

NACHI

CUTTING TOOLS

HSS / HSCO DRILL SERIES CATALOG



SCREW MACHINE LENGTH BRIGHT

List No. 561 General Purpose



Fractional: Range 3/64" to 2"
 Wire: Range #1 to #60
 Letter Range: A to Z

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1061218		#60		0.0400	1/2	1 3/8
1061224		#59		0.0410		
1061230		#58		0.0420		
1061247		#57		0.0430		
1061253		#56		0.0465		
1265486	3/64			0.0469		
1061276		#55		0.0520		
1061282		#54		0.0550		
1061299		#53		0.0595		
1265492	1/16			0.0625		
1061310		#52		0.0635	5/8	1 5/8
1061327		#51		0.0670		
1061333		#50		0.0700		
1061340		#49		0.0730		
1061356		#48		0.0760		
1265508	5/64			0.0781		
1061379		#47		0.0785		
1061385		#46		0.0810		
1061391		#45		0.0820		
1061407		#44		0.0860		
1061413		#43		0.0890	3/4	1 3/4
1061420		#42		0.0935		
1265514	3/32			0.0938		
1061442		#41		0.0960		
1061459		#40		0.0980		
1061465		#39		0.0995		
1061471		#38		0.1015		
1061488		#37		0.1040		
1061494		#36		0.1065		
1265520	7/64			0.1094		
1061516		#35		0.1100	7/8	1 7/8
1061522		#34		0.1110		
1061539		#33		0.1130		
1061545		#32		0.1160		
1061551		#31		0.1200		
1265537	1/8			0.1250		
1061568		#30		0.1285		
1061574		#29		0.1360		
1061580		#28		0.1405		
1265543	9/64			0.1406		
1061602		#27		0.1440	1	2 1/16
1061619		#26		0.1470		
1061625		#25		0.1495		
1061631		#24		0.1520		
1061648		#23		0.1540		
1265550	5/32			0.1563		
1061660		#22		0.1570		
1061677		#21		0.1590		
1061683		#20		0.1610		
1061690		#19		0.1660		
1061705		#18		0.1695	1 1/16	2 1/8
1265566	11/64			0.1719		
1061728		#17		0.1730		
1061734		#16		0.1770		
1061740		#15		0.1800		
1061757		#14		0.1820		
1061763		#13		0.1850		
1265572	3/16			0.1875		
1061786		#12		0.1890		

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1004080		#11		0.1910	1 3/16	2 1/4
1061792		#10		0.1935		
1061808		#9		0.1960		
1061814		#8		0.1990		
1061820		#7		0.2010		
1265589	13/64			0.2031		
1061843		#6		0.2040		
1061850		#5		0.2055		
1061866		#4		0.2090		
1061872		#3		0.2130		
1265595	7/32			0.2188	1 1/4	2 3/8
1061895		#2		0.2210		
1061900		#1		0.2285		
1061917			A	0.2340		
1265600	15/64			0.2344		
1061930			B	0.2380		
1061946			C	0.2420		
1061952			D	0.2460		
1265617	1/4			0.2500		
1061975			E	0.2500		
1061981			F	0.2570	1 3/8	2 1/2
1061998			G	0.2610		
1265623	17/64			0.2656		
1062019			H	0.2660		
1062025			I	0.2720		
1062031			J	0.2770		
1062048			K	0.2810		
1265630	9/32			0.2813		
1062060			L	0.2900		
1062077			M	0.2950		
1265646	19/64			0.2969	1 9/16	2 3/4
1062090			N	0.3020		
1265652	5/16			0.3125		
1062111			O	0.3160		
1062128			P	0.3230		
1265669	21/64			0.3281		
1062140			Q	0.3320		
1062157			R	0.3390		
1265675	11/32			0.3438		
1062170			S	0.3480		
1062186			T	0.3580	1 5/8	2 13/16
1265681	23/64			0.3594		
1062208			U	0.3680		
1265698	3/8			0.3750		
1062220			V	0.3770		
1062237			W	0.3860		
1265703	25/64			0.3906		
1062250			X	0.3970		
1062266			Y	0.4040		
1265710	13/32			0.4063		
1062289			Z	0.4130	1 3/4	3 1/16
1265726	27/64			0.4219		
1265732	7/16			0.4375		

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1265749	29/64			0.4531	2 1/8	3 9/16
1265755	15/32			0.4688		
1265761	31/64			0.4844		
1265778	1/2			0.5000		
1265784	33/64			0.5156		
1265790	17/32			0.5313		
1265806	35/64			0.5469		
1265812	9/16			0.5625		
1265829	37/64			0.5781		
1265835	19/32			0.5938		
1265841	39/64			0.6094	2 1/2	4
1265858	5/8			0.6250		
1265864	41/64			0.6406		
1265870	21/32			0.6563		
1265887	43/64			0.6719		
1265893	11/16			0.6875		
1265909	45/64			0.7031		
1265915	23/32			0.7188		
1265921	47/64			0.7344		
1265938	3/4			0.7500		
1265944	49/64			0.7656	3	4 3/4
1265950	25/32			0.7813		
1265967	51/64			0.7969		
1265973	13/16			0.8125		
1265980	53/64			0.8281		
1265996	27/32			0.8438		
1266000	55/64			0.8594		
1266017	7/8			0.8750		
1266023	57/64			0.8906		
1266030	29/32			0.9063		
1266046	59/64			0.9219	3 1/8	5
1266052	15/16			0.9375		
1266069	61/64			0.9531		
1266075	31/32			0.9688		
1266081	63/64			0.9844		
1266098	1			1.0000		
1266103	1 1/16			1.0625		
1266110	1 1/8			1.1250		
1266126	1 3/16			1.1875		
1266132	1 1/4			1.2500		
1266149	1 5/16			1.3125	3 3/8	5 1/4
1266155	1 3/8			1.3750		
1266161	1 7/16			1.4375		
1266178	1 1/2			1.5000		
1266184	1 9/16			1.5625		
1266190	1 5/8			1.6250		
1266206	1 11/16			1.6875		
1266212	1 3/4			1.7500		
1266229	1 13/16			1.8125		
1266235	1 7/8			1.8750		
1266241	1 15/16			1.9375	4	6
1266258	2			2.0000		

Fractional sizes: Sizes 3/64 to 5/16 in package of 10; 21/64 to 1/2 in package of 5
 Wire gauge sizes: All sizes in package of 10
 Letter sizes: A to N in package of 10; O to Z in package of 5

SCREW MACHINE LENGTH TIN COATED

List No. 561P General Purpose



Fractional: Range 1/16" to 1/2"
Wire: Range #1 to #52

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1087629	1/16			0.0625	5/8	1 5/8
1019049		#52		0.0635	11/16	1 11/16
1019112		#51		0.0670		
1019215		#50		0.0700		
1019324		#49		0.0730		
1019347		#48		0.0760		
1087635	5/64			0.0781	3/4	1 3/4
1019410		#47		0.0785		
1019433		#46		0.0810		
1019456		#45		0.0820		
1019520		#44		0.0860		
1019594		#43		0.0890		
1019651		#42		0.0935		
1087641	3/32			0.0938		
1019805		#41		0.0960	13/16	1 13/16
1019863		#40		0.0980		
1019892		#39		0.0995		
1020096		#38		0.1015		
1020124		#37		0.1040		
1020199		#36		0.1065		
1087658	7/64			0.1094		
1020371		#35		0.1100	7/8	1 7/8
1020416		#34		0.1110		
1020468		#33		0.1130		
1020480		#32		0.1160		
1020502		#31		0.1200		
1087664	1/8			0.1250	15/16	1 15/16
1020548		#30		0.1285		
1020560		#29		0.1360		
1020583		#28		0.1405		
1087670	9/64			0.1406	1	2 1/16
1020611		#27		0.1440		
1020634		#26		0.1470		
1020663		#25		0.1495		
1020708		#24		0.1520		
1020720		#23		0.1540		
1087687	5/32			0.1563		
1020795		#22		0.1570		
1020846		#21		0.1590		
1020869		#20		0.1610		
1020898		#19		0.1660		

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1020961		#18		0.1695	1.0625	2 1/8
1087693	11/64			0.1719	1.125	2 3/16
1021034		#17		0.1730		
1021092		#16		0.1770		
1021200		#15		0.1800		
1021230		#14		0.1820		
1021252		#13		0.1850		
1087709	3/16			0.1875		
1021303		#12		0.1890	1.1875	2 1/4
1021355		#11		0.1910		
1021493		#10		0.1935		
1021521		#9		0.1960		
1021567		#8		0.1990		
1021601		#7		0.2010		
1087715	13/64			0.2031	1 1/4	
1021653		#6		0.2040		
1021676		#5		0.2055		
1021699		#4		0.2090		
1021710		#3		0.2130		
1087721	7/32			0.2188		
1021762		#2		0.2210		
1021791		#1		0.2285	1 5/16	2 7/16
1087738	15/64			0.2344	1 3/8	2 1/2
1087744	1/4			0.2500		
1087750	17/64			0.2656	1 7/16	2 5/8
1087767	9/32			0.2813	1 1/2	2 11/16
1087773	19/64			0.2969	1 9/16	2 3/4
1087780	5/16			0.3125	1 5/8	2 13/16
1087796	21/64			0.3281	1 11/16	2 15/16
1087801	11/32			0.3438	1 11/16	3
1087818	23/64			0.3594	1 3/4	3 1/16
1087824	3/8			0.3750	1 13/16	3 1/8
1087830	25/64			0.3906	1 7/8	3 1/4
1087847	13/32			0.4063	1 5/16	3 5/16
1087853	27/64			0.4219	2	3 3/8
1087860	7/16			0.4375	2 1/16	3 7/16
1087876	29/64			0.4531	2 1/8	3 9/16
1087882	15/32			0.4688	2 1/8	3 5/8
1087899	31/64			0.4844	2 3/16	3 11/16
1087904	1/2			0.5000	2 1/4	3 3/4

Fractional sizes: Sizes 3/64 to 5/16 in package of 10; 21/64 to 1/2 in package of 5
Wire gauge sizes: All sizes in package of 10

SCREW MACHINE LENGTH AIRCRAFT

List No. 563 Aircraft NAS907-C - Black Oxide



Fractional Range: 3/64" to 1/2"
 Range: #1 to #52
 Letter: Range A to Z

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1050626	3/64			0.0469	1/2	1 3/8
1050632	1/16			0.0625	5/8	1 5/8
1050649		#52		0.0635	11/16	1 11/16
1050655		#51		0.0670		
1050661		#50		0.0700		
1050678		#49		0.0730		
1050684		#48		0.0760		
1050690	5/64			0.0781	3/4	1 3/4
1050706		#47		0.0785		
1050712		#46		0.0810		
1050729		#45		0.0820		
1050735		#44		0.0860		
1050741		#43		0.0890	13/16	1 13/16
1050758		#42		0.0935		
1050764	3/32			0.0938		
1050770		#41		0.0960		
1050787		#40		0.0980		
1050793		#39		0.0995	7/8	1 7/8
1050809		#38		0.1015		
1050815		#37		0.1040		
1050821		#36		0.1065		
1050838	7/64			0.1094		
1050844		#35		0.1100	15/16	1 15/16
1050850		#34		0.1110		
1050867		#33		0.1130		
1050873		#32		0.1160		
1050880		#31		0.1200		
1050896	1/8			0.1250	1	2 1/16
1050901		#30		0.1285		
1059812		#29		0.1360		
1050918		#28		0.1405		
1050924	9/64			0.1406		
1050930		#27		0.1440	1	2 1/8
1050947		#26		0.1470		
1050953		#25		0.1495		
1050960		#24		0.1520		
1050976		#23		0.1540		
1059829	5/32			0.1563	1.0625	2 1/8
1050982		#22		0.1570		
1050999		#21		0.1590		
1059835		#20		0.1610		
1051003		#19		0.1660		
1051010		#18		0.1695	1.125	2 3/16
1059841	11/64			0.1719		
1051026		#17		0.1730		
1051032		#16		0.1770		
1051049		#15		0.1800		
1051055		#14		0.1820	1.1875	2 1/4
1051061		#13		0.1850		
1051078	3/16			0.1875		
1051084		#12		0.1890		
1051090		#11		0.1910		
1051106		#10		0.1935	1 3/16	2 1/4
1051112		#9		0.1960		

