






# HIGH SPEED STEEL SPECIAL POINT JOBBER LENGTH DRILLS

ICS USA SPECIAL PURPOSE SPECIAL POINT

ITEM NO.	DRILL POINT ILLUSTRATION	CUTTING APPLICATION & FEATURES	STEEL SPECS
JD-FF118P	 Four Facet 118° Point	Four Facet (Pyrcon) Points have a primary cutting lip facet and a secondary heel clearance facet. It is the same geometry used on end mills and is designed for long life and harder metals. The secondary facet is ground to the midway point of the chisel to produce a self-centering point. It is one of the most accurate points for CNC Machine Centers.  <b>Note:</b> Use 118° Point for general purpose drilling. Use 135° Point for drilling work hardening metals.	M2
JD-FF135P	 Four Facet 135° Point		M2
JD-HS118P	 Helical "S" 118° Point	Helical Points have an S-shaped chisel which offers exceptional self-centering capability and reduced thrust. It was one of the first drill point geometries developed to save drilling time on CNC Machining Centers. Its four cutting edges will cut so close to actual diameter that reaming can be eliminated or reduced. Drill life is extended because the helical point wears evenly and will drill up to 15 times more holes than a conventional 118° point.  <b>Note:</b> Use 118° Point for general purpose drilling. Use 135° Point for drilling work hardening metals.	M2
JD-HS135P	 Helical "S" 135° Point		M2
JD-HFBP	 Helical Flat Bottom Point	Helical Flat Bottom Points have the features of both the helical and flat bottom point. They combine the self-centering point, long life, and the secondary reaming ability of the helical point with the burr-free breakthrough and the flat bottom or blind hole drilling ability of a flat bottom point. It can be used for plastic, wood, or metal.	M2

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

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HIGH SPEED STEEL				
				FOUR FACET 118° POINT	FOUR FACET 135° POINT	HELICAL "S" 118° POINT	HELICAL "S" 135° POINT	HELICAL FLAT BOTTOM POINT
				JD-FF118P	JD-FF135P	JD-HS118P	JD-HS135P	JD-HFBP
1/16	.0625	7/8	1-7/8	3.36	3.36	2.68	2.68	-
5/64	.0781	1	2	3.36	3.36	2.68	2.68	-
3/32	.0938	1-1/4	2-1/4	3.36	3.36	2.68	2.68	-
7/64	.1094	1-1/2	2-5/8	3.36	3.36	2.68	2.68	-
1/8	.1250	1-5/8	2-3/4	3.36	3.36	2.68	2.68	2.68
9/64	.1406	1-3/4	2-7/8	3.50	3.50	2.92	2.92	2.92
5/32	.1562	2	3-1/8	3.78	3.78	3.32	3.32	3.32
11/64	.1719	2-1/8	3-1/4	3.88	3.88	3.66	3.66	3.66
3/16	.1875	2-5/16	3-1/2	4.08	4.08	3.84	3.84	3.84
13/64	.2031	2-7/16	3-5/8	4.78	4.78	4.18	4.18	4.18
7/32	.2188	2-1/2	3-3/4	5.02	5.02	4.44	4.44	4.44
15/64	.2344	2-5/8	3-7/8	5.22	5.22	4.62	4.62	4.62
1/4	.2500	2-3/4	4	5.26	5.26	4.66	4.66	4.66
17/64	.2656	2-7/8	4-1/8	5.88	5.88	5.30	5.30	5.30
9/32	.2812	2-15/16	4-1/4	6.14	6.14	5.54	5.54	5.54
19/64	.2969	3-1/16	4-3/8	6.54	6.54	5.94	5.94	5.94
5/16	.3125	3-3/16	4-1/2	6.72	6.72	6.14	6.14	6.14
21/64	.3281	3-5/16	4-5/8	7.12	7.12	6.54	6.54	6.54
11/32	.3438	3-7/16	4-3/4	7.38	7.38	6.78	6.78	6.78
23/64	.3594	3-1/2	4-7/8	7.80	7.80	7.20	7.20	7.20
3/8	.3750	3-5/8	5	8.20	8.20	7.60	7.60	7.60
25/64	.3906	3-3/4	5-1/8	8.38	8.38	7.80	7.80	7.80
13/32	.4062	3-7/8	5-1/4	9.18	9.18	8.60	8.60	8.60
27/64	.4219	3-15/16	5-3/8	9.70	9.70	9.12	9.12	9.12
7/16	.4375	4-1/16	5-1/2	10.06	10.06	9.48	9.48	9.48
29/64	.4531	4-3/16	5-5/8	10.58	10.58	10.00	10.00	10.00
15/32	.4688	4-5/16	5-3/4	11.24	11.24	10.66	10.66	10.66
31/64	.4844	4-3/8	5-7/8	11.64	11.64	11.06	11.06	11.06
1/2	.5000	4-1/2	6	12.14	12.14	11.56	11.56	11.56

**PACKAGING**

1/64 to 17/64 - 12 Drills/Envelope  
9/32 to 1/2 - 6 Drills/Envelope

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**ORDERING NOTE**

Orders accepted in less than package quantity are subject to a 15% surcharge.

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**DRILL SETS**

Special Point Jobber Length Drill Sets can be found on page 63.



All Drill Pointing by ICS Cutting Tools is done on Winslow®. Drill Point Grinders manufactured by Giddings & Lewis.