

HIGH SPEED STEEL FAST/SLOW SPIRAL JOBBER LENGTH DRILLS

ICS USA

SPECIAL PURPOSE

118° POINT



Wire Gauge Sizes (Straight Shank) #1 to #80 Dia.

| SIZE | DEC. EQUIV. | FLUTE LENGTH | OVERALL LENGTH | HIGH SPEED STEEL | |
|------|-------------|--------------|----------------|--------------------------|------|
| | | | | BRIGHT FINISH 118° POINT | |
| | | | | JDF | JDS |
| 1 | .2280 | 2-5/8 | 3-7/8 | 4.34 | 5.72 |
| 2 | .2210 | 2-5/8 | 3-7/8 | 4.46 | 5.72 |
| 3 | .2130 | 2-1/2 | 3-3/4 | 4.18 | 5.50 |
| 4 | .2090 | 2-1/2 | 3-3/4 | 4.18 | 5.50 |
| 5 | .2055 | 2-1/2 | 3-3/4 | 4.18 | 5.50 |
| 6 | .2040 | 2-1/2 | 3-3/4 | 4.18 | 5.50 |
| 7 | .2010 | 2-7/16 | 3-5/8 | 3.40 | 4.70 |
| 8 | .1990 | 2-7/16 | 3-5/8 | 3.52 | 4.70 |
| 9 | .1960 | 2-7/16 | 3-5/8 | 3.42 | 4.70 |
| 10 | .1935 | 2-7/16 | 3-5/8 | 3.42 | 4.70 |
| 11 | .1910 | 2-5/16 | 3-1/2 | 3.24 | 4.40 |
| 12 | .1890 | 2-5/16 | 3-1/2 | 3.44 | 4.40 |
| 13 | .1850 | 2-5/16 | 3-1/2 | 3.24 | 4.10 |
| 14 | .1820 | 2-3/16 | 3-3/8 | 3.24 | 4.10 |
| 15 | .1800 | 2-3/16 | 3-3/8 | 3.14 | 4.10 |
| 16 | .1770 | 2-3/16 | 3-3/8 | 3.14 | 4.10 |
| 17 | .1730 | 2-3/16 | 3-3/8 | 3.22 | 4.10 |
| 18 | .1695 | 2-1/8 | 3-1/4 | 2.78 | 3.64 |
| 19 | .1660 | 2-1/8 | 3-1/4 | 2.72 | 3.64 |
| 20 | .1610 | 2-1/8 | 3-1/4 | 2.72 | 3.64 |
| 21 | .1590 | 2-1/8 | 3-1/4 | 2.50 | 3.54 |
| 22 | .1570 | 2 | 3-1/8 | 2.56 | 3.54 |
| 23 | .1540 | 2 | 3-1/8 | 2.40 | 3.54 |
| 24 | .1520 | 2 | 3-1/8 | 2.28 | 3.40 |
| 25 | .1495 | 1-7/8 | 3 | 2.28 | 3.40 |
| 26 | .1470 | 1-7/8 | 3 | 2.28 | 3.12 |
| 27 | .1440 | 1-7/8 | 3 | 2.28 | 3.12 |
| 28 | .1405 | 1-3/4 | 2-7/8 | 2.20 | 3.12 |
| 29 | .1360 | 1-3/4 | 2-7/8 | 2.10 | 2.72 |
| 30 | .1285 | 1-5/8 | 2-3/4 | 2.10 | 2.72 |
| 31 | .1200 | 1-5/8 | 2-3/4 | 2.16 | 2.72 |
| 32 | .1160 | 1-5/8 | 2-3/4 | 2.16 | 2.72 |
| 33 | .1130 | 1-1/2 | 2-5/8 | 2.24 | 2.72 |
| 34 | .1110 | 1-1/2 | 2-5/8 | 2.24 | 2.72 |
| 35 | .1100 | 1-1/2 | 2-5/8 | 2.16 | 2.72 |
| 36 | .1065 | 1-7/16 | 2-1/2 | 2.24 | 2.72 |
| 37 | .1040 | 1-7/16 | 2-1/2 | 2.16 | 2.72 |
| 38 | .1015 | 1-7/16 | 2-1/2 | 2.16 | 2.72 |
| 39 | .0995 | 1-3/8 | 2-3/8 | 2.16 | 2.72 |
| 40 | .0980 | 1-3/8 | 2-3/8 | 2.10 | 2.72 |