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1051129		#8		0.1990	1 3/16	2 1/4
1051135		#7		0.2010		
1059858	13/64			0.2031		
1051141		#6		0.2040		
1051158		#5		0.2055		
1051164		#4		0.2090	1 1/4	2 3/8
1051170		#3		0.2130		
1051187	7/32			0.2188		
1051193		#2		0.2210		
1051209		#1		0.2285		
1051215			A	0.2340	15/16	2 7/16
1051221	15/64			0.2344		
1051238			B	0.2380		
1051244			C	0.2420		
1051250			D	0.2460		
1051267	1/4			0.2500	1 3/8	2 1/2
1051273			E	0.2500		
1051280			F	0.2570		
1051296			G	0.2610		
1051301	17/64			0.2656		
1059864			H	0.2660	1 7/16	2 5/8
1051318			I	0.2720		
1051324			J	0.2770		
1051330			K	0.2810		
1051347	9/32			0.2813		
1051353			L	0.2900	1 9/16	2 3/4
1051360			M	0.2950		
1051376	19/64			0.2969		
1051382			N	0.3020		
1051399	5/16			0.3125		
1051404			O	0.3160	1 11/16	3
1051410			P	0.3230		
1051427	21/64			0.3281		
1051433			Q	0.3320		
1051440			R	0.3390		
1051456	11/32			0.3438	1 3/4	3 1/16
1051462			S	0.3480		
1051479			T	0.3580		
1051485	23/64			0.3594		
1051491			U	0.3680		
1059870	3/8			0.3750	1 13/16	3 1/8
1051507			V	0.3770		
1051513			W	0.3860		
1051520	25/64			0.3906		
1051536			X	0.3970		
1051542			Y	0.4040	1 15/16	3 5/16
1051559	13/32			0.4063		
1051565			Z	0.4130		
1051571	27/64			0.4219		
1051588	7/16			0.4375		
1051594	29/64			0.4531	2	3 3/8
1051600	15/32			0.4688		
1051616	31/64			0.4844		
1051622	1/2			0.5000		

Fractional sizes: Sizes 3/64 to 5/16 in package of 10; 21/64 to 1/2 in package of 5
 Wire gauge sizes: All sizes in package of 10
 Letter sizes: A to N in package of 10; O to Z in package of 5

SCREW MACHINE LENGTH COBALT

List No. 6563 Aircraft NAS907-C - Cobalt



Fractional: Bright Finish 3/64 to 7/64 Black Oxide 1/8 to 1/2
 Wire: Bright Finish #32 to #52 Black Oxide #1 to #31
 Letter: Range A to Z

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1080704	3/64			0.0469	1/2	1 3/8
1080710	1/16			0.0625	5/8	1 5/8
1081259		#52		0.0635	11/16	1 11/16
1081265		#51		0.0670		
1081271		#50		0.0700		
1081288		#49		0.0730		
1081294		#48		0.0760		
1080727	5/64			0.0781		
1081300		#47		0.0785		
1081316		#46		0.0810		
1081322		#45		0.0820		
1081339		#44		0.0860		
1081345		#43		0.0890		
1081351		#42		0.0935		
1080733	3/32			0.0938		
1081368		#41		0.0960		
1081374		#40		0.0980		
1081380		#39		0.0995		
1081397		#38		0.1015		
1081402		#37		0.1040		
1081419		#36		0.1065		
1080740	7/64			0.1094		
1081425		#35		0.1100		
1081431		#34		0.1110		
1081448		#33		0.1130		
1081454		#32		0.1160		
1081460		#31		0.1200		
1080756	1/8			0.1250		
1081477		#30		0.1285		
1081483		#29		0.1360		
1081490		#28		0.1405		
1080762	9/64			0.1406		
1081505		#27		0.1440		
1081511		#26		0.1470		
1081528		#25		0.1495		
1081534		#24		0.1520		
1081540		#23		0.1540		

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1080779	5/32			0.1563	1	2 1/8
1081557		#22		0.1570	1 1/16	2 1/8
1081563		#21		0.1590		
1081570		#20		0.1610		
1081586		#19		0.1660		
1081592		#18		0.1695		
1080785	11/64			0.1719		
1081608		#17		0.1730		
1081614		#16		0.1770		
1081620		#15		0.1800		
1081637		#14		0.1820		
1081643		#13		0.1850		
1080791	3/16			0.1875		
1081650		#12		0.1890		
1081666		#11		0.1910		
1081672		#10		0.1935		
1081689		#9		0.1960		
1081695		#8		0.1990		
1081700		#7		0.2010		
1080807	13/64			0.2031		
1081717		#6		0.2040		
1081723		#5		0.2055		
1081730		#4		0.2090		
1081746		#3		0.2130		
1080813	7/32			0.2188		
1081752		#2		0.2210		
1081769		#1		0.2285		
1081001			A	0.2340		
1080820	15/64			0.2344		
1081018			B	0.2380		
1081024			C	0.2420		
1146978			D	0.2460		
1080836	1/4			0.2500		
1081030			E	0.2500		
1081047			F	0.2570		
1081053			G	0.2610		
1080842	17/64			0.2656		

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1081060			H	0.2660	1 1/2	2 11/16
1081076			I	0.2720		
1081082			J	0.2770		
1081099			K	0.2810		
1080859	9/32			0.2813		
1081104			L	0.2900		
1081110			M	0.2950		
1080865	19/64			0.2969		
1081127			N	0.3020		
1080871	5/16			0.3125		
1081133			O	0.3160		
1081140			P	0.3230		
1080888	21/64			0.3281		
1081156			Q	0.3320		
1081162			R	0.3390		
1080894	11/32			0.3438		
1081179			S	0.3480		
1081185			T	0.3580		
1080900	23/64			0.3594		
1081191			U	0.3680		
1080916	3/8			0.3750		
1081207			V	0.3770		
1081213			W	0.3860		
1080922	25/64			0.3906		
1081220			X	0.3970		
1081236			Y	0.4040		
1080939	13/32			0.4063		
1081242			Z	0.4130		
1080945	27/64			0.4219		
1080951	7/16			0.4375		
1080968	29/64			0.4531		
1080974	15/32			0.4688		
1080980	31/64			0.4844		
1080997	1/2			0.5000		

Fractional sizes: Sizes 3/64 to 5/16 in package of 10; 21/64 to 1/2 in package of 5
 Wire gauge sizes: All sizes in package of 10
 Letter sizes: A to N in package of 10; O to Z in package of 5

WARNING: Cancer - www.P65Warnings.ca.gov

STRAIGHT SHANK JOBBER LENGTH BRIGHT

List No. 501A General Purpose



Fractional: Range 1/64" to 11/16"
Wire: Range #1 to #80
Letter: Range A to Z

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
0010870		#80		0.0135	1/8	3/4
0010886		#79		0.0145	3/16	
0010892	1/64			0.0156		
0010908		#78		0.0160	7/8	
0010914		#77		0.0180		
0010920		#76		0.0200	1	
0010937		#75		0.0210		
0010943		#74		0.0225	1 1/8	
0010950		#73		0.0240		
0010966		#72		0.0250	1 1/4	
0010972		#71		0.0260		
0010989		#70		0.0280	1 3/8	
0010995		#69		0.0292		
0011000		#68		0.0310	1 1/2	
0011016	1/32			0.0313		
0011022		#67		0.0320	1 1/2	
0011039		#66		0.0330		
0011045		#65		0.0350	1 3/4	
0011051		#64		0.0360		
0011068		#63		0.0370	1 7/8	
0011074		#62		0.0380		
0011080		#61		0.0390	2	
0545092		#60		0.0400		
0545108		#59		0.0410	2 1/8	
0545114		#58		0.0420		
0545120		#57		0.0430	2 1/4	
0545137		#56		0.0465		
0543593	3/64			0.0469	2 3/8	
0545143		#55		0.0520		
0545150		#54		0.0550	2 1/2	
0545166		#53		0.0595		
0543609	1/16			0.0625	2 3/4	
0545172		#52		0.0635		
0545189		#51		0.0670	2 7/8	
0545195		#50		0.0700		
0545200		#49		0.0730	3	
0545217		#48		0.0760		
0543615	5/64			0.0781	3 1/8	
0545223		#47		0.0785		
0545230		#46		0.0810	3 1/4	
0545246		#45		0.0820		
0545252		#44		0.0860	3 3/4	
0545269		#43		0.0890		
0545275		#42		0.0935	4	
0543621	3/32			0.0938		
0545281		#41		0.0960	4 1/8	
0545298		#40		0.0980		
0545303		#39		0.0995	4 1/4	
0545310		#38		0.1015		
0545326		#37		0.1040	4 1/2	

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
0545332		#36		0.1065	7/16	2 1/2
0543638	7/64			0.1094	1/2	2 5/8
0545349		#35		0.1100		
0545355		#34		0.1110	1 1/2	2 3/4
0545361		#33		0.1130		
0545378		#32		0.1160	1 5/8	2 3/4
0545384		#31		0.1200		
0543644	1/8			0.1250	1 3/4	2 7/8
0545390		#30		0.1285		
0545406		#29		0.1360	2	3 1/8
0545412		#28		0.1405		
0543650	9/64			0.1406	1 7/8	3
0545429		#27		0.1440		
0545435		#26		0.1470	2	3 1/8
0545441		#25		0.1495		
0545458		#24		0.1520	2 1/8	3 1/4
0545464		#23		0.1540		
0543667	5/32			0.1563	2 3/16	3 3/8
0545470		#22		0.1570		
0545487		#21		0.1590	2 1/8	3 1/4
0545493		#20		0.1610		
0545509		#19		0.1660	2 3/16	3 3/8
0545515		#18		0.1695		
0545521		#17		0.1700	2 1/8	3 1/4
0543673	11/64			0.1719		
0545538		#16		0.1730	2 3/16	3 3/8
0545544		#15		0.1800		
0545550		#14		0.1820	2 5/16	3 1/2
0545567		#13		0.1850		
0543680	3/16			0.1875	2 7/16	3 5/8
0545573		#12		0.1890		
0545580		#11		0.1910	2 1/2	3 3/4
0545596		#10		0.1935		
0545601		#9		0.1960	2 3/4	4
0545618		#8		0.1990		
0545624		#7		0.2010	2 3/4	4
0543696	13/64			0.2031		
0545630		#6		0.2040	2 1/2	3 3/4
0545647		#5		0.2055		
0545653		#4		0.2090	2 5/8	3 7/8
0545660		#3		0.2130		
0543701	7/32			0.2188	2 3/4	4
0545676		#2		0.2210		
0545682		#1		0.2280	2 3/4	4
0545699			A	0.2340		
0543718	15/64			0.2344	2 3/4	4
0545704			B	0.2380		
0545710			C	0.2420	2 3/4	4
0545727			D	0.2460		
0543724	1/4			0.2500		

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
0545733			E	0.2500	2 3/4	4
0545740			F	0.2570	2 7/8	4 1/8
0545756			G	0.2610		
0543730	17/64			0.2656	2 15/16	4 1/4
0545762			H	0.2660		
0545779			I	0.2720	3 1/16	4 3/8
0545785			J	0.2770		
0545791			K	0.2810	3 1/16	4 3/8
0543747	9/32			0.2813		
0545807			L	0.2900	3 3/16	4 1/2
0545813			M	0.2950		
0543753	19/64			0.2969	3 5/16	4 5/8
0545820			N	0.3020		
0543760	5/16			0.3125	3 7/16	4 3/4
0545836			O	0.3160		
0545842			P	0.3230	3 7/16	4 3/4
0543776	21/64			0.3281		
0545859			Q	0.3320	3 7/8	5 1/4
0545865			R	0.3390		
0543782	11/32			0.3438	3 1/2	4 7/8
0545871			S	0.3480		
0545888			T	0.3580	3 5/8	5
0543799	23/64			0.3594		
0545894			U	0.3680	3 3/4	5 1/8
0543804	3/8			0.3750		
0545900			V	0.3770	3 7/8	5 1/4
0545916			W	0.3860		
0543810	25/64			0.3906	3 7/8	5 1/4
0545922			X	0.3970		
0545939			Y	0.4040	4 1/2	6
0543827	13/32			0.4063		
0545945			Z	0.4130	4 13/16	6 5/8
0543833	27/64			0.4219		
0543840	7/16			0.4375	5 3/16	7 1/8
0543856	29/64			0.4531		
0543862	15/32			0.4688	5 3/8	7 1/4
0543879	31/64			0.4844		
0543885	1/2			0.5000	5 7/8	7 5/8
1131784	33/64			0.5156		
1131790	17/32			0.5313	5 7/8	7 5/8
1131806	35/64			0.5469		
1131812	9/16			0.5625	5 7/8	7 5/8
1131829	37/64			0.5781		
1131835	19/32			0.5938	5 7/8	7 5/8
1131841	39/64			0.6094		
1131858	5/8			0.6250	5 7/8	7 5/8
1131864	41/64			0.6406		
1131870	21/32			0.6563	5 7/8	7 5/8
1131887	43/64			0.6719		
1131893	11/16			0.6875		

Fractional sizes: Sizes 1/64 to 5/16 in package of 10; 21/64 to 1/2 in package of 5; 33/64 to 11/16 in package of 2
Wire gauge sizes: All sizes in package of 10
Letter sizes: A to N in package of 10; O to Z in package of 5

