

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	
				FAST SPIRAL	SLOW SPIRAL
				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

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL	
				FAST SPIRAL	SLOW SPIRAL
				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	
				FAST SPIRAL	SLOW SPIRAL
				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

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL	
				FAST SPIRAL	SLOW SPIRAL
				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