

**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 COATED	PACKAGE QUANTITY
				OXIDE FINISH 118° POINT	OXIDE FINISH 118° POINT	BRIGHT FINISH 118° POINT	GOLD FINISH 118° POINT	
				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 118° POINT	OXIDE FINISH 118° POINT	BRIGHT FINISH 118° POINT	
				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	65	14	25, 49-58	25	79, 87	98	112
Cobalt	65	19	-	-	83	-	112
TiN Coated	65	-	25	-	-	-	-
Carbide Tipped	-	-	53	-	-	-	-
Solid Carbide	-	-	54	-	-	-	-