

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	JBFXXX
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	JBFXXX
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	JBFXXX
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	JBFXXX
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	JBNXXX
#1	0.2280	2-5/8"	3-7/8"	R01
#2	0.2210	2-5/8"	3-7/8"	R02
#3	0.2130	2-1/2"	3-3/4"	R03
#4	0.2090	2-1/2"	3-3/4"	R04
#5	0.2055	2-1/2"	3-3/4"	R05
#6	0.2040	2-1/2"	3-3/4"	R06
#7	0.2010	2-7/16"	3-5/8"	R07
#8	0.1990	2-7/16"	3-5/8"	R08
#9	0.1960	2-7/16"	3-5/8"	R09
#10	0.1935	2-7/16"	3-5/8"	R10
#11	0.1910	2-5/16"	3-1/2"	R11
#12	0.1890	2-5/16"	3-1/2"	R12
#13	0.1850	2-5/16"	3-1/2"	R13
#14	0.1820	2-3/16"	3-3/8"	R14
#15	0.1800	2-3/16"	3-3/8"	R15
#16	0.1770	2-3/16"	3-3/8"	R16
#17	0.1730	2-3/16"	3-3/8"	R17
#18	0.1695	2-1/8"	3-1/4"	R18
#19	0.1660	2-1/8"	3-1/4"	R19
#20	0.1610	2-1/8"	3-1/4"	R20
#21	0.1590	2-1/8"	3-1/4"	R21
#22	0.1570	2"	3-1/8"	R22
#23	0.1540	2"	3-1/8"	R23
#24	0.1520	2"	3-1/8"	R24
#25	0.1495	1-7/8"	3"	R25
#26	0.1470	1-7/8"	3"	R26
#27	0.1440	1-7/8"	3"	R27
#28	0.1405	1-3/4"	2-7/8"	R28
#29	0.1360	1-3/4"	2-7/8"	R29
#30	0.1285	1-5/8"	2-3/4"	R30

Size	Dec. Equiv	Flute Length	Overall Length	JBNXXX
#31	0.1200	1-5/8"	2-3/4"	R31
#32	0.1160	1-5/8"	2-3/4"	R32
#33	0.1130	1-1/2"	2-5/8"	R33
#34	0.1110	1-1/2"	2-5/8"	R34
#35	0.1100	1-1/2"	2-5/8"	R35
#36	0.1065	1-7/16"	2-1/2"	R36
#37	0.1040	1-7/16"	2-1/2"	R37
#38	0.1015	1-7/16"	2-1/2"	R38
#39	0.0995	1-3/8"	2-3/8"	R39
#40	0.0980	1-3/8"	2-3/8"	R40
#41	0.0960	1-3/8"	2-3/8"	R41
#42	0.0935	1-1/4"	2-1/4"	R42
#43	0.0890	1-1/4"	2-1/4"	R43
#44	0.0860	1-1/8"	2-1/8"	R44
#45	0.0820	1-1/8"	2-1/8"	R45
#46	0.0810	1-1/8"	2-1/8"	R46
#47	0.0785	1"	2"	R47
#48	0.0760	1"	2"	R48
#49	0.0730	1"	2"	R49
#50	0.0700	1"	2"	R50
#51	0.0670	1"	2"	R51
#52	0.0635	7/8"	1-7/8"	R52
#53	0.0595	7/8"	1-7/8"	R53
#54	0.0550	7/8"	1-7/8"	R54
#55	0.0520	7/8"	1-7/8"	R55
#56	0.0465	3/4"	1-3/4"	R56
#57	0.0430	3/4"	1-3/4"	R57
#58	0.0420	11/16"	1-5/8"	R58
#59	0.0410	11/16"	1-5/8"	R59
#60	0.0400	11/16"	1-5/8"	R60