STRAIGHT SHANK JOBBER LENGTH

List No. 500

General Purpose



Bright Finish 0.2 to 1.95 mm
Black Oxide 2.0 to 17.5 mm

(Unit) : mm

EDP	Size	Decimal Equivalent	Flute Length	Overall Length	EDP	Size	Decimal Equivalent	Flute Length	Overall Length	EDP	Size	Decimal Equivalent	Flute Length	Overall Length
0121256	0.2000	0.0079	3	19	0004333	2.8000	0.1102			0004917	7.5000	0.2953		
0345266	0.2200	0.0087			0156256	2.8500	0.1122	39	67	0004930	7.6000	0.2992	78	111
0062423	0.2500	0.0098			0004340	2.9000	0.1142			0004946	7.7000	0.3031		
0345403	0.2800	0.0110	3.5	20	0159123	2.9500	0.1161			0141194	7.7500	0.3051		
0062417	0.3000	0.0118			0004356	3.0000	0.1181			0004952	7.8000	0.3071	81	114
0345478	0.3200	0.0126			0004362	3.1000	0.1220	42	71	0004969	7.9000	0.3110		
0062400	0.3500	0.0138	5.5	24	0004385	3.2000	0.1260			0004981	8.0000	0.3150		
0345570	0.3800	0.0150			0159713	3.2500	0.1280			0004998	8.1000	0.3189		
0062395	0.4000	0.0157			0004391	3.3000	0.1299			0005002	8.2000	0.3228	84	117
0346474	0.4200	0.0165			0004407	3.4000	0.1339	45	73	0142957	8.2500	0.3248		
0062389	0.4500	0.0177	7.5	27	0118957	3.5000	0.1378			0005019	8.3000	0.3268		
0346560	0.4800	0.0189			0004436	3.6000	0.1417			0005031	8.4000	0.3307		
0062372	0.5000	0.0197			0004442	3.7000	0.1457			0005048	8.5000	0.3346	87	121
0062366	0.5500	0.0217			0159880	3.7500	0.1476	48	76	0005054	8.6000	0.3386		
0062350	0.6000	0.0236	8.5	30	0004459	3.8000	0.1496			0005060	8.7000	0.3425		
0062343	0.6500	0.0256	10	32	0004465	3.9000	0.1535	51	79	0143151	8.7500	0.3445		
0062337	0.7000	0.0276			0004488	4.0000	0.1575			0005083	8.8000	0.3465		
0062320	0.7500	0.0295	11	34	0004494	4.1000	0.1614			0005090	8.9000	0.3504	89	124
0062314	0.8000	0.0315			0004500	4.2000	0.1654	54	83	0005105	9.0000	0.3543		
0062308	0.8500	0.0335	13	36	0159931	4.2500	0.1673			0005111	9.1000	0.3583		
0062292	0.9000	0.0354			0004516	4.3000	0.1693			0005134	9.2000	0.3622		
0062286	0.9500	0.0374	18	40	0004539	4.4000	0.1732			0143517	9.2500	0.3642		
0062270	1.0000	0.0394			0004545	4.5000	0.1772	56	86	0005140	9.3000	0.3661	92	127
0128870	1.0500	0.0413			0004551	4.6000	0.1811			0005157	9.4000	0.3701		
0062263	1.1000	0.0433	20	42	0004568	4.7000	0.1850			0005163	9.5000	0.3740		
0129641	1.1500	0.0453			0160090	4.7500	0.1870	59	89	0005186	9.6000	0.3780		
0062257	1.2000	0.0472			0004580	4.8000	0.1890			0005192	9.7000	0.3819		
0130298	1.2500	0.0492	22	45	0004597	4.9000	0.1929			0144244	9.7500	0.3839		
0062240	1.3000	0.0512			0004602	5.0000	0.1969	62	92	0005208	9.8000	0.3858	95	130
0131271	1.3500	0.0531			0004619	5.1000	0.2008			0005214	9.9000	0.3898		
0062234	1.4000	0.0551	23	48	0004631	5.2000	0.2047			0005237	10.0000	0.3937		
0132473	1.4500	0.0571			0160347	5.2500	0.2067			0005250	10.2000	0.4016	98	133
0062228	1.5000	0.0591			0004648	5.3000	0.2087	64	95	0144410	10.2500	0.4035		
0133280	1.5500	0.0610			0004654	5.4000	0.2126			0005295	10.5000	0.4134	100	137
0062211	1.6000	0.0630	25	50	0004660	5.5000	0.2165			0144651	10.7500	0.4232		
0134098	1.6500	0.0650			0004683	5.6000	0.2205			0005330	10.8000	0.4252	103	140
0062205	1.7000	0.0669			0004690	5.7000	0.2244			0005352	11.0000	0.4331		
0135254	1.7500	0.0689			0160600	5.7500	0.2264	67	98	0005381	11.2000	0.4409		
0062190	1.8000	0.0709	28	52	0004705	5.8000	0.2283			0145074	11.2500	0.4429	106	143
0136870	1.8500	0.0728			0004711	5.9000	0.2323			0005410	11.5000	0.4528		
0062183	1.9000	0.0748			0004734	6.0000	0.2362			0145635	11.7500	0.4626		
0138728	1.9500	0.0768			0004740	6.1000	0.2402			0005455	11.8000	0.4646	109	146
0004230	2.0000	0.0787			0004757	6.2000	0.2441	70	102	0005484	12.0000	0.4724		
0139856	2.0500	0.0807	29	55	0140640	6.2500	0.2461			0005506	12.2000	0.4803	111	149
0004247	2.1000	0.0827			0004763	6.3000	0.2480			0147317	12.2500	0.4823		
0143632	2.1500	0.0846			0004786	6.4000	0.2520			0005541	12.5000	0.4921		
0004253	2.2000	0.0866			0004792	6.5000	0.2559			0147804	12.7500	0.5020	114	152
0144536	2.2500	0.0886	33	58	0004808	6.6000	0.2598			0005587	12.8000	0.5039		
0004260	2.3000	0.0906			0004814	6.7000	0.2638			0005609	13.0000	0.5118		
0146385	2.3500	0.0925			0140713	6.7500	0.2657	73	105	0005615	13.5000	0.5315		
0004282	2.4000	0.0945			0004837	6.8000	0.2677			0005638	14.0000	0.5512	122	168
0147810	2.4500	0.0965	35	61	0004843	6.9000	0.2717			0005644	14.5000	0.5709		
0004299	2.5000	0.0984			0004850	7.0000	0.2756			0005650	15.0000	0.5906		
0149355	2.5500	0.1004			0004866	7.1000	0.2795			0005667	15.5000	0.6102	132	181
0004304	2.6000	0.1024			0004889	7.2000	0.2835			0005673	16.0000	0.6299		
0151450	2.6500	0.1043	37	64	0140977	7.2500	0.2854	75	108	0005680	16.5000	0.6496		
0004310	2.7000	0.1063			0004895	7.3000	0.2874			0005701	17.0000	0.6693		
0152995	2.7500	0.1083	39	67	0004900	7.4000	0.2913	78	111	0005718	17.5000	0.6890	143	194

0.2 to 8.0 in package of 10; 8.1 to 13.0 in package of 5; 13.5 to 17.50 in package of 2

STRAIGHT SHANK JOBBER LENGTH

List No. 501 General Purpose - Black Oxide



Fractional: Range 3/64" to 11/16"
 Wire: Range #1 to #60
 Letter: Range A to Z

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
0011097		#60		0.0400		
0011102		#59		0.0410	11/16	1 5/8
0011119		#58		0.0420		
0011125		#57		0.0430		
0011131		#56		0.0465	3/4	1 3/4
0011148	3/64			0.0469		
0011154		#55		0.0520		
0011160		#54		0.0550		
0011177		#53		0.0595	7/8	1 7/8
0011183	1/16			0.0625		
0011190		#52		0.0635		
0011205		#51		0.0670		
0011211		#50		0.0700		
0011228		#49		0.0730	1	2
0011234		#48		0.0760		
0011240	5/64			0.0781		
0011257		#47		0.0785		
0011263		#46		0.0810		
0011270		#45		0.0820	1 1/8	2 1/8
0011286		#44		0.0860		
0011292		#43		0.0890		
0011308		#42		0.0935	1 1/4	2 1/4
0011314	3/32			0.0938		
0011320		#41		0.0960		
0590530		#40		0.0980	1 3/8	2 3/8
0011343		#39		0.0995		
0011350		#38		0.1015		
0011366		#37		0.1040	1 7/16	2 1/2
0011372		#36		0.1065		
0011389	7/64			0.1094		
0011395		#35		0.1100	1 1/2	2 5/8
0011400		#34		0.1110		
0011417		#33		0.1130		
0011423		#32		0.1160		
0011430		#31		0.1200	1 5/8	2 3/4
0011446	1/8			0.1250		
0011452		#30		0.1285		
0011469		#29		0.1360		
0011475		#28		0.1405	1 3/4	2 7/8
0011481	9/64			0.1406		
0011498		#27		0.1440		
0011503		#26		0.1470	1 7/8	3

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
0011526		#24		0.1520		
0011532		#23		0.1540	2	3 1/8
0011549	5/32			0.1563		
0011555		#22		0.1570		
0011561		#21		0.1590		
0011578		#20		0.1610		
0011584		#19		0.1660	2 1/8	3 1/4
0011590		#18		0.1695		
0011606	11/64			0.1719		
0011629		#17		0.1730		
0011612		#16		0.1770	2 3/16	3 3/8
0011635		#15		0.1800		
0011641		#14		0.1820		
0011658		#13		0.1850		
0011664	3/16			0.1875	2 5/16	3 1/2
0011670		#12		0.1890		
0011687		#11		0.1910		
0011693		#10		0.1935		
0011709		#9		0.1960		
0011715		#8		0.1990	2 7/16	3 5/8
0011721		#7		0.2010		
0011738	13/64			0.2031		
0011744		#6		0.2040		
0011750		#5		0.2055		
0011767		#4		0.2090	2 1/2	3 3/4
0011773		#3		0.2130		
0011780	7/32			0.2188		
0011796		#2		0.2210		
0011801		#1		0.2280	2 5/8	3 7/8
0553836			A	0.2340		
0011818	15/64			0.2344		
0553842			B	0.2380		
0553859			C	0.2420		
0553865			D	0.2460	2 3/4	4
0553871			E	0.2500		
0011824	1/4			0.2500		
0553888			F	0.2570		
0553894			G	0.2610		
0011830	17/64			0.2656	2 7/8	4 1/8
0553900			H	0.2660		
0553916			I	0.2720		
0553922			J	0.2770		

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
0011847	9/32			0.2813	2 15/16	4 1/4
0553945			L	0.2900		
0553951			M	0.2950		
0011853	19/64			0.2969	3 1/16	4 3/8
0553968			N	0.3020		
0011860	5/16			0.3125	3 3/16	4 1/2
0553974			O	0.3160		
0553980			P	0.3230	3 5/16	4 5/8
0011876	21/64			0.3281		
0553997			Q	0.3320		
0554001			R	0.3390	3 7/16	4 3/4
0011882	11/32			0.3438		
0554018			S	0.3480		
0554024			T	0.3580	3 1/2	4 7/8
0011899	23/64			0.3594		
0554030			U	0.3680		
0011904	3/8			0.3750	3 5/8	5
0554047			V	0.3770		
0554053			W	0.3860		
0011910	25/64			0.3906	3 3/4	5 1/8
0554060			X	0.3970		
0554076			Y	0.4040		
0011927	13/32			0.4063	3 7/8	5 1/4
0554082			Z	0.4130		
0011933	27/64			0.4219	3 15/16	5 3/8
0011940	7/16			0.4375	4 1/16	5 1/2
0011956	29/64			0.4531	4 3/16	5 5/8
0011962	15/32			0.4688	4 5/16	5 3/4
0011979	31/64			0.4844	4 3/8	5 7/8
0011985	1/2			0.5000	4 1/2	6
1131669	33/64			0.5156		
1131675	17/32			0.5313		
1131681	35/64			0.5469	4 13/16	6 5/8
1131698	9/16			0.5625		
1131703	37/64			0.5781		
1131710	19/32			0.5938		
1131726	39/64			0.6094		
1131732	5/8			0.6250	5 3/16	7 1/8
1131749	41/64			0.6406		
1131755	21/32			0.6563		
1131761	43/64			0.6719	5 5/8	7 5/8
1131778	11/16			0.6875		

Fractional sizes: Sizes 1/64 to 5/16 in package of 10; 21/64 to 1/2 in package of 5; 33/64 to 11/16 in package of 2
 Wire gauge sizes: All sizes in package of 10
 Letter sizes: A to N in package of 10; O to Z in package of 5

