

## HSS Jobber Length Twist Drills with Straight Shank

List No. JB02H10 -- M2 Black & Bronze Finish



List No. JB02H13 -- M2 Black & Bronze, Left



135° Split  
Quick-Cut  
Point

List No. JB02W10 -- HSS M2 Bright Finish



List No. JB42G10 -- HSS M42 Golden Finish



### Features

- \* Precision ground to insure concentricity of tip & body
- \* Smooth flutes & special surface treated for effective chip flow
- \* Penetrates faster with less pressure
- \* Premium quality high speed steel, special heat treatment to remain sharper edges, & reduce wear
- \* Self-feeding point, unique flute design and industrial heavy duty web can drill faster, cool, longer!
- \* Cobalt drills have extremely heat resistant
- \* Special bronze-oxide, Tin-Coated, Black Oxide, and bright surface treatment
- \* 3-Equal Flat on shank is for positive holding in 3-Jaw Chucks
- \* All dimensional & element tolerances conform to one of ASME/ANSI B94.11M, NAS 907 - National Aerospace Standards, USCTI - United States Cutting Tool Institute (formerly MCTI)

### Application

- \* Cobalt Drills are ideal for effective drilling in extremely hard metals including stainless steel and others
- \* 118° chisel angle for general purpose, and allows easier penetration
- \* 135° chisel angle with Split Point (D>1.70mm) may be used with heavier feeds (Quick-Cut) in harder materials, and avoid "Walk" or Wander". It is popular in hand held drilling applications to reduce breakage and eliminate skidding or walking.

### Sizes available

- Diameter 1/16" to 3/4" by 64ths with fully ground HSS M2
- Hands: Standard Drills are Right Hand. Left hand & Parabolic flutes are available as custom request
- Shank: Standard Drills are cylindrical shank. 3/8" shrink shank can be made for diameter larger than 3/8" Tanged shank is available as per custom request
- Male Point All drills under 3/32" may be have a chamfer or male point at MFG's option; Otherwise, chamfer on shank
- Drill Sets & Custom Package are available

**Material:** HSS M2, M35 Cobalt, M42 Cobalt

### How to Order ....

When order drills, please specify material, diameter, cut direction, surface finish, shank style, chisel point angle, etc

### Fractional Sizes

Size	Dec. Equiv	Flute Length	Overall Length	List No
1/64"	0.0156	3/16"	3/4"	R/L001
1/32"	0.0312	1/2"	1-3/8"	R/L002
3/64"	0.0469	3/4"	1-3/4"	R/L003
1/16"	0.0625	7/8"	1-7/8"	R/L004
5/64"	0.0781	1"	2"	R/L005
3/32"	0.0938	1-1/4"	2-1/4"	R/L006
7/64"	0.1094	1-1/2"	2-5/8"	R/L007
1/8"	0.1250	1-5/8"	2-3/4"	R/L008
9/64"	0.1406	1-3/4"	2-7/8"	R/L009
5/32"	0.1562	2"	3-1/8"	R/L010
11/64"	0.1719	2-1/8"	3-1/4"	R/L011
3/16"	0.1875	2-5/16"	3-1/2"	R/L012

Size	Dec. Equiv	Flute Length	Overall Length	List No
25/64"	0.3906	3-3/4"	5-1/8"	R/L025
13/32"	0.4062	3-7/8"	5-1/4"	R/L026
27/64"	0.4219	3-15/16"	5-3/8"	R/L027
7/16"	0.4375	4-1/16"	5-1/2"	R/L028
29/64"	0.4531	4-3/16"	5-5/8"	R/L029
15/32"	0.4688	4-5/16"	5-3/4"	R/L030
31/64"	0.4844	4-3/8"	5-7/8"	R/L031
1/2"	0.5000	4-1/2"	6"	R/L032
33/64"	0.5156	4-13/16"	6-5/8"	R/L033
17/32"	0.5312	4-13/16"	6-5/8"	R/L034
35/64"	0.5469	4-13/16"	6-5/8"	R/L035
9/16"	0.5625	4-13/16"	6-5/8"	R/L036

