






# HIGH SPEED STEEL JOBBER LENGTH DRILLS

ICS USA

HEAVY DUTY

SPLIT POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA
<b>JDHB</b>	 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
<b>JDHP</b>	 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
<b>JDHGF</b>	 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
<b>JDHDF</b>	 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 Special Web
<b>JDHT</b>	 GOLD TITANIUM COATED	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 COATED
				OXIDE FINISH 135° S/P	BRIGHT FINISH 135° S/P	GOLD FINISH 135° S/P	BLACK/GOLD FINISH 135° S/P	GOLD COATED 135° S/P
				JDHB	JDHP	JDHGF	JDHDF	JDHT
*1/64	.0156	3/16	3/4	\$1.80	\$1.80	\$ -	\$ -	\$ -
*1/32	.0313	1/2	1-3/8	1.60	1.60	-	-	-
*3/64	.0469	3/4	1-3/4	1.36	1.36	-	-	-
1/16	.0625	7/8	1-7/8	1.00	1.00	1.00	1.06	2.58
5/64	.0781	1	2	1.00	1.00	1.00	1.06	2.58
3/32	.0938	1-1/4	2-1/4	1.00	1.00	1.00	1.06	2.58
7/64	.1094	1-1/2	2-5/8	1.00	1.00	1.00	1.06	2.58
1/8	.1250	1-5/8	2-3/4	1.04	1.04	1.04	1.10	2.64
9/64	.1406	1-3/4	2-7/8	1.12	1.12	1.12	1.20	2.72
5/32	.1562	2	3-1/8	1.40	1.40	1.40	1.48	2.98
11/64	.1719	2-1/8	3-1/4	1.52	1.52	1.52	1.60	3.10
3/16	.1875	2-5/16	3-1/2	1.64	1.64	1.64	1.74	3.24
13/64	.2031	2-7/16	3-5/8	1.92	1.92	1.92	2.02	5.04
7/32	.2188	2-1/2	3-3/4	2.04	2.04	2.04	2.16	5.18
15/64	.2344	2-5/8	3-7/8	2.18	2.18	2.18	2.30	5.32
1/4	.2500	2-3/4	4	2.28	2.28	2.28	2.40	5.40
17/64	.2656	2-7/8	4-1/8	2.94	2.94	2.94	3.10	9.48
9/32	.2812	2-15/16	4-1/4	3.20	3.20	3.20	3.36	9.74
19/64	.2969	3-1/16	4-3/8	3.54	3.54	3.54	3.76	10.08
5/16	.3125	3-3/16	4-1/2	3.68	3.68	3.68	3.88	10.22
21/64	.3281	3-5/16	4-5/8	4.06	4.06	4.06	4.28	10.60
11/32	.3438	3-7/16	4-3/4	4.58	4.58	4.58	4.82	11.12
23/64	.3594	3-1/2	4-7/8	5.10	5.10	5.10	5.36	13.02
3/8	.3750	3-5/8	5	5.30	5.30	5.30	5.58	13.22
25/64	.3906	3-3/4	5-1/8	5.84	5.84	5.84	6.14	16.38
13/32	.4062	3-7/8	5-1/4	6.12	6.12	6.12	6.46	16.68
27/64	.4219	3-15/16	5-3/8	6.52	6.52	6.52	6.88	17.08
7/16	.4375	4-1/16	5-1/2	7.34	7.34	7.34	7.72	17.88
29/64	.4531	4-3/16	5-5/8	8.08	8.08	8.08	8.50	18.62
15/32	.4688	4-5/16	5-3/4	8.58	8.58	8.58	9.04	19.14
31/64	.4844	4-3/8	5-7/8	8.82	8.82	8.82	9.28	19.36
1/2	.5000	4-1/2	6	9.18	9.18	9.18	9.66	19.72

\*Not split point

(Sizes continued on next page)

### 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.