STRAIGHT SHANK JOBBER LENGTH AIRCRAFT

List No. 6501 Aircraft NAS907-J - Black Oxide



Fractional: Range 1/64" to 1/2"

Wire: Range #1 to #80

Letter: Range A to Z

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1056762		#80		0.0135	1/8	3/4
1056779		#79		0.0145		
1056785	1/64			0.0156	3/16	7/8
1056791		#78		0.0160		
1056807		#77		0.0180	1/4	1
1056813		#76		0.0200		
1056820		#75		0.0210	5/16	1 1/8
1056836		#74		0.0225		
1056842		#73		0.0240	3/8	1 1/4
1056855		#72		0.0250		
1056859		#71		0.0260	1/2	1 3/8
1056871		#70		0.0280		
1056888		#69		0.0292	5/8	1 1/2
1056894		#68		0.0310		
1056900	1/32			0.0313	11/16	1 5/8
1056916		#67		0.0320		
1056922		#66		0.0330	3/4	1 3/4
1056939		#65		0.0350		
1056945		#64		0.0360	7/8	1 7/8
1056951		#63		0.0370		
1056968		#62		0.0380	1	2
1053889		#61		0.0390		
1059950		#60		0.0400	1 1/8	2 1/8
1059967		#59		0.0410		
1059973		#58		0.0420	1 1/4	2 1/4
1059980		#57		0.0430		
1059986		#56		0.0465	1 3/8	2 3/8
1053895	3/64			0.0469		
1060000		#55		0.0520	1 3/8	2 3/8
1060016		#54		0.0550		
1060022		#53		0.0595	1 3/8	2 3/8
1053900	1/16			0.0625		
1060039		#52		0.0635	1 3/8	2 3/8
1060045		#51		0.0670		
1060051		#50		0.0700	1 3/8	2 3/8
1060068		#49		0.0730		
1060074		#48		0.0760	1 3/8	2 3/8
1053923	5/64			0.0781		
1060080		#47		0.0785	1 3/8	2 3/8
1060097		#46		0.0810		
1060102		#45		0.0820	1 3/8	2 3/8
1060119		#44		0.0860		
1060125		#43		0.0890	1 3/8	2 3/8
1060131		#42		0.0935		
1053946	3/32			0.0938	1 3/8	2 3/8
1060148		#41		0.0960		

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1060154		#40		0.0980	1 3/8	2 3/8
1060160		#39		0.0995		
1060177		#38		0.1015	1 7/16	2 1/2
1060183		#37		0.1040		
1060190		#36		0.1065	1 1/2	2 5/8
1053969	7/64			0.1094		
1060205		#35		0.1100	1 5/8	2 3/4
1060211		#34		0.1110		
1060228		#33		0.1130	2	3 1/8
1060234		#32		0.1160		
1060240		#31		0.1200	2 1/8	3 1/4
1060257	1/8			0.1250		
1060263		#30		0.1285	2 3/16	3 3/8
1060270		#29		0.1360		
1060286		#28		0.1405	2 5/16	3 1/2
1060292	9/64			0.1406		
1060308		#27		0.1440	2 7/8	3 5/8
1060314		#26		0.1470		
1060320		#25		0.1495	3	4
1060337		#24		0.1520		
1060343		#23		0.1540	3 1/4	4 1/4
1060350	5/32			0.1563		
1060366		#22		0.1570	3 1/2	4 1/2
1060372		#21		0.1590		
1060389		#20		0.1610	3 3/4	4 3/4
1060395		#19		0.1660		
1060400		#18		0.1695	3 7/8	4 3/4
1060423		#17		0.1700		
1060417	11/64			0.1719	4	4 3/4
1060430		#16		0.1730		
1060446		#15		0.1800	4 1/4	4 3/4
1060452		#14		0.1820		
1060469		#13		0.1850	4 1/2	4 3/4
1060475	3/16			0.1875		
1060481		#12		0.1890	4 3/4	4 3/4
1060498		#11		0.1910		
1060503		#10		0.1935	4 3/4	4 3/4
1060510		#9		0.1960		
1060526		#8		0.1990	4 3/4	4 3/4
1060532		#7		0.2010		
1060549	13/64			0.2031	4 3/4	4 3/4
1060555		#6		0.2040		
1060561		#5		0.2055	4 3/4	4 3/4
1060578		#4		0.2090		
1060584		#3		0.2130	4 3/4	4 3/4
1060590	7/32			0.2188		

EDP	Size			Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire	Letter			
1060606		#2		0.2210	2 5/8	3 7/8
1060612		#1		0.2280		
1054054			A	0.2340	2 3/4	4
1060629	15/64			0.2344		
1054077			B	0.2380	2 3/4	4
1054083			C	0.2420		
1054090			D	0.2460	2 7/8	4 1/8
1060635	1/4			0.2500		
1054111			E	0.2500	2 7/8	4 1/8
1054128			F	0.2570		
1054134			G	0.2610	2 15/16	4 1/4
1060641	17/64			0.2656		
1054157			H	0.2660	3 1/16	4 3/8
1054163			I	0.2720		
1054170			J	0.2770	3 3/16	4 1/2
1054186			K	0.2810		
1060658	9/32			0.2813	3 5/16	4 5/8
1054208			L	0.2900		
1054214			M	0.2950	3 7/16	4 3/4
1060664	19/64			0.2969		
1054237			N	0.3020	3 7/16	4 3/4
1060670	5/16			0.3125		
1054250			O	0.3160	3 1/2	4 7/8
1054266			P	0.3230		
1060687	21/64			0.3281	3 1/2	4 7/8
1054289			Q	0.3320		
1054295			R	0.3390	3 1/2	4 7/8
1060693	11/32			0.3438		
1054317			S	0.3480	3 1/2	4 7/8
1054323			T	0.3580		
1060709	23/64			0.3594	3 5/8	5
1054346			U	0.3680		
1060715	3/8			0.3750	3 3/4	5 1/8
1054369			V	0.3770		
1054375			W	0.3860	3 3/4	5 1/8
1060721	25/64			0.3906		
1054398			X	0.3970	3 7/8	5 1/4
1054403			Y	0.4040		
1060738	13/32			0.4063	3 15/16	5 3/8
1054426			Z	0.4130		
1060744	27/64			0.4219	4 1/16	5 1/2
1060750	7/16			0.4375		
1060767	29/64			0.4531	4 3/16	5 5/8
1060773	15/32			0.4688		
1060780	31/64			0.4844	4 3/8	5 7/8
1060796	1/2			0.5000		

Fractional sizes: Sizes 1/64 to 5/16 in package of 10; 21/64 to 1/2 in package of 5; 33/64 to 11/16 in package of 2
 Wire gauge sizes: All sizes in package of 10
 Letter sizes: A to N in package of 10; O to Z in package of 5

STRAIGHT SHANK JOBBER LENGTH TIN COATED

List No. 501P General Purpose



Fractional: Range 1/16" to 1/2"
Wire: Range #1 to #52

EDP	Size		Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire			
1047548	1/16		0.0625	7/8	1 7/8
1001039		#52	0.0635		
1001068		#51	0.0670	1	2
1001102		#50	0.0700		
1001125		#49	0.0730		
1001131		#48	0.0760		
1143985	5/64		0.0781		
1001154		#47	0.0785		
1001160		#46	0.0810	1 1/8	2 1/8
1001177		#45	0.0820		
1001190		#44	0.0860		
1001205		#43	0.0890	1 1/4	2 1/4
1001211		#42	0.0935		
1226503	3/32		0.0938	1 3/8	2 3/8
1001234		#41	0.0960		
1001240		#40	0.0980		
1001270		#39	0.0995		
1001308		#38	0.1015	1 7/16	2 1/2
1001337		#37	0.1040		
1001395		#36	0.1065	1 1/2	2 5/8
1141626	7/64		0.1094		
1001475		#35	0.1100		
1001481		#34	0.1110		
1001498		#33	0.1130		
1001503		#32	0.1160		
1001510		#31	0.1200	1 5/8	2 3/4
1144006	1/8		0.1250		
1001532		#30	0.1285		
1001549		#29	0.1360	1 3/4	2 7/8
1001584		#28	0.1405		
1143991	9/64		0.1406	1 7/8	3
1001606		#27	0.1440		
1001612		#26	0.1470		
1001635		#25	0.1495		
1001693		#24	0.1520	2	3 1/8
1001744		#23	0.1540		
1141598	5/32		0.1563		
1001933		#22	0.1570		
1001956		#21	0.1590	2 1/8	3 1/4
1002012		#20	0.1610		
1002167		#19	0.1660		

EDP	Size		Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire			
1002173		#18	0.1695	2 1/8	3 1/4
1226510	11/64		0.1719		
1002260		#17	0.1730	2 3/16	3 3/8
1002247		#16	0.1770		
1002310		#15	0.1800		
1002385		#14	0.1820		
1002420		#13	0.1850	2 5/16	3 1/2
1226526	3/16		0.1875		
1002734		#12	0.1890		
1002770		#11	0.1910	2 7/16	3 5/8
1002814		#10	0.1935		
1002837		#9	0.1960		
1002889		#8	0.1990		
1002952		#7	0.2010		
1174858	13/64		0.2031		
1002998		#6	0.2040	2 1/2	3 3/4
1003186		#5	0.2055		
1003192		#4	0.2090		
1003208		#3	0.2130		
1226532	7/32		0.2188	2 5/8	3 7/8
1003237		#2	0.2210		
1003300		#1	0.2280		
1141632	15/64		0.2344	2 3/4	4
1226549	1/4		0.2500		
1141603	17/64		0.2656	2 7/8	4 1/8
1144029	9/32		0.2813	2 15/16	4 1/4
1141610	19/64		0.2969	3 1/16	4 3/8
1141649	5/16		0.3125	3 3/16	4 1/2
1086513	21/64		0.3281	3 5/16	4 5/8
1086520	11/32		0.3438	3 7/16	4 3/4
1086536	23/64		0.3594	3 1/2	4 7/8
1086542	3/8		0.3750	3 5/8	5
1086559	25/64		0.3906	3 3/4	5 1/8
1086565	13/32		0.4063	3 7/8	5 1/4
1086571	27/64		0.4219	3 15/16	5 3/8
1086588	7/16		0.4375	4 1/16	5 1/2
1086594	29/64		0.4531	4 3/16	5 5/8
1086600	15/32		0.4688	4 5/16	5 3/4
1086616	31/64		0.4844	4 3/8	5 7/8
1086622	1/2		0.5000	4 1/2	6

Fractional sizes: Sizes 1/64 to 5/16 in package of 10; 21/64 to 1/2 in package of 5; 33/64 to 11/16 in package of 2
Wire gauge sizes: All sizes in package of 10

STRAIGHT SHANK JOBBER LENGTH PARABOLIC

List No. 517P Tin Coated



Fractional: Range 1/16" to 1/2"
Wire: Range #1 to #52

EDP	Size		Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire			
1019026	1/16		0.0625	7/8	1 7/8
1019055		#52	0.0635		
1019158		#51	0.0670		
1019318		#50	0.0700		
1019330		#49	0.0730	1	2
1019382		#48	0.0760		
1019399	5/64		0.0781		
1019427		#47	0.0785		
1019440		#46	0.0810		
1019462		#45	0.0820	1 1/8	2 1/8
1019559		#44	0.0860		
1019645		#43	0.0890		
1019748		#42	0.0935	1 1/4	2 1/4
1019783	3/32		0.0938		
1019840		#41	0.0960		
1019870		#40	0.0980	1 3/8	2 3/8
1020015		#39	0.0995		
1020118		#38	0.1015		
1020153		#37	0.1040	1 7/16	2 1/2
1020233		#36	0.1065		
1020279	7/64		0.1094		
1020394		#35	0.1100	1 1/2	2 5/8
1020451		#34	0.1110		
1020474		#33	0.1130		
1020497		#32	0.1160		
1020519		#31	0.1200	1 5/8	2 3/4
1020531	1/8		0.1250		
1020554		#30	0.1285		
1020577		#29	0.1360		
1020590		#28	0.1405	1 3/4	2 7/8
1020605	9/64		0.1406		
1020628		#27	0.1440		
1020640		#26	0.1470	1 7/8	3
1020686		#25	0.1495		
1020714		#24	0.1520		
1020737		#23	0.1540	2	3 1/8
1020750	5/32		0.1563		
1020817		#22	0.1570		
1020852		#21	0.1590		
1020881		#20	0.1610	2 1/8	3 1/4
1020932		#19	0.1660		