## HSS Jobber Length Twist Drills with Straight Shank

### Fractional Sizes

Size	Dec. Equiv	Flute Length	Overall Length	List No
13/64"	0.2031	2-7/16"	3-5/8"	R/L013
7/32"	0.2188	2-1/2"	3-3/4"	R/L014
15/64"	0.2344	2-5/8"	3-7/8"	R/L015
1/4"	0.2500	2-3/4"	4"	R/L016
17/64"	0.2656	2-7/8"	4-1/8"	R/L017
9/32"	0.2812	2-15/16"	4-1/4"	R/L018
19/64"	0.2969	3-1/16"	4-3/8"	R/L019
5/16"	0.3125	3-3/16"	4-1/2"	R/L020
21/64"	0.3281	3-5/16"	4-5/8"	R/L021
11/32"	0.3438	3-7/16"	4-3/4"	R/L022
23/64"	0.3594	3-1/2"	4-7/8"	R/L023
3/8"	0.3750	3-5/8"	5"	R/L024

Size	Dec. Equiv	Flute Length	Overall Length	List No
37/64"	0.5781	4-13/16"	6-5/8"	R/L037
19/32"	0.5938	5-3/16"	7-1/8"	R/L038
39/64"	0.6094	5-3/16"	7-1/8"	R/L039
5/8"	0.6250	5-3/16"	7-1/8"	R/L040
41/64"	0.6406	5-3/16"	7-1/8"	R/L041
21/32"	0.6562	5-3/16"	7-1/8"	R/L042
43/64"	0.6719	5-5/8"	7-5/8"	R/L043
11/16"	0.6875	5-5/8"	7-5/8"	R/L044
45/64"	0.7031	5-5/8"	7-5/8"	R/L045
23/32"	0.7188	5-5/8"	7-5/8"	R/L046
47/64"	0.7344	5-5/8"	7-5/8"	R/L047
3/4"	0.7500	5-5/8"	7-5/8"	R/L048

### Wire Gauge Sizes

Size	Dec. Equiv	Flute Length	Overall Length	List No
#1	0.2280	2-5/8"	3-7/8"	RN01
#2	0.2210	2-5/8"	3-7/8"	RN02
#3	0.2130	2-1/2"	3-3/4"	RN03
#4	0.2090	2-1/2"	3-3/4"	RN04
#5	0.2055	2-1/2"	3-3/4"	RN05
#6	0.2040	2-1/2"	3-3/4"	RN06
#7	0.2010	2-7/16"	3-5/8"	RN07
#8	0.1990	2-7/16"	3-5/8"	RN08
#9	0.1960	2-7/16"	3-5/8"	RN09
#10	0.1935	2-7/16"	3-5/8"	RN10
#11	0.1910	2-5/16"	3-1/2"	RN11
#12	0.1890	2-5/16"	3-1/2"	RN12
#13	0.1850	2-5/16"	3-1/2"	RN13
#14	0.1820	2-3/16"	3-3/8"	RN14
#15	0.1800	2-3/16"	3-3/8"	RN15
#16	0.1770	2-3/16"	3-3/8"	RN16
#17	0.1730	2-3/16"	3-3/8"	RN17
#18	0.1695	2-1/8"	3-1/4"	RN18
#19	0.1660	2-1/8"	3-1/4"	RN19
#20	0.1610	2-1/8"	3-1/4"	RN20
#21	0.1590	2-1/8"	3-1/4"	RN21
#22	0.1570	2"	3-1/8"	RN22
#23	0.1540	2"	3-1/8"	RN23
#24	0.1520	2"	3-1/8"	RN24
#25	0.1495	1-7/8"	3"	RN25
#26	0.1470	1-7/8"	3"	RN26
#27	0.1440	1-7/8"	3"	RN27
#28	0.1405	1-3/4"	2-7/8"	RN28
#29	0.1360	1-3/4"	2-7/8"	RN29
#30	0.1285	1-5/8"	2-3/4"	RN30

