



SOLID CARBIDE JOBBER LENGTH DRILLS

ICS USA

SPECIAL PURPOSE

118° & 150° POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA
SCJD (2 Flute)	 BRIGHT POLISHED FINISH	For precision drilling of cast iron, non-ferrous metals, and non-metals. Needs rigid set-up for best results.	MICRO GRAIN CARBIDE 10% COBALT	Four Facet 118° Point Std. Spiral Std. Web
SCJD3F (3 Flute)	 BRIGHT POLISHED FINISH	For precision (reamer quality) drilling in cast iron, high silicon aluminum, alloy steels and non-ferrous materials. Three flute design removes more material per revolution, tracks straighter in hole, drill at very high feed rates, and does not need to be run on a super rigid set-up like other carbide drills. This self-centering drill is ideal for CNC Machine Center.	MICRO GRAIN CARBIDE 10% COBALT	Self-Centering 150° Point 30° Spiral Heavy Web

Fractional Sizes (Straight Shank) 1/32" to 3/4" Dia.

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	2 FLUTE		3 FLUTE	
				118° POINT	150° POINT	118° POINT	150° POINT
				SCJD	SCJD3F	SCJD	SCJD3F
1/32	.0313	5/16	1-1/4	16.74	-	-	-
3/64	.0469	3/4	1-1/2	16.74	-	-	-
1/16	.0625	3/4	1-1/2	14.24	-	-	-
5/64	.0781	7/8	1-3/4	14.96	-	-	-
3/32	.0938	1	1-3/4	16.46	-	-	-
7/64	.1094	1-1/4	2	18.70	25.28	-	-
1/8	.1250	1-1/4	2	20.00	27.52	-	-
9/64	.1406	1-3/8	2-1/2	22.14	32.14	-	-
5/32	.1562	1-3/8	2-1/2	24.70	34.02	-	-
11/64	.1719	1-5/8	2-3/4	29.28	36.46	-	-
3/16	.1875	1-5/8	2-3/4	30.12	40.32	-	-
13/64	.2031	1-3/4	3	34.68	48.76	-	-
7/32	.2188	1-3/4	3	38.52	50.12	-	-
15/64	.2344	2	3-1/4	43.62	53.74	-	-
1/4	.2500	2	3-1/4	45.94	54.58	-	-
17/64	.2656	2-1/8	3-1/2	51.82	60.14	-	-
9/32	.2812	2-1/8	3-1/2	54.16	67.34	-	-

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	2 FLUTE		3 FLUTE	
				118° POINT	150° POINT	118° POINT	150° POINT
				SCJD	SCJD3F	SCJD	SCJD3F
19/64	.2969	2-3/8	3-3/4	60.62	74.60	-	-
5/16	.3125	2-3/8	3-3/4	63.62	78.96	-	-
21/64	.3281	2-1/2	4	70.52	86.14	-	-
11/32	.3438	2-1/2	4	76.42	95.50	-	-
23/64	.3594	2-3/4	4-1/4	87.08	104.26	-	-
3/8	.3750	2-3/4	4-1/4	91.82	121.32	-	-
25/64	.3906	2-7/8	4-1/2	108.20	127.78	-	-
13/32	.4062	2-7/8	4-1/2	117.68	141.80	-	-
27/64	.4219	2-7/8	4-1/2	124.72	147.70	-	-
7/16	.4375	2-7/8	4-1/2	135.22	154.72	-	-
29/64	.4531	3	4-3/4	150.66	162.30	-	-
15/32	.4688	3	4-3/4	162.34	169.82	-	-
31/64	.4844	3	4-3/4	166.92	177.30	-	-
1/2	.5000	3	4-3/4	166.92	183.92	-	-
9/16	.5625	3	4-3/4	-	290.90	-	-
5/8	.6250	3-1/2	5-3/4	-	355.06	-	-
3/4	.7500	4-1/2	5-3/4	-	504.48	-	-

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

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	2 FLUTE		3 FLUTE	
				118° POINT	150° POINT	118° POINT	150° POINT
				SCJD	SCJD3F	SCJD	SCJD3F
A	.234	2	3-1/4	42.40	52.82	-	-
B	.238	2	3-1/4	44.20	54.04	-	-
C	.242	2	3-1/4	44.54	47.12	-	-
D	.246	2	3-1/4	45.18	54.44	-	-
E	.250	2	3-1/4	49.12	54.58	-	-
F	.257	2	3-1/4	52.08	57.30	-	-
G	.261	2-1/8	3-1/2	53.24	58.72	-	-
H	.266	2-1/8	3-1/2	53.24	61.32	-	-
I	.272	2-1/8	3-1/2	54.16	63.70	-	-
J	.277	2-1/8	3-1/2	55.66	65.52	-	-
K	.281	2-1/8	3-1/2	56.14	65.24	-	-
L	.290	2-1/8	3-1/2	59.28	70.26	-	-
M	.295	2-3/8	3-3/4	60.42	71.68	-	-

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	2 FLUTE		3 FLUTE	
				118° POINT	150° POINT	118° POINT	150° POINT
				SCJD	SCJD3F	SCJD	SCJD3F
N	.302	2-3/8	3-3/4	64.26	76.76	-	-
O	.316	2-3/8	3-3/4	67.76	81.84	-	-
P	.323	2-3/8	3-3/4	70.20	84.72	-	-
Q	.332	2-1/2	4	72.88	89.26	-	-
R	.339	2-1/2	4	76.12	93.94	-	-
S	.348	2-1/2	4	81.10	99.02	-	-
T	.358	2-3/4	4-1/4	83.88	102.50	-	-
U	.368	2-3/4	4-1/4	88.06	105.42	-	-
V	.377	2-3/4	4-1/4	97.52	113.64	-	-
W	.386	2-7/8	4-1/2	104.90	120.72	-	-
X	.397	2-7/8	4-1/2	114.62	133.40	-	-
Y	.404	2-7/8	4-1/2	118.50	139.00	-	-
Z	.413	2-7/8	4-1/2	128.30	144.18	-	-