EDP	Size		Decimal Equivalent	Flute Length	Overall Length
	Fractional	Wire			
1020990		#18	0.1695	2 1/8	3 1/4
1021057		#16	0.1700	2 3/16	3 3/8
1021028	11/64		0.1719	2 1/8	3 1/4
1021166		#17	0.1730		
1021217		#15	0.1800	2 3/16	3 3/8
1021246		#14	0.1820		
1021275		#13	0.1850		
1021281	3/16		0.1875	2 5/16	3 1/2
1021310		#12	0.1890		
1021384		#11	0.1910		
1021515		#10	0.1935		
1021544		#9	0.1960		
1021596		#8	0.1990	2 7/16	3 5/8
1021630		#7	0.2010		
1021647	13/64		0.2031		
1021660		#6	0.2040		
1021682		#5	0.2055		
1021704		#4	0.2090	2 1/2	3 3/4
1021727		#3	0.2130		
1021733	7/32		0.2188		
1021779		#2	0.2210		
1021820		#1	0.2280	2 5/8	3 7/8
1021836	15/64		0.2344		
1021842	1/4		0.2500	2 3/4	4
1021871	17/64		0.2656	2 7/8	4 1/8
1021888	9/32		0.2813	2 15/16	4 1/4
1021894	19/64		0.2969	3 1/16	4 3/8
1021900	5/16		0.3125	3 3/16	4 1/2
1021922	21/64		0.3281	3 5/16	4 5/8
1021939	11/32		0.3438	3 7/16	4 3/4
1021951	23/64		0.3594	3 1/2	4 7/8
1021968	3/8		0.3750	3 5/8	5
1021974	25/64		0.3906	3 3/4	5 1/8
1021997	13/32		0.4063	3 7/8	5 1/4
1022001	27/64		0.4219	3 15/16	5 3/8
1022018	7/16		0.4375	4 1/16	5 1/2
1022024	29/64		0.4531	4 3/16	5 5/8
1022030	15/32		0.4688	4 5/16	5 3/4
1022047	31/64		0.4844	4 3/8	5 7/8
1022053	1/2		0.5000	4 1/2	6

Fractional sizes: Sizes 1/64 to 5/16 in package of 10; 21/64 to 1/2 in package of 5; 33/64 to 11/16 in package of 2
Wire gauge sizes: All sizes in package of 10

STRAIGHT SHANK TAPER LENGTH / TAPER LENGTH COBALT

List No. 531 General Purpose



Range 1/64" to 1/2"

EDP	Size	Decimal Equivalent	Flute Length	Overall Length
1278436	1/64	0.0156	5/16	1 1/2
1266264	1/32	0.0313	3/4	2
1266270	3/64	0.0469	1 1/8	2 1/4
1266287	1/16	0.0625	1 3/4	3
1266293	5/64	0.0781	2	3 3/4
1266309	3/32	0.0938	2 1/4	4 1/4
1266315	7/64	0.1094	2 1/2	4 5/8
1266321	1/8	0.1250	2 3/4	5 1/8
1266338	9/64	0.1406	3	5 3/8
1266344	5/32	0.1563	3 3/8	5 3/4
1266350	11/64	0.1719	3 5/8	6
1266367	3/16	0.1875	3 5/8	6
1266373	13/64	0.2031	3 5/8	6
1266380	7/32	0.2188	3 3/4	6 1/8
1266396	15/64	0.2344	3 3/4	6 1/8
1266401	1/4	0.2500	3 7/8	6 1/4
1266418	17/64	0.2656	3 7/8	6 1/4
1266424	9/32	0.2813	4	6 3/8
1266430	19/64	0.2969	4	6 3/8
1266447	5/16	0.3125	4 1/8	6 1/2
1266453	21/64	0.3281	4 1/8	6 1/2
1266460	11/32	0.3438	4 1/4	6 3/4
1266476	23/64	0.3594	4 1/4	6 3/4
1266482	3/8	0.3750	4 3/8	7
1266499	25/64	0.3906	4 3/8	7
1266504	13/32	0.4063	4 5/8	7 1/4
12665102	7/64	0.4219	4 5/8	7 1/4
1266527	7/16	0.4375	4 3/4	7 1/2
1266533	29/64	0.4531	4 3/4	7 1/2
1266540	15/32	0.4688	4 3/4	7 3/4
1266556	31/64	0.4844	4 3/4	7 3/4
1266562	1/2	0.5000	4 3/4	7 3/4

Sizes 1/64 to 5/16 in package of 10; 21/64 to 1/2 in package of 5

List No. 6531 General Purpose - Cobalt



Range 1/16" to 3/4"

EDP	Size	Decimal Equivalent	Flute Length	Overall Length
1053917	1/16	0.0625	1 3/4	3
1053930	5/64	0.0781	2	3 3/4
1053952	3/32	0.0938	2 1/4	4 1/4
1053975	7/64	0.1094	2 1/2	4 5/8
1053981	1/8	0.1250	2 3/4	5 1/8
1053998	9/64	0.1406	3	5 3/8
1054002	5/32	0.1563	3 3/8	5 3/4
1054019	11/64	0.1719	3 3/8	5 3/4
1054025	3/16	0.1875	3 5/8	6
1054031	13/64	0.2031	3 5/8	6
1054048	7/32	0.2188	3 3/4	6 1/8
1054060	15/64	0.2344	3 3/4	6 1/8
1054105	1/4	0.2500	3 7/8	6 1/4
1054140	17/64	0.2656	3 7/8	6 1/4
1054192	9/32	0.2813	4	6 3/8
1054220	19/64	0.2969	4	6 3/8
1054243	5/16	0.3125	4 1/8	6 1/2
1054272	21/64	0.3281	4 1/8	6 1/2
1054300	11/32	0.3438	4 1/4	6 3/4
1054330	23/64	0.3594	4 1/4	6 3/4
1054352	3/8	0.3750	4 3/8	7
1054381	25/64	0.3906	4 3/8	7
1054410	13/32	0.4063	4 5/8	7 1/4
1054432	27/64	0.4219	4 5/8	7 1/4
1054449	7/16	0.4375	4 3/4	7 1/2
1054455	29/64	0.4531	4 3/4	7 1/2
1054461	15/32	0.4688	4 3/4	7 3/4
1054478	31/64	0.4844	4 3/4	7 3/4
1054484	1/2	0.5000	4 3/4	7 3/4
1058198	33/64	0.5156	4 3/4	8
1058261	17/32	0.5313	4 7/8	8 1/4
1058312	35/64	0.5469	4 7/8	8 1/4
1058387	9/16	0.5625	4 7/8	8 3/4
1058450	37/64	0.5781	4 7/8	8 3/4
1058524	19/32	0.5938	4 7/8	8 3/4
1058582	39/64	0.6094	4 7/8	8 3/4
1058656	5/8	0.6250	5 1/8	9
1058713	41/64	0.6406	5 1/8	9
1058765	21/32	0.6563	5 1/8	9
1058822	43/64	0.6719	5 3/8	9 1/4
1058874	11/16	0.6875	5 3/8	9 1/4
1058925	45/64	0.7031	5 5/8	9 1/2
1058954	23/32	0.7188	5 5/8	9 1/2
1058990	47/64	0.7344	5 5/8	9 1/2
1059027	3/4	0.7500	5 7/8	9 3/4

⚠ WARNING: Cancer - www.P65Warnings.ca.gov

Sizes 1/64 to 5/16 in package of 10; 21/64 to 1/2 in package of 5

STRAIGHT SHANK TAPER LENGTH TIN COATED

List No. 545P Parabolic Style



Range: 1/16" to 1/2"

EDP	Size	Decimal Equivalent	Flute Length	Overall Length
1001016	1/16	0.0625	1 3/4	3
1001148	5/64	0.0781	2	3 3/4
1001228	3/32	0.0938	2 1/4	4 1/4
1001446	7/64	0.1094	2 1/2	4 5/8
1001526	1/8	0.1250	2 3/4	5 1/8
1001590	9/64	0.1406	3	5 3/8
1001899	5/32	0.1563		
1002218	11/64	0.1719	3 3/8	5 3/4
1002436	3/16	0.1875		
1002975	13/64	0.2031	3 5/8	6
1003214	7/32	0.2188		
1003403	15/64	0.2344	3 3/4	6 1/8
1003455	1/4	0.2500		
1003541	17/64	0.2656	3 7/8	6 1/4
1003609	9/32	0.2813		
1003615	19/64	0.2969	4	6 3/8
1003621	5/16	0.3125		
1003667	21/64	0.3281	4 1/8	6 1/2
1003673	11/32	0.3438		
1003885	23/64	0.3594	4 1/4	6 3/4
1003920	3/8	0.3750		
1003936	25/64	0.3906	4 3/8	7
1004038	13/32	0.4063		
1004130	27/64	0.4219	4 5/8	7 1/4
1004176	7/16	0.4375		
1004199	29/64	0.4531	4 3/4	7 1/2
1004256	15/32	0.4688		
1004285	31/64	0.4844		
1004291	1/2	0.5000		7 3/4

Sizes 1/64 to 5/16 in package of 10; 21/64 to 1/2 in package of 5

STRAIGHT SHANK DRILL EXTRA LENGTH

List No. 551 General Purpose



Range 1/8" to 1"
Overall Length 12" and 18"

EDP	Size	Decimal Equivalent	Flute Length	Overall Length
1054490	1/8	0.1250	9	12
1054506	9/64	0.1406		
1054512	5/32	0.1563		
1054529	11/64	0.1719		
1054535	3/16	0.1875		
1054558	13/64	0.2031		
1054570	7/32	0.2188		
1054593	15/64	0.2344		
1054615	1/4	0.2500		
1054638	17/64	0.2656		
1054650	9/32	0.2813		
1054673	19/64	0.2969		
1054696	5/16	0.3125		
1054718	21/64	0.3281		
1054730	11/32	0.3438		
1054753	23/64	0.3594		
1054776	3/8	0.3750		
1054799	25/64	0.3906		
1054810	13/32	0.4063		
1054833	27/64	0.4219		
1054856	7/16	0.4375		
1054879	29/64	0.4531		
1054891	15/32	0.4688		
1054913	31/64	0.4844		
1054936	1/2	0.5000		
1058226	33/64	0.5156		
1058290	17/32	0.5313		
1058341	35/64	0.5469		
1058415	9/16	0.5625		
1058480	37/64	0.5781		
1058553	19/32	0.5938		
1058610	39/64	0.6094		
1058685	5/8	0.6250		
1058800	21/32	0.6563		
1058902	11/16	0.6875		
1058977	23/32	0.7188		
1059040	3/4	0.7500		
1059120	13/16	0.8125		
1059200	7/8	0.8750		
1059280	15/16	0.9375		
1059354	1	1.0000		

EDP	Size	Decimal Equivalent	Flute Length	Overall Length
1054541	3/16	0.1875	14	18
1054564	13/64	0.2031		
1054587	7/32	0.2188		
1054609	15/64	0.2344		
1054621	1/4	0.2500		
1054644	17/64	0.2656		
1054667	9/32	0.2813		
1054680	19/64	0.2969		
1054701	5/16	0.3125		
1054724	21/64	0.3281		
1054747	11/32	0.3438		
1054760	23/64	0.3594		
1054782	3/8	0.3750		
1054804	25/64	0.3906		
1054827	13/32	0.4063		
1054840	27/64	0.4219		
1054862	7/16	0.4375		
1054885	29/64	0.4531		
1054907	15/32	0.4688		
1054920	31/64	0.4844		
1054942	1/2	0.5000		
1058210	33/64	0.5156		
1058284	17/32	0.5313		
1058335	35/64	0.5469		
1058409	9/16	0.5625		
1058473	37/64	0.5781		
1058547	19/32	0.5938		
1058604	39/64	0.6094		
1058679	5/8	0.6250		
1058788	21/32	0.6563		
1058897	11/16	0.6875		
1058960	23/32	0.7188		
1059033	3/4	0.7500		
1059113	13/16	0.8125		
1059194	7/8	0.8750		
1059274	15/16	0.9375		
1059348	1	1.0000		

1 per box

STRAIGHT SHANK DRILL EXTRA LENGTH PARABOLIC

List No. 6551 Cobalt - Black Oxide



Range 3/16 to 1/2
Overall Length 10"

EDP	Size	Decimal Equivalent	Flute Length	Overall Length
1010087	3/16	0.1875	7	10
1010109	13/64	0.2031		
1010150	7/32	0.2188		
1010173	15/64	0.2344		
1010196	1/4	0.2500		
1005275	17/64	0.2656		
1005281	9/32	0.2813		
1005298	19/64	0.2969		
1005303	5/16	0.3125		
1005310	21/64	0.3281		
1005326	11/32	0.3438		
1005332	23/64	0.3594		
1005349	3/8	0.3750		
1010333	25/64	0.3906		
1010362	13/32	0.4063		
1010391	27/64	0.4219		
1005390	7/16	0.4375		
1005406	29/64	0.4531		
1010465	15/32	0.4688		
1005435	31/64	0.4844		
1008040	1/2	0.5000		