Size	Dec. Equiv	Flute Length	Overall Length	List No
#31	0.1200	1-5/8"	2-3/4"	RN31
#32	0.1160	1-5/8"	2-3/4"	RN32
#33	0.1130	1-1/2"	2-5/8"	RN33
#34	0.1110	1-1/2"	2-5/8"	RN34
#35	0.1100	1-1/2"	2-5/8"	RN35
#36	0.1065	1-7/16"	2-1/2"	RN36
#37	0.1040	1-7/16"	2-1/2"	RN37
#38	0.1015	1-7/16"	2-1/2"	RN38
#39	0.0995	1-3/8"	2-3/8"	RN39
#40	0.0980	1-3/8"	2-3/8"	RN40
#41	0.0960	1-3/8"	2-3/8"	RN41
#42	0.0935	1-1/4"	2-1/4"	RN42
#43	0.0890	1-1/4"	2-1/4"	RN43
#44	0.0860	1-1/8"	2-1/8"	RN44
#45	0.0820	1-1/8"	2-1/8"	RN45
#46	0.0810	1-1/8"	2-1/8"	RN46
#47	0.0785	1"	2"	RN47
#48	0.0760	1"	2"	RN48
#49	0.0730	1"	2"	RN49
#50	0.0700	1"	2"	RN50
#51	0.0670	1"	2"	RN51
#52	0.0635	7/8"	1-7/8"	RN52
#53	0.0595	7/8"	1-7/8"	RN53
#54	0.0550	7/8"	1-7/8"	RN54
#55	0.0520	7/8"	1-7/8"	RN55
#56	0.0465	3/4"	1-3/4"	RN56
#57	0.0430	3/4"	1-3/4"	RN57
#58	0.0420	11/16"	1-5/8"	RN58
#59	0.0410	11/16"	1-5/8"	RN59
#60	0.0400	11/16"	1-5/8"	RN60



## HSS Jobber Length Twist Drills with Straight Shank

### Letter Sizes

Size	Dec. Equiv	Flute Length	Overall Length	List No
A	0.234	2-5/8"	3-7/8"	RL0A
B	0.238	2-3/4"	4"	RL0B
C	0.242	2-3/4"	4"	RL0C
D	0.246	2-3/4"	4"	RL0D
E	0.250	2-3/4"	4"	RL0E
F	0.257	2-7/8"	4-1/8"	RL0F
G	0.261	2-7/8"	4-1/8"	RL0G
H	0.266	2-7/8"	4-1/8"	RL0H
I	0.272	2-7/8"	4-1/8"	RL0I
J	0.277	2-7/8"	4-1/8"	RL0J
K	0.281	2-15/16"	4-1/4"	RL0K
L	0.290	2-15/16"	4-1/4"	RL0L
M	0.295	3-1/16"	4-3/8"	RL0M

Size	Dec. Equiv	Flute Length	Overall Length	List No
N	0.302	4-3/8"	4-3/8"	RL0N
O	0.316	4-1/2"	4-1/2"	RL0O
P	0.323	4-5/8"	4-5/8"	RL0P
Q	0.332	4-3/4"	4-3/4"	RL0Q
R	0.339	4-3/4"	4-3/4"	RL0R
S	0.348	4-7/8"	4-7/8"	RL0S
T	0.358	4-7/8"	4-7/8"	RL0T
U	0.368	5"	5"	RL0U
V	0.377	5"	5"	RL0V
W	0.386	5-1/8"	5-1/8"	RL0W
X	0.397	5-1/8"	5-1/8"	RL0X
Y	0.404	5-1/4"	5-1/4"	RL0Y
Z	0.413	5-1/4"	5-1/4"	RL0Z

