




JOBBER LENGTH DRILLS - 3 FLATS ON SHANK

HIGH SPEED STEEL

ICS WIS

HEAVY DUTY

135° SPLIT POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL TECHNICAL		
			SPECS	DATA	SHANK
JDHB3F	 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
JDHDF3F	 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
JDC3F	 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
1/16	.0625	7/8	1-7/8	JDHB	JDHDF	JDC
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
1/8	.1250	1-5/8	2-3/4	JDHB	JDHDF	JDC
9/64	.1406	1-3/4	2-7/8	1.10	1.10	2.28
5/32	.1562	2	3-1/8	1.18	1.18	2.32
11/64	.1719	2-1/8	3-1/4	1.48	1.48	2.58
				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
3/16	.1875	2-5/16	3-1/2	JDHB3F	JDHDF3F	JDC3F
13/64	.2031	2-7/16	3-5/8	2.04	2.14	3.40
7/32	.2188	2-1/2	3-3/4	2.36	2.44	4.00
15/64	.2344	2-5/8	3-7/8	2.46	2.58	4.50
1/4	.2500	2-3/4	4	2.60	2.74	4.98
17/64	.2656	2-7/8	4-1/8	2.72	2.84	5.12
9/32	.2812	2-15/16	4-1/4	3.40	3.58	5.84
19/64	.2969	3-1/16	4-3/8	3.68	3.84	6.44
5/16	.3125	3-3/16	4-1/2	4.04	4.26	7.10
21/64	.3281	3-5/16	4-5/8	4.18	4.40	7.48
11/32	.3438	3-7/16	4-3/4	4.58	4.82	8.32
				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
23/64	.3594	3-1/2	4-7/8	JDHB3F	JDHDF3F	JDC3F
3/8	.3750	3-5/8	5	5.68	5.94	10.28
25/64	.3906	3-3/4	5-1/8	5.88	6.18	10.44
13/32	.4062	3-7/8	5-1/4	6.46	6.76	11.84
27/64	.4219	3-15/16	5-3/8	6.74	7.10	12.40
7/16	.4375	4-1/16	5-1/2	7.16	7.54	13.62
29/64	.4531	4-3/16	5-5/8	8.02	8.42	13.92
15/32	.4688	4-5/16	5-3/4	8.80	9.24	16.64
31/64	.4844	4-3/8	5-7/8	9.32	9.82	16.92
1/2	.5000	4-1/2	6	9.58	10.06	18.38
				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
25/64	.3906	3-3/4	5-1/8	JDHB3FTS	JDHDF3FTS	JDC3FTS
13/32	.4062	3-7/8	5-1/4	8.80	8.90	14.94
27/64	.4219	3-15/16	5-3/8	9.10	9.20	15.52
7/16	.4375	4-1/16	5-1/2	9.52	9.62	16.82
				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
29/64	.4531	4-3/16	5-5/8	JDHB3FTS	JDHDF3FTS	JDC3FTS
15/32	.4688	4-5/16	5-3/4	11.16	11.26	20.02
31/64	.4844	4-3/8	5-7/8	11.68	11.78	20.32
1/2	.5000	4-1/2	6	11.94	12.04	21.86
				12.32	12.42	21.18