1 per box

WARNING: Cancer - www.P65Warnings.ca.gov

STRAIGHT SHANK DRILL OIL HOLE

List No. 581 M35 Cobalt



Range 3/8 to 1 1/2

EDP	Size	Decimal Equivalent	Flute Length	Overall Length
1056974	3/8	0.3750	4 1/4	6 3/4
1056997	25/64	0.3906	4 3/8	7
1057018	13/32	0.4063		
1057030	27/64	0.4219	4 5/8	7 1/4
1061093	7/16	0.4375		
1057060	29/64	0.4531	4 7/8	7 1/2
1061109	15/32	0.4688		
1057099	31/64	0.4844	5	7 3/4
1057110	1/2	0.5000		
1057133	33/64	0.5156	5 1/4	8
1057156	17/32	0.5313		
1057179	35/64	0.5469	5 3/8	8 1/4
1057191	9/16	0.5625		
1057213	37/64	0.5781	5 5/8	8 1/2
1057236	19/32	0.5938		
1057259	39/64	0.6094	5 3/4	8 3/4
1057271	5/8	0.6250		
1146307	41/64	0.6406	5 7/8	9
1057316	21/32	0.6563		
1057339	43/64	0.6719	6	9 1/4
1057351	11/16	0.6875		
1057374	45/64	0.7031	6 3/16	9 1/2
1057397	23/32	0.7188		
1057419	47/64	0.7344	6 3/8	9 3/4
1061115	3/4	0.7500		
1057448	49/64	0.7656	6 1/2	9 7/8
1057460	25/32	0.7813		
1057483	51/64	0.7969	6 5/8	10

EDP	Size	Decimal Equivalent	Flute Length	Overall Length
1057505	13/16	0.8125	6 5/8	10
1057528	53/64	0.8281		
1057540	27/32	0.8438	6 3/4	10 1/4
1057563	55/64	0.8594		
1061121	7/8	0.8750		
1057592	57/64	0.8906	7	10 1/2
1057614	29/32	0.9063		
1057637	59/64	0.9219		
1057650	15/16	0.9375		
1057672	61/64	0.9531	7 1/8	10 7/8
1057695	31/32	0.9688		
1057717	63/64	0.9844	7 3/16	11
1057730	1	1.0000		
1057752	1 1/64	1.0156	7 5/16	11 1/8
1057769	1 1/32	1.0313		
1057775	1 3/64	1.0469	7 3/8	11 1/4
1057781	1 1/16	1.0625		
1057803	1 3/32	1.0938	7 5/8	11 1/2
1057810	1 1/8	1.1250	7 7/8	11 3/4
1057832	1 5/32	1.1563	8	11 7/8
1057849	1 3/16	1.1875	8 1/8	12
1057861	1 7/32	1.2188		
1057878	1 1/4	1.2500	8 1/2	12 1/2
1057890	1 5/16	1.3125	9 1/4	14 1/4
1057912	1 3/8	1.3750	9 1/2	14 1/2
1057935	1 7/16	1.4375	9 5/8	14 3/4
1057958	1 1/2	1.5000	9 7/8	15

1 per box

⚠ WARNING: Cancer - www.P65Warnings.ca.gov

TAPER SHANK DRILL REGULAR LENGTH

List No. 601 General Purpose



Range 9/32" to 3 1/2"

EDP	Size	Decimal Equivalent	Flute Length	Overall Length	Taper Shank
1267305	9/32	0.2813	3	6 1/4	1
1267328	19/64	0.2969	3 1/8	6 3/8	
1267357	5/16	0.3125			
1267363	21/64	0.3281	3 1/4	6 1/2	
1267370	11/32	0.3438	3 1/2	6 3/4	
1267386	23/64	0.3594			
1267392	3/8	0.3750	3 5/8	7	
1267408	25/64	0.3906			
1267414	13/32	0.4063	3 7/8	7 1/4	
1268221	27/64	0.4219			
1268238	7/16	0.4375	4 1/8	7 1/2	
1268250	29/64	0.4531			
1268296	15/32	0.4688	4 3/8	8 1/4	
1268318	31/64	0.4844			
1268330	1/2	0.5000	4 5/8	8 1/2	
1268353	33/64	0.5156			
1268376	17/32	0.5313	4 7/8	8 3/4	
1268399	35/64	0.5469			
1268410	9/16	0.5625	5 1/8	9	
1268433	37/64	0.5781			
1268456	19/32	0.5938	5 3/8	9 1/4	
1268479	39/64	0.6094			
1268507	5/8	0.6250	5 5/8	9 1/2	
1268513	41/64	0.6406			
1268536	21/32	0.6563	5 7/8	9 3/4	
1268565	43/64	0.6719			
1268588	11/16	0.6875	6	9 7/8	
1268600	45/64	0.7031			
1268639	23/32	0.7188	6 1/8	10 3/4	
1268668	47/64	0.7344			
1268680	3/4	0.7500	6 3/8	11	
1268702	49/64	0.7656			
1268725	25/32	0.7813	6 5/8	11	
1268886	51/64	0.7969			
1268892	13/16	0.8125	6 3/4	11 1/4	
1268908	53/64	0.8281			
1268914	27/32	0.8438	6 1/2	11 1/2	
1268920	55/64	0.8594			
1268943	7/8	0.8750	6 3/4	11 3/4	
1268972	57/64	0.8906			
1268995	29/32	0.9063	6 1/2	11 3/4	
1269022	59/64	0.9219			
1269051	15/16	0.9375	6 3/4	11 3/4	
1269080	61/64	0.9531			

EDP	Size	Decimal Equivalent	Flute Length	Overall Length	Taper Shank
1269097	31/32	0.9688	6 3/8	11	3
1269125	63/64	0.9844			
1269160	1	1.0000	6 1/2	11 1/8	
1269205	1 1/64	1.0156			
1269234	1 1/32	1.0313	6 5/8	11 1/4	
1269240	1 3/64	1.0469			
1269263	1 1/16	1.0625	6 7/8	12 1/2	
1269286	1 5/64	1.0781			
1269314	1 3/32	1.0938	7 1/8	12 3/4	
1269337	1 7/64	1.1094			
1269366	1 1/8	1.1250	7 1/4	12 7/8	
1269400	1 9/64	1.1406			
1269430	1 5/32	1.1563	7 3/8	13	
1269469	1 11/64	1.1719			
1269498	1 3/16	1.1875	7 1/2	13 1/8	
1269526	1 13/64	1.2031			
1269664	1 7/32	1.2188	7 7/8	13 1/2	
1269709	1 15/64	1.2344			
1269773	1 1/4	1.2500	8 1/2	14 1/8	
1269830	1 17/64	1.2656			
1269899	1 9/32	1.2813	8 5/8	14 1/4	
1269910	1 19/64	1.2969			
1269927	1 5/16	1.3125	8 3/4	14 3/8	
1269933	1 21/64	1.3281			
1269940	1 11/32	1.3438	8 7/8	14 1/2	
1269956	1 23/64	1.3594			
1269962	1 3/8	1.3750	9	14 5/8	
1269979	1 25/64	1.3906			
1269985	1 13/32	1.4063	9 1/8	14 3/4	
1269991	1 27/64	1.4219			
1270005	1 7/16	1.4375	9 1/4	14 7/8	
1270011	1 29/64	1.4531			
1270028	1 15/32	1.4688	9 3/8	15	
1270034	1 31/64	1.4844			
1270040	1 1/2	1.5000	9 5/8	15 5/8	
1270057	1 33/64	1.5156			
1270063	1 17/32	1.5313	9 7/8	16 7/8	
1270070	1 35/64	1.5469			
1270086	1 9/16	1.5625	10	17	
1270092	1 37/64	1.5781			
1270108	1 19/32	1.5938	10 1/8	17 1/8	
1270114	1 39/64	1.6094			
1270120	1 5/8	1.6250	10 1/8	17 1/8	
1270126	1 11/16	1.6406			

EDP	Size	Decimal Equivalent	Flute Length	Overall Length	Taper Shank
1270269	1 21/32	1.6563	10 1/8	17 1/8	5
1270275	1 43/64	1.6719			
1270281	1 11/16	1.6875	10 3/8	17 3/8	
1270298	1 45/64	1.7031			
1270303	1 23/32	1.7188	10 1/4	18 3/4	
1270332	1 47/64	1.7344			
1270361	1 3/4	1.7500	10 1/8	19 1/2	
1270390	1 25/32	1.7813			
1270429	1 13/16	1.8125	11 1/4	20 3/8	
1270458	1 27/32	1.8438			
1270487	1 7/8	1.8750	11 7/8	21 1/8	
1270515	1 29/32	1.9063			
1270630	1 15/16	1.9375	12 3/4	21 3/4	
1270660	1 31/32	1.9688			
1270699	2	2.0000	13 3/8	22 1/8	
1270727	2 1/32	2.0313			
1270762	2 1/16	2.0625	14 1/8	23 1/8	
1270785	2 3/32	2.0938			
1270807	2 1/8	2.1250	14 3/8	24 1/2	
1270836	2 5/32	2.1563			
1270859	2 3/16	2.1875	15 1/2	25 1/2	
1270865	2 7/32	2.2188			
1270871	2 1/4	2.2500	16 3/8	26 1/2	
1270888	2 5/16	2.3125			
1270894	2 3/8	2.3750	16 3/8	26 1/2	
1270900	2 7/16	2.4375			
1270916	2 1/2	2.5000	17 1/8	27 1/8	
1270922	2 9/16	2.5625			
1270939	2 5/8	2.6250	17 3/8	27 3/8	
1270945	2 11/16	2.6875			
1270951	2 3/4	2.7500	18 1/8	28 1/8	
1270968	2 13/16	2.8125			
1270974	2 7/8	2.8750	18 3/8	28 3/8	
1270980	2 15/16	2.9375			
1270997	3	3.0000	19 1/8	29 1/8	
1271001	3 1/16	3.0625			
1271018	3 1/8	3.1250	19 3/8	29 3/8	
1271024	3 3/16	3.1875			
1271030	3 1/4	3.2500	20 1/8	30 1/8	
1271047	3 5/16	3.3125			
1271076	3 3/8	3.3750	20 3/8	30 3/8	
1271127	3 7/16	3.4375			
1271179	3 1/2	3.5000	21 1/8	31 1/8	

1 per box

TAPER SHANK DRILL EXTRA LENGTH

List No. 651



Range 1/4 to 2 1/2
Overall Length 18"

EDP	Size	Decimal Equivalent	Flute Length	Overall Length	Overall Length	Taper Shank
1057970	1/4	0.2500				1
1057987	17/64	0.2656				
1057993	9/32	0.2813	14	18		
1058008	19/64	0.2969				
1058014	5/16	0.3125				
1058020	5/16	0.3125	20		24	
1058037	21/64	0.3281				
1058043	11/32	0.3438				
1058050	23/64	0.3594	14	18		
1058066	3/8	0.3750				
1058072	3/8	0.3750	20		24	
1058089	25/64	0.3906				
1058095	13/32	0.4063				
1058100	27/64	0.4219	14	18		
1058117	7/16	0.4375				
1058123	7/16	0.4375	20		24	
1058130	29/64	0.4531				
1058146	15/32	0.4688				
1058152	31/64	0.4844	14	18		
1058169	1/2	0.5000				
1058175	1/2	0.5000	20		24	
1058181	33/64	0.5156	14	18		
1061138	33/64	0.5156	20		24	
1058249	17/32	0.5313	14	18		
1058255	17/32	0.5313	20		24	
1061144	35/64	0.5469	14	18		
1058364	9/16	0.5625	14	18		
1058370	9/16	0.5625	20		24	
1058438	37/64	0.5781	14	18		
1058444	37/64	0.5781	20		24	
1058501	19/32	0.5938	14	18		
1058518	19/32	0.5938	20		24	
1058576	39/64	0.6094				
1058633	5/8	0.6250	14	18		
1058640	5/8	0.6250	20		24	
1058707	41/64	0.6406				
1058742	21/32	0.6563	14	18		
1058759	21/32	0.6563	20		24	
1058816	43/64	0.6719				
1058851	11/16	0.6875	14	18		
1058868	11/16	0.6875	20		24	
1058919	45/64	0.7031				
1058931	23/32	0.7188	14	18		
1058948	23/32	0.7188	20		24	
1058983	47/64	0.7344				
1059004	3/4	0.7500	14	18		
1059010	3/4	0.7500	20		24	
1059056	49/64	0.7656				
1059062	25/32	0.7813	14	18		
1059079	25/32	0.7813	20		24	
1059085	51/64	0.7969				
1059091	13/16	0.8125	13	18		
1059107	13/16	0.8125	19		24	
1059136	53/64	0.8281				
1059142	27/32	0.8438	13	18		
1059159	27/32	0.8438	19		24	
1059165	55/64	0.8594	13	18		

