






# HIGH SPEED STEEL JOBBER LENGTH DRILLS

ICS USA

GENERAL PURPOSE

118° POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA	SHANK
<b>JDR</b>	 OXIDE FINISH	For general purpose and production machine drilling in ferrous or non-ferrous metals. Thicker web construction for extended drill life. Relief ground and twist fluted for maximum strength and rigidity.	M2	118° Point Std. Spiral Thicker Web	Str. 1/4 3/8
<b>JDG</b>	 OXIDE FINISH	For portable or machine drilling in ferrous or non-ferrous metals. Ground oxide finish flutes retain lubricants and ease chip welding when drilling cast iron, steel, etc.	M1, M2 M7, M50	118° Point Std. Spiral Std. Web	Str. 1/4 3/8 1/2
<b>JDP</b>	 BRIGHT POLISHED FINISH	For portable or machine drilling in ferrous or non-ferrous metals. Polished ground flutes reduce loading when drilling soft materials like aluminum, brass, etc.	M1, M2 M7, M50	118° Point Std. Spiral Std. Web	Str. 1/4 3/8 1/2
<b>JDT</b>	 GOLD TITANIUM COATED	For high production drilling of ferrous and non-ferrous metals. TiN coating extends life of drill up to 700%.	M1, M2 M7, M50	118° Point Std. Spiral Std. Web	Str. 1/4 3/8 1/2
<b>JDZ</b>	 SILVER-GOLD ZIRCONIUM FINISH	For machining cast iron, brass, and aluminum die castings. Out performs TiN in many applications. Zirconium is harder than TiN and remains stable at higher cutting temperatures.	M1, M2 M7, M50	118° Point Std. Spiral Std. Web	Str.

## Fractional Sizes (Straight Shank) 1/64" to 1/2" Dia.

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL			TiN COAT	ZrN COAT
				OXIDE FINISH	OXIDE FINISH	BRIGHT FINISH	GOLD FINISH	SILVER/GOLD
				JDR	JDG	JDP	JDT	JDZ
1/64	.0156	3/16	3/4	1.56	1.64	1.64	-	-
1/32	.0313	1/2	1-3/8	1.12	1.18	1.18	-	-
3/64	.0469	3/4	1-3/4	1.08	1.14	1.14	2.82	3.50
1/16	.0625	7/8	1-7/8	0.78	0.82	0.82	2.48	3.18
5/64	.0781	1	2	0.78	0.82	0.82	2.48	3.18
3/32	.0938	1-1/4	2-1/4	0.82	0.84	0.84	2.50	3.20
7/64	.1094	1-1/2	2-5/8	0.88	0.90	0.90	2.58	3.26
1/8	.1250	1-5/8	2-3/4	0.90	1.04	1.04	2.62	3.30
9/64	.1406	1-3/4	2-7/8	0.98	1.04	1.04	2.70	3.38
5/32	.1562	2	3-1/8	1.04	1.08	1.08	2.74	3.42
11/64	.1719	2-1/8	3-1/4	1.14	1.22	1.22	2.88	3.58
3/16	.1875	2-5/16	3-1/2	1.30	1.36	1.36	3.04	3.72
13/64	.2031	2-7/16	3-5/8	1.46	1.52	1.52	4.82	6.14
7/32	.2188	2-1/2	3-3/4	1.62	1.70	1.70	5.00	6.32
15/64	.2344	2-5/8	3-7/8	1.70	1.82	1.82	5.08	6.40
1/4	.2500	2-3/4	4	1.84	1.92	1.92	5.22	6.54
17/64	.2656	2-7/8	4-1/8	2.44	2.58	2.58	9.46	12.18
9/32	.2812	2-15/16	4-1/4	2.60	2.74	2.74	9.60	12.34
19/64	.2969	3-1/16	4-3/8	2.90	3.08	3.08	9.94	12.66
5/16	.3125	3-3/16	4-1/2	3.18	3.32	3.32	10.18	12.92
21/64	.3281	3-5/16	4-5/8	3.20	3.36	3.36	10.24	12.94
11/32	.3438	3-7/16	4-3/4	3.92	4.12	4.12	11.00	13.72
23/64	.3594	3-1/2	4-7/8	4.38	4.60	4.60	12.92	16.26
3/8	.3750	3-5/8	5	4.54	4.78	4.78	13.08	16.42
25/64	.3906	3-3/4	5-1/8	4.80	5.04	5.04	16.14	20.52
13/32	.4062	3-7/8	5-1/4	4.98	5.24	5.24	16.32	20.72
27/64	.4219	3-15/16	5-3/8	5.72	6.02	6.02	17.10	21.48
7/16	.4375	4-1/16	5-1/2	5.78	6.08	6.08	17.16	21.56
29/64	.4531	4-3/16	5-5/8	6.52	6.86	6.86	17.94	22.32
15/32	.4688	4-5/16	5-3/4	6.86	7.20	7.20	18.30	22.68
31/64	.4844	4-3/8	5-7/8	7.30	7.64	7.64	18.74	23.12
1/2	.5000	4-1/2	6	7.36	7.74	7.74	18.80	23.20

### 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.

