


HIGH SPEED STEEL METRIC SCREW MACHINE LENGTH DRILLS

ICS

WIS


HEAVY DUTY

SPLIT POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA	NAS* SPECS
SMM	 OXIDE FINISH	For drilling in hard steel, stainless steel, titanium and other hard materials.	M2	135° Split Pt. Std. Spiral Hvy. Duty Web	C

Metric Sizes (Straight Shank) 1.00mm To 13.00mm Dia.

SIZE mm	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS		SIZE mm	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS	
				OXIDE FINISH 135° SPLIT PT	SMM					OXIDE FINISH 135° SPLIT PT	SMM
*1.00	.0394	1/4	1-1/32		\$1.98	7.50	.2953	1-5/16	2-29/32		\$5.66
1.50	.0591	11/32	1-1/4		1.98	8.00	.3150	1-7/16	3-1/8		5.66
2.00	.0781	15/32	1-1/2		1.98	8.50	.3346	1-7/16	3-1/8		6.28
2.50	.0984	9/16	1-11/16		1.98	9.00	.3543	1-9/16	3-5/16		7.12
3.00	.1181	5/8	1-13/16		1.98	9.50	.3740	1-9/16	3-5/16		8.88
3.50	.1378	25/32	2-1/16		1.96	10.00	.3937	1-11/16	3-1/2		8.88
4.00	.1575	7/8	2-5/32		2.16	10.50	.4137	1-11/16	3-1/2		9.64
4.50	.1772	15/16	2-9/32		2.64	11.00	.4331	1-27/32	3-3/4		9.86
5.00	.1969	1-1/32	2-7/16		2.64	11.50	.4528	1-27/32	3-3/4		11.66
5.50	.2165	1-1/8	2-19/32		3.40	12.00	.4724	2	4		12.80
6.00	.2362	1-1/8	2-19/32		3.78	12.50	.4921	2	4		12.80
6.50	.2560	1-7/32	2-3/4		4.22	13.00	.5118	2	4		12.80
7.00	.2756	1-5/16	2-29/32		4.76						



Metric Screw Machine Length Drill Sets on page 14.

*Not split point

HIGH SPEED STEEL DOUBLE END (STUB) DRILLS

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Double End Stub Drills are fluted and split pointed on both ends and have a solid center shank for chucking. They will drill twice as many holes as a Single End Drill for only a fraction more in cost. When one end gets dull or breaks, it can be quickly reversed in drill chuck to reduce change-over time, overall costs, and inventory.

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL			
				OXIDE FINISH 135° SPLIT PT	BRIGHT FINISH 135° SPLIT PT	GOLD FINISH 135° SPLIT PT	GOLD FINISH 135° SPLIT PT
				DED	DEDP	DEDF	DEDT
*1/16	.0625	9/16	2	\$1.90	\$1.90	\$ -	\$ -
*3/32	.0938	9/16	2	1.90	1.90	-	-
7/64	.1094	9/16	2	1.60	1.60	-	-
1/8	.1250	9/16	2	1.36	1.36	1.40	2.36
9/64	.1406	9/16	2	1.60	1.60	2.14	-
5/32	.1562	9/16	2-1/16	1.84	1.84	2.24	-
11/64	.1719	9/16	2-1/16	2.10	2.10	-	-
3/16	.1879	9/16	2-3/16	2.10	2.10	2.48	-
13/64	.2031	9/16	2-3/16	2.80	2.80	3.04	-
7/32	.2188	9/16	2-3/8	2.70	2.70	3.04	-
*15/64	.2344	9/16	2-3/8	3.26	3.26	-	-
1/4	.2500	9/16	2-1/2	3.06	3.06	3.36	-
*9/32	.2812	9/16	2-1/2	5.16	5.16	-	-
*5/16	.3125	9/16	2-13/16	6.04	8.20	-	-
*3/8	.3750	1-1/8	3-1/4	6.16	6.16	6.72	-
#11	.1910	9/16	2-1/4	3.50	3.50	-	7.46
#20	.1610	9/16	2-1/8	2.90	2.90	-	-
#30	.1285	9/16	2	1.36	1.36	1.40	2.36

NOW AVAILABLE

4 OPTIONS TO IMPROVE PERFORMANCE

Black Oxide Finish for hard steels and other tough materials.

Bright Polished Finish for stainless steels and aluminum.

Gold (Premium) Finish for hard steels, stainless steels and other tough metals.

TiN Coated for long tool life and harder materials. Run at higher speeds for maximum productivity, often used in air drills.

*Available while stock remains.