HSS Jobber Length Twist Drills with Straight Shank

Letter Sizes

Size	Dec. Equiv	Flute Length	Overall Length	JBLXXX
A	0.234	2-5/8"	3-7/8"	R0A
B	0.238	2-3/4"	4"	R0B
C	0.242	2-3/4"	4"	R0C
D	0.246	2-3/4"	4"	R0D
E	0.250	2-3/4"	4"	R0E
F	0.257	2-7/8"	4-1/8"	R0F
G	0.261	2-7/8"	4-1/8"	R0G
H	0.266	2-7/8"	4-1/8"	R0H
I	0.272	2-7/8"	4-1/8"	R0I
J	0.277	2-7/8"	4-1/8"	R0J
K	0.281	2-15/16"	4-1/4"	R0K
L	0.290	2-15/16"	4-1/4"	R0L
M	0.295	3-1/16"	4-3/8"	R0M

Size	Dec. Equiv	Flute Length	Overall Length	JBLXXX
N	0.302	4-3/8"	4-3/8"	R0N
O	0.316	4-1/2"	4-1/2"	R0O
P	0.323	4-5/8"	4-5/8"	R0P
Q	0.332	4-3/4"	4-3/4"	R0Q
R	0.339	4-3/4"	4-3/4"	R0R
S	0.348	4-7/8"	4-7/8"	R0S
T	0.358	4-7/8"	4-7/8"	R0T
U	0.368	5"	5"	R0U
V	0.377	5"	5"	R0V
W	0.386	5-1/8"	5-1/8"	R0W
X	0.397	5-1/8"	5-1/8"	R0X
Y	0.404	5-1/4"	5-1/4"	R0Y
Z	0.413	5-1/4"	5-1/4"	R0Z

Millimeter Jobber Length Drills

Size	Dec. Equiv	Flute Length	Overall Length	JBMXXX
0.15	0.0059	1/16"	3/4"	R0015
0.16	0.0063	1/16"	3/4"	R0016
0.17	0.0067	1/16"	3/4"	R0017
0.18	0.0071	1/16"	3/4"	R0018
0.19	0.0075	1/16"	3/4"	R0019
0.20	0.0079	1/16"	3/4"	R0020
0.22	0.0087	5/64"	3/4"	R0022
0.25	0.0098	5/64"	3/4"	R0025
0.26	0.0102	5/64"	3/4"	R0026
0.27	0.0106	5/64"	3/4"	R0027
0.28	0.0110	3/32"	3/4"	R0028
0.29	0.0114	3/32"	3/4"	R0029
0.30	0.0118	3/32"	3/4"	R0030
0.32	0.0126	3/32"	3/4"	R0032
0.35	0.0138	1/8"	3/4"	R0035
0.38	0.0150	3/16"	3/4"	R0038
0.40	0.0157	3/16"	3/4"	R0040
0.42	0.0165	3/16"	7/8"	R0042
0.45	0.0177	3/16"	7/8"	R0045
0.48	0.0189	3/16"	7/8"	R0048
0.50	0.0197	3/16"	7/8"	R0050
0.55	0.0217	1/4"	1"	R0055
0.60	0.0236	5/16"	1-1/8"	R0060
0.65	0.0256	3/8"	1-1/4"	R0065
0.70	0.0276	3/8"	1-1/4"	R0070
0.75	0.0295	1/2"	1-3/8"	R0075
0.80	0.0315	1/2"	1-3/8"	R0080
0.85	0.0335	5/8"	1-1/2"	R0085
0.90	0.0354	5/8"	1-1/2"	R0090
0.95	0.0374	5/8"	1-1/2"	R0095
1.00	0.0394	11/16"	1-5/8"	R0100
1.05	0.0413	11/16"	1-5/8"	R0105
1.10	0.0433	3/4"	1-3/4"	R0110

