



## High Speed Steel PARALLEL SHANK TWIST DRILLS Jobber Series

Specifications Conform to:  
 IS 5101 - 1991  
 ISO 235 - 1980  
 DIN 338 - 1978  
 BS 328 : Part 1 : 1985  
 Dimensions in mm / Inch



Diameters h8			Flute Length	Overall Length
mm	Inch	Number Series		
0.30			3	19
0.40	1/64		5	20
0.50			6	22
0.60			7	24
0.70			9	28
0.80	1/32	68,67,66	10	30
0.90		65,64,63	11	32
1.00		62,61,60,59	12	34
1.10		58,57	14	36
1.20	3/64	56	16	38
1.30		55	16	38
1.40		54	18	40
1.50			18	40
1.60	1/16	53,52	20	43
1.70			20	43
1.80		51,50	22	46
1.90		49	22	46
2.00	5/64	48,47	24	49
2.10		46,45	24	49
2.20		44	27	53
2.30		43	27	53
2.40	3/32	42,41	30	57
2.50		40,39	30	57
2.60		38,37	30	57
2.70		36	33	61

Diameters h8			Flute Length	Overall Length
mm	Inch	Number Series		
2.80	7/64	35,34	33	61
2.90		33,32	33	61
3.00			33	61
3.10		31	36	65
3.20	1/8		36	65
3.30		30	36	65
3.40			39	70
3.50		29	39	70
3.60	9/64	28	39	70
3.70		27,26	39	70
3.80		25	43	75
3.90		24,23	43	75
4.00	5/32	22,21	43	75
4.10		20	43	75
4.20		19	43	75
4.30		18	47	80
4.40	11/64	17	47	80
4.50		16	47	80
4.60		15,14	47	80
4.70		13	47	80
4.80	3/16	12	52	86
4.90		11,10	52	86
5.00		9	52	86
5.10		9	52	86
5.20	13/64	6,5	52	86

A drill having two flutes and a parallel shank of approximately the same diameter as the cutting end.

Type 'N' Drills shall be supplied unless otherwise specified.

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Diameters h8			Flute Length	Overall Length
mm	Inch	Number & Letter series		
5.30			52	86
5.40		4,3	57	93
5.50			57	93
5.60	7/32	2	57	93
5.70			57	93
5.80		1	57	93
5.90		A	57	93
6.00	15/64		57	93
6.10		B,C	63	101
6.20		D	63	101
6.30			63	101
6.40	1/4	E	63	101
6.50		F	63	101
6.60		G	63	101
6.70			63	101
6.80	17/64	H	69	109
6.90		I	69	109
7.00		J	69	109
7.10	9/32	K	69	109
7.20			69	109
7.30			69	109
7.40		L	69	109
7.50		M	69	109
7.60	19/64		75	117
7.70		N	75	117
7.80			75	117
7.90	5/16		75	117
8.00		O	75	117
8.10			75	117
8.20		P	75	117
8.30	21/64		75	117
8.40		Q	75	117
8.50			75	117

Diameters h8			Flute Length	Overall Length
mm	Inch	Number & Letter series		
8.60		R	81	125
8.70	11/32		81	125
8.80		S	81	125
8.90			81	125
9.00			81	125
9.10	23/64	T	81	125
9.20			81	125
9.30		U	81	125
9.40			81	125
9.50			81	125
9.60	3/8	V	87	133
9.70			87	133
9.80		W	87	133
9.90	25/64		87	133
10.00			87	133
10.10		X	87	133
10.20			87	133
10.30	13/32	Y	87	133
10.40			87	133
10.50		Z	87	133
10.60		-	87	133
10.70	27/64	-	94	142
10.80		-	94	142
10.90		-	94	142
11.00		-	94	142
11.10	7/16	-	94	142
11.20		-	94	142
11.30		-	94	142
11.40		-	94	142
11.50	29/64	-	94	142
11.60		-	94	142
11.70		-	94	142
11.80		-	94	142

Diameters h8		Flute Length	Overall Length
mm	Inch		
11.90	15/32	101	151
12.00		101	151
12.10		101	151
12.20		101	151
12.30	31/64	101	151
12.40		101	151
12.50		101	151
12.60		101	151
12.70	1/2	101	151
12.80		101	151
12.90		101	151
13.00		101	151
13.10	33/64	101	151
13.20		101	151
13.30		108	160
13.40		108	160
13.50	17/32	108	160

Diameters h8		Flute Length	Overall Length
mm	Inch		
13.60		108	160
13.70		108	160
13.80		108	160
13.90	35/64	108	160
14.00		108	160
14.25	9/16	114	169
14.50		114	169
14.75	37/64	114	169
15.00		114	169
15.25	19/32	120	178
15.50	39/64	120	178
15.75		120	178
16.00	5/8	120	178
17.00		125	184
18.00	11/16	130	191
19.00		135	198
20.00	3/4	140	205