### Millimeter Jobber Length Drills

Size	Dec. Equiv	Flute Length	Overall Length	List No
0.15	0.0059	1/16"	3/4"	RM0015
0.16	0.0063	1/16"	3/4"	RM0016
0.17	0.0067	1/16"	3/4"	RM0017
0.18	0.0071	1/16"	3/4"	RM0018
0.19	0.0075	1/16"	3/4"	RM0019
0.20	0.0079	1/16"	3/4"	RM0020
0.22	0.0087	5/64"	3/4"	RM0022
0.25	0.0098	5/64"	3/4"	RM0025
0.26	0.0102	5/64"	3/4"	RM0026
0.27	0.0106	5/64"	3/4"	RM0027
0.28	0.0110	3/32"	3/4"	RM0028
0.29	0.0114	3/32"	3/4"	RM0029
0.30	0.0118	3/32"	3/4"	RM0030
0.32	0.0126	3/32"	3/4"	RM0032
0.35	0.0138	1/8"	3/4"	RM0035
0.38	0.0150	3/16"	3/4"	RM0038
0.40	0.0157	3/16"	3/4"	RM0040
0.42	0.0165	3/16"	7/8"	RM0042
0.45	0.0177	3/16"	7/8"	RM0045
0.48	0.0189	3/16"	7/8"	RM0048
0.50	0.0197	3/16"	7/8"	RM0050
0.55	0.0217	1/4"	1"	RM0055
0.60	0.0236	5/16"	1-1/8"	RM0060
0.65	0.0256	3/8"	1-1/4"	RM0065
0.70	0.0276	3/8"	1-1/4"	RM0070
0.75	0.0295	1/2"	1-3/8"	RM0075
0.80	0.0315	1/2"	1-3/8"	RM0080
0.85	0.0335	5/8"	1-1/2"	RM0085
0.90	0.0354	5/8"	1-1/2"	RM0090
0.95	0.0374	5/8"	1-1/2"	RM0095
1.00	0.0394	11/16"	1-5/8"	RM0100
1.05	0.0413	11/16"	1-5/8"	RM0105
1.10	0.0433	3/4"	1-3/4"	RM0110

Size	Dec. Equiv	Flute Length	Overall Length	List No
4.90	0.1929	2-7/16"	3-5/8"	RM0490
5.00	0.1969	2-7/16"	3-5/8"	RM0500
5.10	0.2008	2-7/16"	3-5/8"	RM0510
5.20	0.2047	2-1/2"	3-3/4"	RM0520
5.30	0.2087	2-1/2"	3-3/4"	RM0530
5.40	0.2126	2-1/2"	3-3/4"	RM0540
5.50	0.2165	2-1/2"	3-3/4"	RM0550
5.60	0.2205	2-5/8"	3-7/8"	RM0560
5.70	0.2244	2-5/8"	3-7/8"	RM0570
5.80	0.2283	2-5/8"	3-7/8"	RM0580
5.90	0.2323	2-5/8"	3-7/8"	RM0590
6.00	0.2362	2-3/4"	4"	RM0600
6.10	0.2402	2-3/4"	4"	RM0610
6.20	0.2441	2-3/4"	4"	RM0620
6.30	0.2480	2-3/4"	4"	RM0630
6.40	0.2520	2-7/8"	4-1/8"	RM0640
6.50	0.2559	2-7/8"	4-1/8"	RM0650
6.60	0.2598	2-7/8"	4-1/8"	RM0660
6.70	0.2638	2-7/8"	4-1/8"	RM0670
6.80	0.2677	2-7/8"	4-1/8"	RM0680
6.90	0.2717	2-7/8"	4-1/8"	RM0690
7.00	0.2756	2-7/8"	4-1/8"	RM0700
7.10	0.2795	2-15/16"	4-1/4"	RM0710
7.20	0.2835	2-15/16"	4-1/4"	RM0720
7.30	0.2874	2-15/16"	4-1/4"	RM0730
7.40	0.2913	3-1/16"	4-3/8"	RM0740
7.50	0.2953	3-1/16"	4-3/8"	RM0750
7.60	0.2992	3-1/16"	4-3/8"	RM0760
7.70	0.3031	3-3/16"	4-1/2"	RM0770
7.80	0.3071	3-3/16"	4-1/2"	RM0780
7.90	0.3110	3-3/16"	4-1/2"	RM0790
8.00	0.3150	3-3/16"	4-1/2"	RM0800
8.10	0.3189	3-5/16"	4-5/8"	RM0810