Size	Dec. Equiv	Flute Length	Overall Length	JBMXXX
4.90	0.1929	2-7/16"	3-5/8"	R0490
5.00	0.1969	2-7/16"	3-5/8"	R0500
5.10	0.2008	2-7/16"	3-5/8"	R0510
5.20	0.2047	2-1/2"	3-3/4"	R0520
5.30	0.2087	2-1/2"	3-3/4"	R0530
5.40	0.2126	2-1/2"	3-3/4"	R0540
5.50	0.2165	2-1/2"	3-3/4"	R0550
5.60	0.2205	2-5/8"	3-7/8"	R0560
5.70	0.2244	2-5/8"	3-7/8"	R0570
5.80	0.2283	2-5/8"	3-7/8"	R0580
5.90	0.2323	2-5/8"	3-7/8"	R0590
6.00	0.2362	2-3/4"	4"	R0600
6.10	0.2402	2-3/4"	4"	R0610
6.20	0.2441	2-3/4"	4"	R0620
6.30	0.2480	2-3/4"	4"	R0630
6.40	0.2520	2-7/8"	4-1/8"	R0640
6.50	0.2559	2-7/8"	4-1/8"	R0650
6.60	0.2598	2-7/8"	4-1/8"	R0660
6.70	0.2638	2-7/8"	4-1/8"	R0670
6.80	0.2677	2-7/8"	4-1/8"	R0680
6.90	0.2717	2-7/8"	4-1/8"	R0690
7.00	0.2756	2-7/8"	4-1/8"	R0700
7.10	0.2795	2-15/16"	4-1/4"	R0710
7.20	0.2835	2-15/16"	4-1/4"	R0720
7.30	0.2874	2-15/16"	4-1/4"	R0730
7.40	0.2913	3-1/16"	4-3/8"	R0740
7.50	0.2953	3-1/16"	4-3/8"	R0750
7.60	0.2992	3-1/16"	4-3/8"	R0760
7.70	0.3031	3-3/16"	4-1/2"	R0770
7.80	0.3071	3-3/16"	4-1/2"	R0780
7.90	0.3110	3-3/16"	4-1/2"	R0790
8.00	0.3150	3-3/16"	4-1/2"	R0800
8.10	0.3189	3-5/16"	4-5/8"	R0810

HSS Jobber Length Twist Drills with Straight Shank

Millimeter Jobber Length Drills

Size	Dec. Equiv	Flute Length	Overall Length	JBMXXX
1.15	0.0453	3/4"	1-3/4"	R0115
1.20	0.0472	7/8"	1-7/8"	R0120
1.25	0.0492	7/8"	1-7/8"	R0125
1.30	0.0512	7/8"	1-7/8"	R0130
1.35	0.0531	7/8"	1-7/8"	R0135
1.40	0.0551	7/8"	1-7/8"	R0140
1.45	0.0571	7/8"	1-7/8"	R0145
1.50	0.0591	7/8"	1-7/8"	R0150
1.55	0.0610	7/8"	1-7/8"	R0155
1.60	0.0630	7/8"	1-7/8"	R0160
1.65	0.0650	1"	2"	R0165
1.70	0.0669	1"	2"	R0170
1.75	0.0689	1"	2"	R0175
1.80	0.0709	1"	2"	R0180
1.85	0.0728	1"	2"	R0185
1.90	0.0748	1"	2"	R0190
1.95	0.0768	1"	2"	R0195
2.00	0.0787	1"	2"	R0200
2.05	0.0807	1-1/8"	2-1/8"	R0205
2.10	0.0827	1-1/8"	2-1/8"	R0210
2.15	0.0846	1-1/8"	2-1/8"	R0215
2.20	0.0866	1-1/4"	2-1/4"	R0220
2.25	0.0886	1-1/4"	2-1/4"	R0225
2.30	0.0906	1-1/4"	2-1/4"	R0230
2.35	0.0925	1-1/4"	2-1/4"	R0235
2.40	0.0945	1-3/8"	2-3/8"	R0240
2.45	0.0965	1-3/8"	2-3/8"	R0245
2.50	0.0984	1-3/8"	2-3/8"	R0250
2.60	0.1024	1-7/16"	2-1/2"	R0260
2.70	0.1063	1-7/16"	2-1/2"	R0270
2.80	0.1102	1-1/2"	2-5/8"	R0280
2.90	0.1142	1-5/8"	2-3/4"	R0290
3.00	0.1181	1-5/8"	2-3/4"	R0300
3.10	0.1220	1-5/8"	2-3/4"	R0310
3.20	0.1260	1-5/8"	2-3/4"	R0320
3.30	0.1299	1-3/4"	2-7/8"	R0330
3.40	0.1339	1-3/4"	2-7/8"	R0340
3.50	0.1378	1-3/4"	2-7/8"	R0350
3.60	0.1417	1-7/8"	3"	R0360
3.70	0.1457	1-7/8"	3"	R0370
3.80	0.1496	1-7/8"	3"	R0380
3.90	0.1535	2"	3-1/8"	R0390
4.00	0.1575	2-1/8"	3-1/4"	R0400
4.10	0.1614	2-1/8"	3-1/4"	R0410
4.20	0.1654	2-1/8"	3-1/4"	R0420
4.30	0.1693	2-1/8"	3-1/4"	R0430
4.40	0.1732	2-3/16"	3-3/8"	R0440
4.50	0.1772	2-3/16"	3-3/8"	R0450
4.60	0.1811	2-3/16"	3-3/8"	R0460
4.70	0.1850	2-5/16"	3-1/2"	R0470
4.80	0.1890	2-5/16"	3-1/2"	R0480