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|------|-------------|--------------|----------------|--------------------------|------|
| | | | | BRIGHT FINISH 118° POINT | |
| | | | | JDF | JDS |
| 41 | .0960 | 1-3/8 | 2-3/8 | 2.26 | 2.76 |
| 42 | .0935 | 1-1/4 | 2-1/4 | 2.26 | 2.76 |
| 43 | .0890 | 1-1/4 | 2-1/4 | 2.14 | 2.76 |
| 44 | .0860 | 1-1/8 | 2-1/8 | 2.20 | 2.76 |
| 45 | .0820 | 1-1/8 | 2-1/8 | 2.20 | 2.76 |
| 46 | .0810 | 1-1/8 | 2-1/8 | 2.20 | 2.76 |
| 47 | .0785 | 1 | 2 | 2.26 | 2.76 |
| 48 | .0760 | 1 | 2 | 2.18 | 2.76 |
| 49 | .0730 | 1 | 2 | 2.26 | 2.76 |
| 50 | .0700 | 1 | 2 | 2.18 | 2.76 |
| 51 | .0670 | 1 | 2 | 2.18 | 2.76 |
| 52 | .0635 | 7/8 | 1-7/8 | 2.18 | 2.76 |
| 53 | .0595 | 7/8 | 1-7/8 | 2.18 | 2.68 |
| 54 | .0550 | 7/8 | 1-7/8 | 2.18 | 2.68 |
| 55 | .0520 | 7/8 | 1-7/8 | 2.12 | 2.68 |
| 56 | .0465 | 3/4 | 1-3/4 | 2.18 | 2.68 |
| 57 | .0430 | 3/4 | 1-3/4 | 2.26 | 2.68 |
| 58 | .0420 | 11/16 | 1-5/8 | 2.26 | 2.68 |
| 59 | .0410 | 11/16 | 1-5/8 | 2.26 | 2.68 |
| 60 | .0400 | 11/16 | 1-5/8 | 2.26 | 2.68 |
| 61 | .0390 | 11/16 | 1-5/8 | 2.60 | 3.32 |
| 62 | .0380 | 5/8 | 1-1/2 | 2.60 | 3.32 |
| 63 | .0370 | 5/8 | 1-1/2 | 2.60 | 3.32 |
| 64 | .0360 | 5/8 | 1-1/2 | 2.60 | 3.32 |
| 65 | .0350 | 5/8 | 1-1/2 | 2.46 | 3.32 |
| 66 | .0330 | 1/2 | 1-3/8 | 2.60 | 3.32 |
| 67 | .0320 | 1/2 | 1-3/8 | 2.46 | 3.32 |
| 68 | .0310 | 1/2 | 1-3/8 | 2.46 | 3.32 |
| 69 | .0292 | 1/2 | 1-3/8 | 2.76 | 3.66 |
| 70 | .0280 | 3/8 | 1-1/4 | 2.76 | 3.66 |
| 71 | .0260 | 3/8 | 1-1/4 | 3.60 | 4.80 |
| 72 | .0250 | 5/16 | 1-1/8 | 3.38 | 4.80 |
| 73 | .0240 | 5/16 | 1-1/8 | 3.38 | 4.80 |
| 74 | .0225 | 1/4 | 1-1/8 | 3.38 | 4.80 |
| 75 | .0210 | 1/4 | 1-1/8 | 3.38 | 4.80 |
| 76 | .0200 | 3/16 | 7/8 | 3.38 | 4.80 |
| 77 | .0180 | 3/16 | 7/8 | 3.38 | 4.80 |
| 78 | .0160 | 3/16 | 7/8 | 3.38 | 4.80 |
| 79 | .0145 | 3/16 | 3/4 | 3.96 | 5.68 |
| 80 | .0135 | 3/16 | 3/4 | 3.96 | 5.68 |

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

| SIZE | DEC. EQUIV. | FLUTE LENGTH | OVERALL LENGTH | HIGH SPEED STEEL | |
|------|-------------|--------------|----------------|--------------------------|-------|
| | | | | BRIGHT FINISH 118° POINT | |
| | | | | JDF | JDS |
| A | .234 | 2-5/8 | 3-7/8 | 4.96 | 7.08 |
| B | .238 | 2-3/4 | 4 | 4.82 | 7.08 |
| C | .242 | 2-3/4 | 4 | 4.42 | 7.08 |
| D | .246 | 2-3/4 | 4 | 4.42 | 7.08 |
| E | .250 | 2-3/4 | 4 | 4.18 | 4.90 |
| F | .257 | 2-7/8 | 4-1/8 | 5.14 | 7.08 |
| G | .261 | 2-7/8 | 4-1/8 | 5.46 | 7.48 |
| H | .266 | 2-7/8 | 4-1/8 | 6.16 | 9.90 |
| I | .272 | 2-7/8 | 4-1/8 | 5.34 | 10.30 |
| J | .277 | 2-7/8 | 4-1/8 | 6.16 | 10.30 |
| K | .281 | 2-15/16 | 4-1/4 | 7.74 | 10.30 |
| L | .290 | 2-15/16 | 4-1/4 | 6.68 | 10.30 |
| M | .295 | 3-1/16 | 4-3/8 | 7.20 | 11.14 |

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|------|-------------|--------------|----------------|--------------------------|-------|
| | | | | BRIGHT FINISH 118° POINT | |
| | | | | JDF | JDS |
| N | .302 | 3-1/16 | 4-3/8 | 6.58 | 11.14 |
| O | .316 | 3-3/16 | 4-1/2 | 7.10 | 12.14 |
| P | .323 | 3-5/16 | 4-5/8 | 7.46 | 12.14 |
| Q | .332 | 3-7/16 | 4-3/4 | 7.46 | 12.08 |
| R | .339 | 3-7/16 | 4-3/4 | 7.74 | 13.94 |
| S | .348 | 3-1/2 | 4-7/8 | 8.40 | 14.60 |
| T | .358 | 3-1/2 | 4-7/8 | 9.84 | 14.60 |
| U | .368 | 3-5/8 | 5 | 9.84 | 14.60 |
| V | .377 | 3-5/8 | 5 | 10.36 | 15.18 |
| W | .386 | 3-3/4 | 5-1/8 | 10.60 | 17.96 |
| X | .397 | 3-3/4 | 5-1/8 | 12.08 | 17.96 |
| Y | .404 | 3-7/8 | 5-1/4 | 14.08 | 20.14 |
| Z | .413 | 3-7/8 | 5-1/4 | 14.66 | 20.14 |