## HSS Jobber Length Twist Drills with Straight Shank

### Millimeter Jobber Length Drills

Size	Dec. Equiv	Flute Length	Overall Length	List No
1.15	0.0453	3/4"	1-3/4"	RM0115
1.20	0.0472	7/8"	1-7/8"	RM0120
1.25	0.0492	7/8"	1-7/8"	RM0125
1.30	0.0512	7/8"	1-7/8"	RM0130
1.35	0.0531	7/8"	1-7/8"	RM0135
1.40	0.0551	7/8"	1-7/8"	RM0140
1.45	0.0571	7/8"	1-7/8"	RM0145
1.50	0.0591	7/8"	1-7/8"	RM0150
1.55	0.0610	7/8"	1-7/8"	RM0155
1.60	0.0630	7/8"	1-7/8"	RM0160
1.65	0.0650	1"	2"	RM0165
1.70	0.0669	1"	2"	RM0170
1.75	0.0689	1"	2"	RM0175
1.80	0.0709	1"	2"	RM0180
1.85	0.0728	1"	2"	RM0185
1.90	0.0748	1"	2"	RM0190
1.95	0.0768	1"	2"	RM0195
2.00	0.0787	1"	2"	RM0200
2.05	0.0807	1-1/8"	2-1/8"	RM0205
2.10	0.0827	1-1/8"	2-1/8"	RM0210
2.15	0.0846	1-1/8"	2-1/8"	RM0215
2.20	0.0866	1-1/4"	2-1/4"	RM0220
2.25	0.0886	1-1/4"	2-1/4"	RM0225
2.30	0.0906	1-1/4"	2-1/4"	RM0230
2.35	0.0925	1-1/4"	2-1/4"	RM0235
2.40	0.0945	1-3/8"	2-3/8"	RM0240
2.45	0.0965	1-3/8"	2-3/8"	RM0245
2.50	0.0984	1-3/8"	2-3/8"	RM0250
2.60	0.1024	1-7/16"	2-1/2"	RM0260
2.70	0.1063	1-7/16"	2-1/2"	RM0270
2.80	0.1102	1-1/2"	2-5/8"	RM0280
2.90	0.1142	1-5/8"	2-3/4"	RM0290
3.00	0.1181	1-5/8"	2-3/4"	RM0300
3.10	0.1220	1-5/8"	2-3/4"	RM0310
3.20	0.1260	1-5/8"	2-3/4"	RM0320
3.30	0.1299	1-3/4"	2-7/8"	RM0330
3.40	0.1339	1-3/4"	2-7/8"	RM0340
3.50	0.1378	1-3/4"	2-7/8"	RM0350
3.60	0.1417	1-7/8"	3"	RM0360
3.70	0.1457	1-7/8"	3"	RM0370
3.80	0.1496	1-7/8"	3"	RM0380
3.90	0.1535	2"	3-1/8"	RM0390
4.00	0.1575	2-1/8"	3-1/4"	RM0400
4.10	0.1614	2-1/8"	3-1/4"	RM0410
4.20	0.1654	2-1/8"	3-1/4"	RM0420
4.30	0.1693	2-1/8"	3-1/4"	RM0430
4.40	0.1732	2-3/16"	3-3/8"	RM0440
4.50	0.1772	2-3/16"	3-3/8"	RM0450
4.60	0.1811	2-3/16"	3-3/8"	RM0460
4.70	0.1850	2-5/16"	3-1/2"	RM0470
4.80	0.1890	2-5/16"	3-1/2"	RM0480