Size	Dec. Equiv	Flute Length	Overall Length	JBMXXX
8.20	0.3228	3-5/16"	4-5/8"	R0820
8.30	0.3268	3-5/16"	4-5/8"	R0830
8.40	0.3307	3-7/16"	4-3/4"	R0840
8.50	0.3346	3-7/16"	4-3/4"	R0850
8.60	0.3386	3-7/16"	4-3/4"	R0860
8.70	0.3425	3-7/16"	4-3/4"	R0870
8.80	0.3465	3-1/2"	4-7/8"	R0880
8.90	0.3504	3-1/2"	4-7/8"	R0890
9.00	0.3543	3-1/2"	4-7/8"	R0900
9.10	0.3583	3-1/2"	4-7/8"	R0910
9.20	0.3622	3-5/8"	5"	R0920
9.30	0.3661	3-5/8"	5"	R0930
9.40	0.3701	3-5/8"	5"	R0940
9.50	0.3740	3-5/8"	5"	R0950
9.60	0.3780	3-3/4"	5-1/8"	R0960
9.70	0.3819	3-3/4"	5-1/8"	R0970
9.80	0.3858	3-3/4"	5-1/8"	R0980
9.90	0.3898	3-3/4"	5-1/8"	R0990
10.00	0.3937	3-3/4"	5-1/8"	R1000
10.20	0.4016	3-7/8"	5-1/4"	R1020
10.50	0.4134	3-7/8"	5-1/4"	R1050
10.80	0.4252	4-1/16"	5-1/2"	R1080
11.00	0.4331	4-1/16"	5-1/2"	R1100
11.20	0.4409	4-3/16"	5-5/8"	R1120
11.50	0.4528	4-3/16"	5-5/8"	R1150
11.80	0.4646	4-5/16"	5-3/4"	R1180
12.00	0.4724	4-3/8"	5-7/8"	R1200
12.20	0.4803	4-3/8"	5-7/8"	R1220
12.50	0.4921	4-1/2"	6"	R1250
12.90	0.5039	4-1/2"	6"	R1290
13.00	0.5118	4-1/2"	6"	R1300
13.20	0.5197	4-13/16"	6-5/8"	R1320
13.50	0.5315	4-13/16"	6-5/8"	R1350
13.80	0.5433	4-13/16"	6-5/8"	R1380
14.00	0.5512	4-13/16"	6-5/8"	R1400
14.25	0.5610	4-13/16"	6-5/8"	R1425
14.50	0.5709	4-13/16"	6-5/8"	R1450
14.75	0.5807	5-3/16"	7-1/8"	R1475
15.00	0.5906	5-3/16"	7-1/8"	R1500
15.25	0.6004	5-3/16"	7-1/8"	R1525
15.50	0.6102	5-3/16"	7-1/8"	R1550
15.75	0.6201	5-3/16"	7-1/8"	R1575
16.00	0.6299	5-3/16"	7-1/8"	R1600
16.25	0.6398	5-3/16"	7-1/8"	R1625
16.50	0.6496	5-3/16"	7-1/8"	R1650
16.75	0.6594	5-5/8"	7-5/8"	R1675
17.00	0.6693	5-5/8"	7-5/8"	R1700
17.25	0.6791	5-5/8"	7-5/8"	R1725
17.50	0.6890	5-5/8"	7-5/8"	R1750
18.00	0.7087	5-5/8"	7-5/8"	R1800
19.00	0.7480	5-5/8"	7-5/8"	R1900