



# HIGH SPEED STEEL FAST/SLOW SPIRAL JOBBER LENGTH DRILLS

**ICS USA**

**SPECIAL PURPOSE**

**118° POINT**

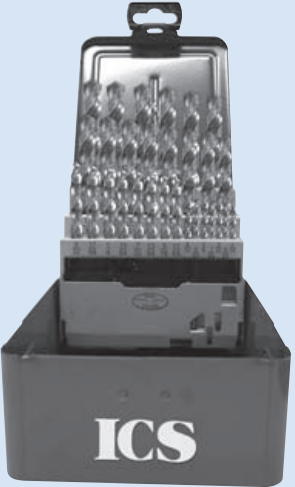
ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA
<b>JDF</b>	 BRIGHT POLISHED FINISH	For portable or machine drilling low tensile strength materials such as aluminum, magnesium, copper, zinc, and similar materials producing long stringy swarf. Excellent chip-clearing when drilling deep holes.	M2	118° Point Fast Spiral Std. Web
<b>JDS</b>	 BRIGHT POLISHED FINISH	For portable or machine drilling in brass, copper, and similar alloys. Also for soft copper and aluminum sheet where breakout "snatch" or burr is a problem. Polished ground flutes ease chip ejection.	M2	118° Point Slow Spiral Std. Web

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

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL	
				BRIGHT FINISH 118° POINT	
				JDF	JDS
1/16	.0625	7/8	1-7/8	2.12	2.46
5/64	.0781	1	2	2.16	2.46
3/32	.0938	1-1/4	2-1/4	2.16	2.42
7/64	.1094	1-1/2	2-5/8	2.12	2.46
1/8	.1250	1-5/8	2-3/4	2.12	2.42
9/64	.1406	1-3/4	2-7/8	2.12	2.46
5/32	.1562	2	3-1/8	2.32	2.96
11/64	.1719	2-1/8	3-1/4	2.80	3.44
3/16	.1875	2-5/16	3-1/2	3.10	3.42
13/64	.2031	2-7/16	3-5/8	3.56	4.10
7/32	.2188	2-1/2	3-3/4	3.86	4.64
15/64	.2344	2-5/8	3-7/8	4.40	5.24
1/4	.2500	2-3/4	4	4.18	4.90
17/64	.2656	2-7/8	4-1/8	5.66	6.34
9/32	.2812	2-15/16	4-1/4	5.64	6.60

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL	
				BRIGHT FINISH 118° POINT	
				JDF	JDS
19/64	.2969	3-1/16	4-3/8	6.52	7.82
5/16	.3125	3-3/16	4-1/2	6.70	8.12
21/64	.3281	3-5/16	4-5/8	7.78	8.86
11/32	.3438	3-7/16	4-3/4	8.26	9.82
23/64	.3594	3-1/2	4-7/8	10.26	13.24
3/8	.3750	3-5/8	5	9.94	11.70
25/64	.3906	3-3/4	5-1/8	11.92	14.66
13/32	.4062	3-7/8	5-1/4	11.62	13.48
27/64	.4219	3-15/16	5-3/8	13.86	17.20
7/16	.4375	4-1/16	5-1/2	13.64	15.62
29/64	.4531	4-3/16	5-5/8	14.94	20.12
15/32	.4688	4-5/16	5-3/4	15.36	19.18
31/64	.4844	4-3/8	5-7/8	16.82	22.64
1/2	.5000	4-1/2	6	16.26	20.02

## HIGH SPEED STEEL FAST/SLOW SPIRAL JOBBER LENGTH DRILL SETS

DESCRIPTION	TYPE OF DRILL	ITEM NO.	PRICE
 29 PC DRILL SETS  Sizes 1/16 to 1/2 by 64ths METAL INDEX	Fast Spiral Jobber Drill - 118° Pt	<b>DS-JDF-29</b>	182.20
	Slow Spiral Jobber Drill - 118° Pt	<b>DS-JDS-29</b>	210.66