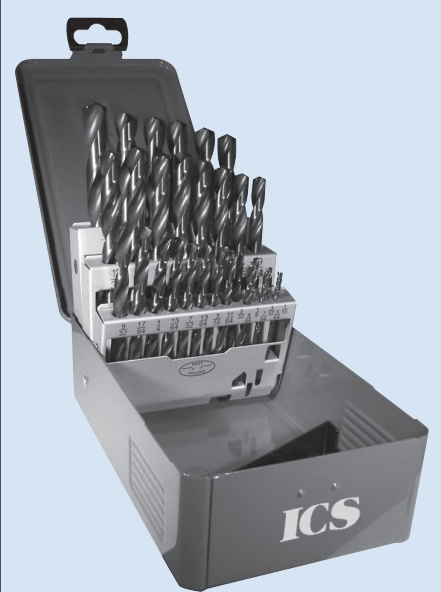
Fractional Sizes (Straight Shank) 1/64" to 1/2" Dia.

| SIZE | DEC. EQUIV. | FLUTE LENGTH | OVERALL LENGTH | HIGH SPEED STEEL | | | | TiN COAT |
|-------|-------------|--------------|----------------|------------------|---------------|--------------|--------------|-------------|
| | | | | OXIDE FINISH | BRIGHT FINISH | GOLD FINISH | BLACK/GOLD | GOLD COATED |
| | | | | 135° S/P | 135° S/P | 135° S/P | 135° S/P | 135° S/P |
| | | | | JDHB | JDHP | JDHGF | JDHDF | JDHT |
| *1/64 | .0156 | 3/16 | 3/4 | 1.90 | 1.90 | - | - | - |
| *1/32 | .0313 | 1/2 | 1-3/8 | 1.68 | 1.68 | - | - | - |
| *3/64 | .0469 | 3/4 | 1-3/4 | 1.44 | 1.44 | - | - | - |
| 1/16 | .0625 | 7/8 | 1-7/8 | 1.12 | 1.12 | 1.12 | 1.12 | 2.72 |
| 5/64 | .0781 | 1 | 2 | 1.12 | 1.12 | 1.12 | 1.12 | 2.72 |
| 3/32 | .0938 | 1-1/4 | 2-1/4 | 1.12 | 1.12 | 1.12 | 1.12 | 2.72 |
| 7/64 | .1094 | 1-1/2 | 2-5/8 | 1.12 | 1.12 | 1.12 | 1.12 | 2.72 |
| 1/8 | .1250 | 1-5/8 | 2-3/4 | 1.16 | 1.16 | 1.16 | 1.16 | 2.78 |
| 9/64 | .1406 | 1-3/4 | 2-7/8 | 1.28 | 1.28 | 1.28 | 1.26 | 2.88 |
| 5/32 | .1562 | 2 | 3-1/8 | 1.60 | 1.60 | 1.60 | 1.56 | 3.18 |
| 11/64 | .1719 | 2-1/8 | 3-1/4 | 1.82 | 1.82 | 1.82 | 1.68 | 3.40 |
| 3/16 | .1875 | 2-5/16 | 3-1/2 | 2.04 | 2.04 | 2.04 | 1.84 | 3.60 |
| 13/64 | .2031 | 2-7/16 | 3-5/8 | 2.36 | 2.36 | 2.36 | 2.12 | 5.54 |
| 7/32 | .2188 | 2-1/2 | 3-3/4 | 2.54 | 2.54 | 2.54 | 2.28 | 5.70 |
| 15/64 | .2344 | 2-5/8 | 3-7/8 | 2.70 | 2.70 | 2.70 | 2.42 | 5.88 |
| 1/4 | .2500 | 2-3/4 | 4 | 2.80 | 2.80 | 2.80 | 2.52 | 5.96 |
| 17/64 | .2656 | 2-7/8 | 4-1/8 | 3.62 | 3.62 | 3.62 | 3.26 | 10.32 |
| 9/32 | .2812 | 2-15/16 | 4-1/4 | 3.94 | 3.94 | 3.94 | 3.54 | 10.64 |
| 19/64 | .2969 | 3-1/16 | 4-3/8 | 4.40 | 4.40 | 4.40 | 3.96 | 11.02 |
| 5/16 | .3125 | 3-3/16 | 4-1/2 | 4.54 | 4.54 | 4.54 | 4.08 | 11.20 |
| 21/64 | .3281 | 3-5/16 | 4-5/8 | 5.00 | 5.00 | 5.00 | 4.50 | 11.64 |
| 11/32 | .3438 | 3-7/16 | 4-3/4 | 5.62 | 5.62 | 5.62 | 5.06 | 12.24 |
| 23/64 | .3594 | 3-1/2 | 4-7/8 | 6.28 | 6.28 | 6.28 | 5.64 | 14.32 |
| 3/8 | .3750 | 3-5/8 | 5 | 6.52 | 6.52 | 6.52 | 5.86 | 14.54 |
| 25/64 | .3906 | 3-3/4 | 5-1/8 | 7.18 | 7.18 | 7.18 | 6.46 | 17.92 |
| 13/32 | .4062 | 3-7/8 | 5-1/4 | 7.54 | 7.54 | 7.54 | 6.78 | 18.28 |
| 27/64 | .4219 | 3-15/16 | 5-3/8 | 8.02 | 8.02 | 8.02 | 7.22 | 18.74 |
| 7/16 | .4375 | 4-1/16 | 5-1/2 | 9.02 | 9.02 | 9.02 | 8.12 | 19.68 |
| 29/64 | .4531 | 4-3/16 | 5-5/8 | 9.92 | 9.92 | 9.92 | 8.92 | 20.56 |
| 15/32 | .4688 | 4-5/16 | 5-3/4 | 10.64 | 10.64 | 10.64 | 9.50 | 21.24 |
| 31/64 | .4844 | 4-3/8 | 5-7/8 | 10.82 | 10.82 | 10.82 | 9.74 | 21.42 |
| 1/2 | .5000 | 4-1/2 | 6 | 11.24 | 11.24 | 11.24 | 10.14 | 21.82 |

| PACKAGING |
|--|
| 1/64 to 17/64 - 12 Drills/Envelope 9/32 to 1/2 - 6 Drills/Envelope 33/64 to 3/4 - 1 Drill/Tube |

ORDERING NOTE
To complete your order we may substitute or interchange black or bright drills unless you have specified "no substitutions". Orders accepted in less than package quantity are subject to a 15% surcharge.

DRILL SETS
A variety of Jobber Length Drill Sets can be found on pages 60 to 67.



*Not Split Point

(Sizes continued on next page)