EDP	Size	Decimal Equivalent	Flute Length	Overall Length	Overall Length	Taper Shank
1059171	7/8	0.8750	13	18		3
1059188	7/8	0.8750	19		24	
1059216	57/64	0.8906	13	18		
1059222	29/32	0.9063	13			
1059239	29/32	0.9063	19		24	
1059245	59/64	0.9219	13	18		
1059251	15/16	0.9375	13			
1059268	15/16	0.9375	19		24	
1059297	61/64	0.9531	13	18		
1059302	31/32	0.9688	13			
1059319	31/32	0.9688	19		24	
1059325	63/64	0.9844	13	18		
1061167	1	1.0000	13			
1059331	1	1.0000	19		24	
1059360	1 1/32	1.0313	13	18		
1059377	1 1/16	1.0625	13			
1059383	1 1/16	1.0625	19		24	
1059390	1 3/32	1.0938	12	18		
1059405	1 1/8	1.1250	12			
1059411	1 1/8	1.1250	19		24	
1059428	1 5/32	1.1563	12	18		
1229743	1 5/32	1.1563	18		24	
1059434	1 3/16	1.1875	12	18		
1059440	1 3/16	1.1875	18		24	
1059457	1 7/32	1.2188	12	18		
1229750	1 7/32	1.2188	18		24	
1059463	1 1/4	1.2500	12	18		
1059470	1 1/4	1.2500	18		24	
1059486	1 9/32	1.2813	12	18		
1059492	1 5/16	1.3125	12			
1059508	1 5/16	1.3125	18		24	
1059514	1 11/32	1.3438	12	18		
1059520	1 3/8	1.3750	12			
1059537	1 3/8	1.3750	18		24	
1059543	1 13/32	1.4063	12	18		
1059550	1 7/16	1.4375	12			
1059566	1 7/16	1.4375	18		24	
1059572	1 15/32	1.4688	12	18		
1059589	1 1/2	1.5000	12			
1059595	1 1/2	1.5000	18		24	
1059600	1 9/16	1.5625	10 1/2	18		
1059617	1 9/16	1.5625	17		24	
1059623	1 5/8	1.6250	10 1/2	18		
1059630	1 5/8	1.6250	17		24	
1059646	1 11/16	1.6875	10 1/2	18		
1059652	1 11/16	1.6875	17		24	
1059669	1 3/4	1.7500	10 1/2	18		
1059675	1 3/4	1.7500	17		24	
1059681	1 7/8	1.8750	10 1/2	18		
1059698	1 7/8	1.8750	17		24	
1059703	2	2.0000	10 1/2	18		
1061173	2	2.0000	17		24	
1059726	2 1/16	2.0625	17			
1059749	2 1/8	2.1250	17			
1059761	2 1/4	2.2500	17	24		
1159848	2 3/8	2.3750	17		5	
1059784	2 1/2	2.5000	17			

1 per box

TAPER SHANK DRILL OIL HOLE

List No. 683 M35 Cobalt



Range 3/8 to 1 1/2

EDP	Size	Decimal Equivalent	Flute Length	Overall Length	Taper Shank	
1056980	3/8	0.3750	4 1/4	8 1/8	2	
1057001	25/64	0.3906	4 3/8	8 1/4		
1057024	13/32	0.4063	4 5/8	8 1/2		
1057047	27/64	0.4219				
1057053	7/16	0.4375	4 7/8	8 3/4		
1057076	29/64	0.4531				
1057082	15/32	0.4688	5	9 5/8		
1057104	31/64	0.4844				
1057127	1/2	0.5000				
1057140	33/64	0.5156			5 1/8	9 3/4
1057162	17/32	0.5313				
1057185	35/64	0.5469			5 1/4	9 7/8
1057207	9/16	0.5625				
1057220	37/64	0.5781			5 1/2	10 1/8
1057242	19/32	0.5938				
1057265	39/64	0.6094			5 5/8	10 1/4
1057288	5/8	0.6250				
1057300	41/64	0.6406	5 3/4	10 3/8		
1057322	21/32	0.6563				
1057345	43/64	0.6719	5 7/8	10 1/2		
1057368	11/16	0.6875				
1057380	45/64	0.7031	6 1/8	10 3/4		
1057402	23/32	0.7188				
1057425	47/64	0.7344	6 1/4	10 7/8		
1057431	3/4	0.7500				

EDP	Size	Decimal Equivalent	Flute Length	Overall Length	Taper Shank	
1057454	49/64	0.7656	6 3/8	11	3	
1057477	25/32	0.7813				
1057490	51/64	0.7969	6 1/2	11 1/8		
1057511	13/16	0.8125				
1057534	53/64	0.8281	6 5/8	11 1/4		
1057557	27/32	0.8438				
1057570	55/64	0.8594	6 7/8	11 1/2		
1057586	7/8	0.8750				
1057608	57/64	0.8906				
1057620	29/32	0.9063				
1057643	59/64	0.9219				
1057666	15/16	0.9375				
1057689	61/64	0.9531			7	11 5/8
1057700	31/32	0.9688				
1057723	63/64	0.9844			7 1/8	11 3/4
1057746	1	1.0000				
1057798	1 1/16	1.0625	7 1/4	12 7/8	4	
1057826	1 1/8	1.1250	7 3/4	13 3/8		
1057855	1 3/16	1.1875	8	13 5/8		
1057884	1 1/4	1.2500	8 1/4	13 7/8		
1057906	1 5/16	1.3125	9 1/8	14 3/4		
1057929	1 3/8	1.3750	9 3/8	15		
1057941	1 7/16	1.4375	9 1/2	15 1/8		
1057964	1 1/2	1.5000	9 3/4	15 3/8		

1 per box

⚠ WARNING: Cancer - www.P65Warnings.ca.gov

SILVER AND DEMING DRILL

List No. 575



Shank Diameter 1/2" by 2 1/2" long
Range 1/2 to 1 1/2

EDP	Size	Decimal Equivalent	Flute Length	Overall Length	EDP	Size	Decimal Equivalent	Flute Length	Overall Length
1023604	1/2	0.5000	3 1/8	6	1015851	57/64	0.8906	3	6
1015599	33/64	0.5156			1027857	29/32	0.9062		
1016600	17/32	0.5312			1015874	59/64	0.9219		
1015604	35/64	0.5469			1028148	15/16	0.9375		
1023839	9/16	0.5625			1015897	61/64	0.9531		
1015640	37/64	0.5781			1028498	31/32	0.9687		
1023925	19/32	0.5938			1015902	63/64	0.9844		
1062352	39/64	0.6094			1028721	1	1.0000		
1024062	5/8	0.6250			1015919	1 1/32	1.0312		
1015656	41/64	0.6406			1029391	1 1/16	1.0625		
1024194	21/32	0.6562			1015925	1 3/32	1.0938		
1015685	43/64	0.6719			1029757	1 1/8	1.1250		
1024319	11/16	0.6875			1015948	1 5/32	1.1562		
1015765	45/64	0.7031			1030300	1 3/16	1.1875		
1024550	23/32	0.7187			1015954	1 7/32	1.2188		
1015771	47/64	0.7344			1030993	1 1/4	1.1250		
1024909	3/4	0.7500			1005922	1 9/32	1.2812		
1015788	49/64	0.7656	1005939	1 5/16	1.3125				
1025178	25/32	0.7812	1011054	1 11/32	1.3438				
1015822	51/64	0.7969	1005951	1 3/8	1.3750				
1025642	13/16	0.8125	1011140	1 13/32	1.4062				
1015839	53/64	0.8281	1005968	1 7/16	1.4375				
1026408	27/32	0.8438	1011163	1 15/32	1.4688				
1015845	55/64	0.8594	1005974	1 1/2	1.5000				
1027250	7/8	0.8750							

1 per box

DRILL SET JOBBER LENGTH

List No. 599 General Purpose - Black Oxide



EDP	HIGH SPEED DRILLS SETS	SET NO.
Fractional Sizes	Fractional Sizes	
3599013	1/16" To 1/4" By 64ths	S13
3599015	1/16" To 1/2" By 32nds	S15
3599021	1/16" To 3/8" By 64ths	S21
3599129	1/16" To 1/2" By 64ths	S29
Wire Gauge Sizes	Wire Gauge Sizes	
3599060	No.1 To No.60	S60
3599020	No.61 To No. 80	S20
Letter Sizes	Letter Sizes	
3599026	A To Z	S26
Combination Sizes	Combination Sizes	
3599115	S29, S60, S26	S115
COBALT DRILL SETS	COBALT DRILL SETS	SET NO.
Fractional Sizes	Fractional Sizes	
3599029	1/16" To 1/2" By 64ths	C29

STANDARD DRILLING CONDITION

Straight Shank Drills

Jobber Length
Screw Machine Length
Taper Length

List No. 500, 501, 501A, 599
List No. 561, 563
List No. 531

Straight Shank Cobalt Drills

Jobber Length
Screw Machine Length
Taper Length

List No. 6501, 6520, 599
List No. 6563
List No. 6531

Workpiece Material			Carbon Steels		Alloy Steels Hardened Steels		Mold Steels Stainless Steels		Titanium Alloys ¹ High Temperature Alloys ¹		Cast Irons		Aluminum Alloys Nonferrous Metals	
Speed (SFM)			50 - 65 SFM		40 - 52 SFM		30 - 40 SFM		10 - 20 SFM		55 - 72 SFM		83 - 115 SFM	
Drill Diameter			50 - 65 SFM		40 - 52 SFM		30 - 40 SFM		10 - 20 SFM		55 - 72 SFM		83 - 115 SFM	
Fractional	Metric (mm)	Decimal	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)
—	1	0.0394	4,800	0.0008	3,800	0.0007	2,900	0.0006	1,500	0.0003	5,300	0.0010	8,100	0.0007
1/16	1.588	0.0625	3,400	0.0013	2,700	0.0011	2,100	0.0009	1,000	0.0005	3,800	0.0015	5,800	0.0011
—	2	0.0787	2,900	0.0016	2,300	0.0013	1,700	0.0012	720	0.0006	3,200	0.0020	4,900	0.0014
—	3	0.1181	2,100	0.0028	1,700	0.0023	1,300	0.0021	480	0.0009	2,300	0.0034	3,600	0.0024
1/8	3.175	0.1250	2,000	0.0029	1,700	0.0023	1,200	0.0022	460	0.0010	2,200	0.0036	3,500	0.0025
—	5	0.1969	1,300	0.0042	1,000	0.0037	760	0.0033	290	0.0015	1,400	0.0053	2,200	0.0038
1/4	6.35	0.2500	1,100	0.0047	800	0.0044	610	0.0038	230	0.0020	1,120	0.0064	1,750	0.0044
—	8	0.3150	800	0.0059	640	0.0050	480	0.0044	180	0.0025	900	0.0074	1,400	0.0051
3/8	9.525	0.3750	680	0.0065	540	0.0055	400	0.0049	160	0.0030	740	0.0082	1,200	0.0054
—	10	0.3937	640	0.0068	510	0.0057	380	0.0050	150	0.0032	700	0.0084	1,100	0.0057
—	12	0.4724	530	0.0074	420	0.0064	320	0.0057	120	0.0040	580	0.0095	900	0.0066
1/2	12.7	0.5000	510	0.0076	400	0.0066	310	0.0057	120	0.0043	550	0.0099	860	0.0069
5/8	15.875	0.6250	410	0.0089	330	0.0076	250	0.0065	100	0.0050	450	0.0115	690	0.0086
—	16	0.6299	400	0.0091	320	0.0078	240	0.0067	90	0.0050	440	0.0116	680	0.0087

1) The cutting condition of Titanium Alloys and Nickel Alloys are for HSS-Co drills only.

2) The above values apply when coolant is used in a vertical machine. In a horizontal machine or deep hole, use pecking.

3) Adjust drilling condition when unusual vibration or different sound occurs.

