




# HIGH SPEED STEEL JOBBER LENGTH DRILLS - 3 FLATS ON SHANK

ICS WIS

HEAVY DUTY

135° SPLIT POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL TECHNICAL		
			SPECS	DATA	SHANK
<b>JDHB3F</b>	 OXIDE FINISH	For portable or machine drilling in hard steels, stainless steels and other hard materials. Mfr. to NAS 907-B specs. Flats are ground on three sides of drill shank for positive holding in 3 Jaw Chucks.	M2 M7	135° Split Pt. Std. Spiral Hvy. Duty Web	Straight 3 Flats
<b>JDHDF3F</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. Flats are ground on three sides of drill shank for positive holding in 3 Jaw Chucks.	M2 M7	135° Split Pt. Std. Spiral Hvy. Duty Web	Straight 3 Flats
<b>JDC3F</b>	 GOLD COBALT FINISH	For portable or machine drilling in stainless steel, titanium, and other work hardening metals. Mfr. to NAS 907-J specs. Flats are ground on three sides of drill shank for positive holding in 3 Jaw Chucks.	M2 M7	135° Split Pt. Std. Spiral Hvy. Duty Web	Straight 3 Flats

## Fractional Sizes (Straight Shank - no Flats) 1/16" to 11/64" Dia.

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS		COBALT
				OXIDE FINISH	BLACK/GOLD	COBALT
				135° S/P	135° S/P	135° S/P
				<b>JDHB</b>	<b>JDHDF</b>	<b>JDC</b>
1/16	.0625	7/8	1-7/8	1.06	1.06	1.72
5/64	.0781	1	2	1.06	1.06	1.72
3/32	.0938	1-1/4	2-1/4	1.06	1.06	1.72
7/64	.1094	1-1/2	2-5/8	1.06	1.06	1.92

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS		COBALT
				OXIDE FINISH	BLACK/GOLD	COBALT
				135° S/P	135° S/P	135° S/P
				<b>JDHB</b>	<b>JDHDF</b>	<b>JDC</b>
1/8	.1250	1-5/8	2-3/4	1.10	1.10	2.28
9/64	.1406	1-3/4	2-7/8	1.18	1.18	2.32
5/32	.1562	2	3-1/8	1.48	1.48	2.58
11/64	.1719	2-1/8	3-1/4	1.60	1.60	2.82

## Fractional Sizes (Straight Shank - 3 Flats) 3/16" to 1/2" Dia.

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS		COBALT
				OXIDE FINISH	BLACK/GOLD	COBALT
				135° S/P	135° S/P	135° S/P
				<b>JDHB3F</b>	<b>JDHDF3F</b>	<b>JDC3F</b>
3/16	.1875	2-5/16	3-1/2	2.04	2.14	3.40
13/64	.2031	2-7/16	3-5/8	2.36	2.44	4.00
7/32	.2188	2-1/2	3-3/4	2.46	2.58	4.50
15/64	.2344	2-5/8	3-7/8	2.60	2.74	4.98
1/4	.2500	2-3/4	4	2.72	2.84	5.12
17/64	.2656	2-7/8	4-1/8	3.40	3.58	5.84
9/32	.2812	2-15/16	4-1/4	3.68	3.84	6.44
19/64	.2969	3-1/16	4-3/8	4.04	4.26	7.10
5/16	.3125	3-3/16	4-1/2	4.18	4.40	7.48
21/64	.3281	3-5/16	4-5/8	4.58	4.82	8.32
11/32	.3438	3-7/16	4-3/4	5.12	5.38	9.18

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS		COBALT
				OXIDE FINISH	BLACK/GOLD	COBALT
				135° S/P	135° S/P	135° S/P
				<b>JDHB3F</b>	<b>JDHDF3F</b>	<b>JDC3F</b>
23/64	.3594	3-1/2	4-7/8	5.68	5.94	10.28
3/8	.3750	3-5/8	5	5.88	6.18	10.44
25/64	.3906	3-3/4	5-1/8	6.46	6.76	11.84
13/32	.4062	3-7/8	5-1/4	6.74	7.10	12.40
27/64	.4219	3-15/16	5-3/8	7.16	7.54	13.62
7/16	.4375	4-1/16	5-1/2	8.02	8.42	13.92
29/64	.4531	4-3/16	5-5/8	8.80	9.24	16.64
15/32	.4688	4-5/16	5-3/4	9.32	9.82	16.92
31/64	.4844	4-3/8	5-7/8	9.58	10.06	18.38
1/2	.5000	4-1/2	6	9.96	10.46	17.70

NOTE: 29 pc. sets (1/16 - 1/2 by 64ths) can be ordered with 3 flats although sizes 1/16 - 11/64 will not have flats

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## Fractional Sizes (3/8" Shank - 3 Flats) 25/64" to 1/2" Dia.

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS		COBALT
				OXIDE FINISH	BLACK/GOLD	COBALT
				135° S/P	135° S/P	135° S/P
				<b>JDHB3FTS</b>	<b>JDHDF3FTS</b>	<b>JDC3FTS</b>
25/64	.3906	3-3/4	5-1/8	8.80	8.90	14.94
13/32	.4062	3-7/8	5-1/4	9.10	9.20	15.52
27/64	.4219	3-15/16	5-3/8	9.52	9.62	16.82
7/16	.4375	4-1/16	5-1/2	10.38	10.48	17.14

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS		COBALT
				OXIDE FINISH	BLACK/GOLD	COBALT
				135° S/P	135° S/P	135° S/P
				<b>JDHB3FTS</b>	<b>JDHDF3FTS</b>	<b>JDC3FTS</b>
29/64	.4531	4-3/16	5-5/8	11.16	11.26	20.02
15/32	.4688	4-5/16	5-3/4	11.68	11.78	20.32
31/64	.4844	4-3/8	5-7/8	11.94	12.04	21.86
1/2	.5000	4-1/2	6	12.32	12.42	21.18