Size	Dec. Equiv	Flute Length	Overall Length	List No
8.20	0.3228	3-5/16"	4-5/8"	RM0820
8.30	0.3268	3-5/16"	4-5/8"	RM0830
8.40	0.3307	3-7/16"	4-3/4"	RM0840
8.50	0.3346	3-7/16"	4-3/4"	RM0850
8.60	0.3386	3-7/16"	4-3/4"	RM0860
8.70	0.3425	3-7/16"	4-3/4"	RM0870
8.80	0.3465	3-1/2"	4-7/8"	RM0880
8.90	0.3504	3-1/2"	4-7/8"	RM0890
9.00	0.3543	3-1/2"	4-7/8"	RM0900
9.10	0.3583	3-1/2"	4-7/8"	RM0910
9.20	0.3622	3-5/8"	5"	RM0920
9.30	0.3661	3-5/8"	5"	RM0930
9.40	0.3701	3-5/8"	5"	RM0940
9.50	0.3740	3-5/8"	5"	RM0950
9.60	0.3780	3-3/4"	5-1/8"	RM0960
9.70	0.3819	3-3/4"	5-1/8"	RM0970
9.80	0.3858	3-3/4"	5-1/8"	RM0980
9.90	0.3898	3-3/4"	5-1/8"	RM0990
10.00	0.3937	3-3/4"	5-1/8"	RM1000
10.20	0.4016	3-7/8"	5-1/4"	RM1020
10.50	0.4134	3-7/8"	5-1/4"	RM1050
10.80	0.4252	4-1/16"	5-1/2"	RM1080
11.00	0.4331	4-1/16"	5-1/2"	RM1100
11.20	0.4409	4-3/16"	5-5/8"	RM1120
11.50	0.4528	4-3/16"	5-5/8"	RM1150
11.80	0.4646	4-5/16"	5-3/4"	RM1180
12.00	0.4724	4-3/8"	5-7/8"	RM1200
12.20	0.4803	4-3/8"	5-7/8"	RM1220
12.50	0.4921	4-1/2"	6"	RM1250
12.90	0.5039	4-1/2"	6"	RM1290
13.00	0.5118	4-1/2"	6"	RM1300
13.20	0.5197	4-13/16"	6-5/8"	RM1320
13.50	0.5315	4-13/16"	6-5/8"	RM1350
13.80	0.5433	4-13/16"	6-5/8"	RM1380
14.00	0.5512	4-13/16"	6-5/8"	RM1400
14.25	0.5610	4-13/16"	6-5/8"	RM1425
14.50	0.5709	4-13/16"	6-5/8"	RM1450
14.75	0.5807	5-3/16"	7-1/8"	RM1475
15.00	0.5906	5-3/16"	7-1/8"	RM1500
15.25	0.6004	5-3/16"	7-1/8"	RM1525
15.50	0.6102	5-3/16"	7-1/8"	RM1550
15.75	0.6201	5-3/16"	7-1/8"	RM1575
16.00	0.6299	5-3/16"	7-1/8"	RM1600
16.25	0.6398	5-3/16"	7-1/8"	RM1625
16.50	0.6496	5-3/16"	7-1/8"	RM1650
16.75	0.6594	5-5/8"	7-5/8"	RM1675
17.00	0.6693	5-5/8"	7-5/8"	RM1700
17.25	0.6791	5-5/8"	7-5/8"	RM1725
17.50	0.6890	5-5/8"	7-5/8"	RM1750
18.00	0.7087	5-5/8"	7-5/8"	RM1800
19.00	0.7480	5-5/8"	7-5/8"	RM1900