



SOLID CARBIDE JOBBER LENGTH DRILLS

ICS **USA**

SPECIAL PURPOSE

118° POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA
SCJD (2 Flute)	 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)	 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 straighten 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	SOLID CARBIDE	
				BRIGHT FINISH 118° PT	BRIGHT FINISH 150° PT
				SCJD	SCJD3F
1/32	.0313	5/16	1-1/4	\$15.94	\$ -
3/64	.0469	3/4	1-1/2	15.94	-
1/16	.0625	3/4	1-1/2	13.56	-
5/64	.0781	7/8	1-3/4	14.24	-
3/32	.0938	1	1-3/4	15.68	-
7/64	.1094	1-1/4	2	17.80	24.08
1/8	.1250	1-1/4	2	19.04	26.20
9/64	.1406	1-3/8	2-1/2	21.08	30.60
5/32	.1562	1-3/8	2-1/2	23.52	32.40
11/64	.1719	1-5/8	2-3/4	27.88	34.72
3/16	.1875	1-5/8	2-3/4	28.68	38.40
13/64	.2031	1-3/4	3	33.02	46.44
7/32	.2188	1-3/4	3	36.68	47.72
15/64	.2344	2	3-1/4	41.54	51.18
1/4	.2500	2	3-1/4	43.74	51.98
17/64	.2656	2-1/8	3-1/2	49.34	57.28
9/32	.2812	2-1/8	3-1/2	51.58	64.12

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	SOLID CARBIDE	
				BRIGHT FINISH 118° PT	BRIGHT FINISH 150° PT
				SCJD	SCJD3F
19/64	.2969	2-3/8	3-3/4	\$57.72	\$71.04
5/16	.3125	2-3/8	3-3/4	60.58	75.20
21/64	.3281	2-1/2	4	67.16	82.04
11/32	.3438	2-1/2	4	72.78	90.94
23/64	.3594	2-3/4	4-1/4	82.92	99.30
3/8	.3750	2-3/4	4-1/4	87.44	115.53
25/64	.3906	2-7/8	4-1/2	103.04	121.70
13/32	.4062	2-7/8	4-1/2	112.08	135.04
27/64	.4219	2-7/8	4-1/2	118.78	140.66
7/16	.4375	2-7/8	4-1/2	128.78	147.34
29/64	.4531	3	4-3/4	143.48	154.56
15/32	.4688	3	4-3/4	154.60	161.72
31/64	.4844	3	4-3/4	158.96	168.86
1/2	.5000	3	4-3/4	158.96	175.16
9/16	.5625	3	4-3/4	-	277.04
5/8	.6250	3-1/2	5-3/4	-	338.14
3/4	.7500	4-1/2	5-3/4	-	480.46

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

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	SOLID CARBIDE	
				BRIGHT FINISH 118° PT	BRIGHT FINISH 150° PT
				SCJD	SCJD3F
A	.234	2	3-1/4	\$40.38	\$50.30
B	.238	2	3-1/4	42.10	51.46
C	.242	2	3-1/4	42.42	44.88
D	.246	2	3-1/4	43.02	51.84
E	.250	2	3-1/4	46.78	51.98
F	.257	2	3-1/4	49.60	54.56
G	.261	2-1/8	3-1/2	50.70	55.92
H	.266	2-1/8	3-1/2	50.70	58.40
I	.272	2-1/8	3-1/2	51.58	60.66
J	.277	2-1/8	3-1/2	53.00	62.40
K	.281	2-1/8	3-1/2	53.46	62.12
L	.290	2-1/8	3-1/2	56.46	66.90
M	.295	2-3/8	3-3/4	57.54	68.26

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	SOLID CARBIDE	
				BRIGHT FINISH 118° PT	BRIGHT FINISH 150° PT
				SCJD	SCJD3F
N	.302	2-3/8	3-3/4	\$61.20	\$73.10
O	.316	2-3/8	3-3/4	64.52	77.94
P	.323	2-3/8	3-3/4	66.86	80.68
Q	.332	2-1/2	4	69.40	85.00
R	.339	2-1/2	4	72.50	89.46
S	.348	2-1/2	4	77.24	94.30
T	.358	2-3/4	4-1/4	79.88	97.62
U	.368	2-3/4	4-1/4	83.86	100.40
V	.377	2-3/4	4-1/4	92.88	108.22
W	.386	2-7/8	4-1/2	99.90	114.96
X	.397	2-7/8	4-1/2	109.16	127.04
Y	.404	2-7/8	4-1/2	112.86	132.38
Z	.413	2-7/8	4-1/2	122.18	137.30