Straight Shank Drills TiN Coated

Jobber Length
Screw Machine Length

List No. 501P, 520P
List No. 561P

Workpiece Material			Carbon Steels		Alloy Steels		Die Steels Hardened Steels Stainless Steels		Cast Irons		Aluminum Alloys Nonferrous Metals	
Speed (SFM)			60 - 85 SFM		47 - 65 SFM		36 - 48 SFM		66 - 90 SFM		100 - 140 SFM	
Drill Diameter			60 - 85 SFM		47 - 65 SFM		36 - 48 SFM		66 - 90 SFM		100 - 140 SFM	
Fractional	Metric (mm)	Decimal	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)
—	1	0.0394	5,800	0.0008	4,600	0.0007	3,500	0.0006	6,400	0.0010	9,800	0.0007
1/16	1.588	0.0625	4,100	0.0013	3,200	0.0011	2,500	0.0009	4,400	0.0015	7,000	0.0011
—	2	0.0787	3,500	0.0016	2,800	0.0013	2,000	0.0012	3,800	0.0020	5,900	0.0014
—	3	0.1181	2,500	0.0028	2,000	0.0023	1,500	0.0021	2,800	0.0034	4,300	0.0024
1/8	3.175	0.1250	2,400	0.0029	2,000	0.0023	1,400	0.0022	2,600	0.0036	4,200	0.0025
—	5	0.1969	1,600	0.0042	1,200	0.0037	910	0.0033	1,700	0.0053	2,600	0.0038
1/4	6.35	0.2500	1,300	0.0047	1,000	0.0044	730	0.0038	1,300	0.0064	2,100	0.0044
—	8	0.3150	1,000	0.0059	770	0.0050	580	0.0044	1,100	0.0074	1,700	0.0051
3/8	9.525	0.3750	820	0.0065	650	0.0055	480	0.0049	890	0.0082	1,400	0.0054
—	10	0.3937	770	0.0068	610	0.0057	460	0.0050	840	0.0084	1,300	0.0057
—	12	0.4724	640	0.0074	500	0.0064	380	0.0057	700	0.0095	1,100	0.0066
1/2	12.7	0.5000	610	0.0076	490	0.0066	370	0.0057	670	0.0099	1,000	0.0069
5/8	15.875	0.6250	500	0.0089	400	0.0076	300	0.0065	540	0.0115	830	0.0086
—	16	0.6299	480	0.0091	380	0.0078	290	0.0067	530	0.0116	820	0.0087

1) The above values apply when coolant is used in a vertical machine. In a horizontal machine or deep hole, use pecking.

2) Adjust drilling condition when unusual vibration or different sound occurs.

STANDARD DRILLING CONDITION

Straight Shank Drills Parabolic Style TiN Coated

Jobber Length
Taper Length

List No. 517P
List No. 545P

Workpiece Material			Carbon Steels		Alloy Steels		Die Steels Hardened Steels Stainless Steels		Cast Irons	
Speed (SFM)			60 - 85 SFM		47 - 65 SFM		36 - 48 SFM		66 - 90 SFM	
Drill Diameter			60 - 85 SFM		47 - 65 SFM		36 - 48 SFM		66 - 90 SFM	
Fractional	Metric (mm)	Decimal	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)
—	1	0.0394	5,800	0.0011	4,600	0.0009	3,500	0.0008	6,400	0.0014
1/16	1.588	0.0625	4,100	0.0018	3,200	0.0014	2,500	0.0012	4,400	0.0021
—	2	0.0787	3,500	0.0023	2,800	0.0017	2,000	0.0015	3,800	0.0028
—	3	0.1181	2,500	0.0039	2,000	0.0030	1,500	0.0027	2,800	0.0048
1/8	3.175	0.1250	2,400	0.0041	2,000	0.0030	1,400	0.0029	2,600	0.0050
—	5	0.1969	1,600	0.0059	1,200	0.0048	910	0.0042	1,700	0.0075
1/4	6.35	0.2500	1,300	0.0066	1,000	0.0057	730	0.0049	1,300	0.0089
—	8	0.3150	1,000	0.0083	770	0.0066	580	0.0058	1,100	0.0104
3/8	9.525	0.3750	820	0.0091	650	0.0072	480	0.0063	890	0.0115
—	10	0.3937	770	0.0095	610	0.0074	460	0.0065	840	0.0118
—	12	0.4724	640	0.0104	500	0.0083	380	0.0074	700	0.0133
1/2	12.7	0.5000	610	0.0107	490	0.0086	370	0.0075	670	0.0139
5/8	15.875	0.6250	500	0.0124	400	0.0099	300	0.0085	540	0.0161
—	16	0.6299	480	0.0127	380	0.0101	290	0.0087	530	0.0163

- 1) The above values apply when coolant is used in a vertical machine. In a horizontal machine or deep hole, use pecking.
2) Adjust drilling condition when unusual vibration or different sound occurs.

Straight Shank Drills Extra Length Taper Shank Drills Extra Length

List No. 551, 6551
List No. 651

Workpiece Material		Carbon Steels		Alloy Steels Hardened Steels		Stainless Steels		Cast Irons		Brass Nonferrous Metals	
Speed (SFM)		44 - 55 SFM		32 - 40 SFM		32 - 40 SFM		52 - 65 SFM		48 - 60 SFM	
Drill Diameter		44 - 55 SFM		32 - 40 SFM		32 - 40 SFM		52 - 65 SFM		48 - 60 SFM	
Fractional	Decimal	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)
1/16	0.0625	2,700	0.0020	2,000	0.0010	2,000	0.0015	3,200	0.0015	3,000	0.0020
1/8	0.1250	1,600	0.0038	1,200	0.0018	1,200	0.0025	1,800	0.0025	1,700	0.0036
3/16	0.1875	1,200	0.0052	820	0.0025	820	0.0035	1,400	0.0035	1,300	0.0050
1/4	0.2500	850	0.0065	620	0.0030	620	0.0048	1,000	0.0048	1,000	0.0063
5/16	0.3125	680	0.0075	490	0.0035	490	0.0055	800	0.0055	740	0.0078
3/8	0.3750	570	0.0090	410	0.0040	410	0.0060	670	0.0060	620	0.0090
1/2	0.5000	430	0.0110	310	0.0052	310	0.0080	500	0.0080	460	0.0110
5/8	0.6250	340	0.0120	250	0.0060	250	0.0090	400	0.0090	370	0.0120
3/4	0.7500	290	0.0130	210	0.0070	210	0.0100	340	0.0100	310	0.0130
1	1.0000	220	0.0140	160	0.0080	160	0.0110	250	0.0110	230	0.0140

- 1) The above values apply when coolant is used in a vertical machine. In a horizontal machine or deep hole, use pecking.
2) Adjust drilling condition when unusual vibration or different sound occurs.

Straight Shank Oil Hole Drills / Cobalt

List No. 581

Workpiece Material		Carbon Steels		Alloy Steels		Die Steels Hardened Steels Stainless Steels		Cast Irons		Aluminum Alloys Nonferrous Metals	
Speed (SFM)		55 - 66 SFM		44 - 52 SFM		32 - 40 SFM		61 - 73 SFM		91 - 114 SFM	
Drill Diameter		55 - 66 SFM		44 - 52 SFM		32 - 40 SFM		61 - 73 SFM		91 - 114 SFM	
Fractional	Decimal	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)
1/16	0.0625	3,400	0.0016	2,700	0.0013	2,100	0.0011	3,800	0.0018	5,800	0.0013
1/8	0.1250	2,000	0.0035	1,700	0.0027	1,200	0.0027	2,200	0.0043	3,500	0.0030
1/4	0.2500	1,100	0.0056	800	0.0052	610	0.0046	1,120	0.0076	1,750	0.0053
3/8	0.3750	680	0.0078	540	0.0066	400	0.0058	740	0.0099	1,200	0.0065
1/2	0.5000	510	0.0091	400	0.0079	310	0.0069	550	0.0119	860	0.0082
5/8	0.6250	410	0.0106	330	0.0091	250	0.0079	450	0.0138	690	0.0103

- 1) The above values apply when coolant is used in a vertical machine. In a horizontal machine or deep hole, use pecking.
2) Adjust drilling condition when unusual vibration or different sound occurs.

STANDARD DRILLING CONDITION

Taper Shank Drills

Regular Shank / Core Drills Silver and Deming Drills

List No. 601

List No. 575

Workpiece Material		Carbon Steels		Alloy Steels		Die Steels Hardened Steels Stainless Steels		Cast Irons		Aluminum Alloys Nonferrous Metals	
Speed (SFM)		55 - 66 SFM		50 - 60 SFM		35 - 45 SFM		65 - 80 SFM		100 - 110 SFM	
Drill Diameter		55 - 66 SFM		50 - 60 SFM		35 - 45 SFM		65 - 80 SFM		100 - 110 SFM	
Fractional	Decimal	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)
1/8	0.1250	2,000	0.003	1,900	0.003	1,400	0.002	2,500	0.004	3,400	0.003
3/16	0.1875	1,400	0.004	1,300	0.004	920	0.003	1,700	0.005	2,300	0.005
1/4	0.2500	1,000	0.004	920	0.005	690	0.004	1,300	0.007	1,700	0.006
5/16	0.3125	800	0.004	740	0.005	560	0.005	980	0.008	1,400	0.008
3/8	0.3750	670	0.007	620	0.006	460	0.005	820	0.008	1,200	0.008
7/16	0.4375	570	0.007	530	0.006	400	0.005	700	0.009	970	0.009
1/2	0.5000	500	0.008	460	0.006	350	0.006	620	0.010	850	0.009
5/8	0.6250	400	0.009	370	0.008	280	0.007	490	0.012	680	0.012
3/4	0.7500	340	0.010	310	0.009	230	0.008	410	0.013	570	0.013
7/8	0.8750	290	0.011	270	0.009	200	0.008	350	0.014	490	0.014
1	1.0000	250	0.012	230	0.010	180	0.009	310	0.015	430	0.014
1 1/8	1.1250	230	0.012	210	0.011	160	0.010	280	0.016	380	0.015
1 1/4	1.2500	200	0.014	190	0.011	140	0.010	250	0.016	340	0.016
1 3/8	1.3750	190	0.014	170	0.012	130	0.010	230	0.017	310	0.017
1 1/2	1.5000	170	0.014	160	0.012	120	0.011	210	0.017	290	0.017
1 5/8	1.6250	160	0.015	150	0.013	110	0.011	190	0.017	260	0.017
1 3/4	1.7500	150	0.016	140	0.013	100	0.011	180	0.018	250	0.018
1 7/8	1.8750	140	0.016	130	0.014	100	0.012	170	0.019	230	0.019
2	2.0000	130	0.016	120	0.014	90	0.012	160	0.020	220	0.020

Taper Shank Oil Hole Drills / Cobalt List No. 683

Workpiece Material		Carbon Steels		Alloy Steels Hardened Steels		Mold Steels Stainless Steels		Cast Irons		Aluminum Alloys Nonferrous Metals	
Speed (SFM)		55 - 65 SFM		50 - 60 SFM		35 - 45 SFM		65 - 80 SFM		100 - 110 SFM	
Drill Diameter		55 - 65 SFM		50 - 60 SFM		35 - 45 SFM		65 - 80 SFM		100 - 110 SFM	
Fractional	Decimal	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)	RPM	Feed (IPR)
3/8	0.3750	680	0.008	620	0.007	460	0.006	820	0.010	1,200	0.010
7/16	0.4375	580	0.009	530	0.007	400	0.006	700	0.011	970	0.011
1/2	0.5000	510	0.009	460	0.008	350	0.007	620	0.012	850	0.012
5/8	0.6250	410	0.011	370	0.010	280	0.008	490	0.014	680	0.014
23/32	0.7188	360	0.012	320	0.010	240	0.009	430	0.015	590	0.014
3/4	0.7500	340	0.013	310	0.011	230	0.009	410	0.015	570	0.015
7/8	0.8750	290	0.013	270	0.011	200	0.010	350	0.017	490	0.017
1	1.0000	260	0.014	230	0.012	180	0.011	310	0.018	430	0.018
1 1/4	1.2500	210	0.016	190	0.013	140	0.011	250	0.019	340	0.019
1 1/2	1.5000	170	0.017	160	0.014	120	0.012	210	0.021	290	0.021

- 1) The above values apply when coolant is used in a vertical machine. In a horizontal machine or deep hole, use pecking.
2) Adjust drilling condition when unusual vibration or different sound occurs.



WARNING: This product can expose you to chemicals including cobalt, which is known to the State of California to cause cancer. For more information go to www.P65Warnings.ca.gov

NACHI AMERICA INC.

HEADQUARTERS AND MAIN WAREHOUSE

715 Pushville Road, Greenwood, Indiana, 46143, U.S.A.
Phone: 317-530-1003 Toll Free Phone: +1-888-340-8665
Fax: 317-530-1013 Toll Free Fax: +1-888-383-8665
www.nachiamerica.com

WEST COAST BRANCH

12652 E. Alondra Blvd. Cerritos, California, 90703, U.S.A.
Phone: 562-802-0055 Toll Free Phone: 1-800-548-3903
Fax: 562-802-2455

NACHI CANADA INC.

TORONTO HEADQUARTERS

89 Courtland Ave., Unit No.2, Concord, Ontario, L4K 3T4, CANADA
Phone: (905)-660-0088 Toll Free Phone: +1-800-387-9188
Fax: (905)-660-0097

NACHI MEXICANA, S.A. DE C.V.

Calle Tequisquipan 2, Aerotech Industrial Park
Localidad Galeras, Municipio de Colon, Queretaro, Mexico C.P. 76295
Phone: +52-442-153-2424
Fax: +52-442-153-2435