

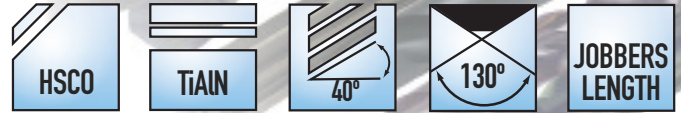
Designed for deep hole drilling with extremely efficient chip evacuation, without the need for frequent drill withdrawal. A heavy web and parabolic flute shape provide increased stability enabling drilling of accurate straight holes up to 5 x D.

| Size (in) | Decimal (mm) | Decimal Equiv. | Flute Length (mm) | Overall Length (mm) | Code No. | Price \$     |
|-----------|--------------|----------------|-------------------|---------------------|----------|--------------|
|           | 3.00         | .1181          | 33                | 61                  | 134-475  | <b>8.80</b>  |
|           | 3.10         | .1220          | 36                | 65                  | 134-476  | <b>13.60</b> |
| 1/8       | 3.17         | .1250          | 36                | 65                  | 134-477  | <b>13.60</b> |
|           | 3.20         | .1260          | 36                | 65                  | 134-478  | <b>13.70</b> |
|           | 3.30*        | .1299          | 36                | 65                  | 134-479  | <b>13.70</b> |
|           | 3.40         | .1339          | 39                | 70                  | 134-480  | <b>14.00</b> |
|           | 3.50*        | .1378          | 39                | 70                  | 134-481  | <b>14.00</b> |
| 9/64      | 3.57         | .1406          | 39                | 70                  | 134-482  | <b>14.00</b> |
|           | 3.60         | .1417          | 39                | 70                  | 134-483  | <b>14.00</b> |
|           | 3.70*        | .1457          | 39                | 70                  | 134-484  | <b>14.00</b> |
|           | 3.80         | .1496          | 43                | 75                  | 134-485  | <b>14.40</b> |
|           | 3.90*        | .1535          | 43                | 75                  | 134-486  | <b>14.40</b> |
| 5/32      | 3.97         | .1562          | 43                | 75                  | 134-487  | <b>14.20</b> |
|           | 4.00         | .1575          | 43                | 75                  | 134-488  | <b>14.20</b> |
|           | 4.10*        | .1614          | 43                | 75                  | 134-489  | <b>16.10</b> |
|           | 4.20*        | .1654          | 43                | 75                  | 134-490  | <b>16.10</b> |
|           | 4.30         | .1693          | 47                | 80                  | 134-491  | <b>16.10</b> |
| 11/64     | 4.37         | .1719          | 47                | 80                  | 134-492  | <b>16.30</b> |
|           | 4.40         | .1732          | 47                | 80                  | 134-493  | <b>16.30</b> |
|           | 4.50*        | .1772          | 47                | 80                  | 134-494  | <b>16.30</b> |
|           | 4.60*        | .1811          | 47                | 80                  | 134-495  | <b>16.40</b> |
|           | 4.70         | .1850          | 47                | 80                  | 134-496  | <b>16.40</b> |
| 3/16      | 4.76         | .1875          | 52                | 86                  | 134-497  | <b>17.00</b> |
|           | 4.80         | .1890          | 52                | 86                  | 134-498  | <b>17.00</b> |
|           | 4.90         | .1929          | 52                | 86                  | 134-499  | <b>17.00</b> |
|           | 5.00*        | .1969          | 52                | 86                  | 134-500  | <b>17.00</b> |
|           | 5.10*        | .2008          | 52                | 86                  | 134-501  | <b>17.20</b> |
| 13/64     | 5.16         | .2031          | 52                | 86                  | 134-502  | <b>17.50</b> |
|           | 5.20         | .2047          | 52                | 86                  | 134-503  | <b>17.50</b> |
|           | 5.30         | .2087          | 52                | 86                  | 134-504  | <b>17.50</b> |
|           | 5.40         | .2126          | 57                | 93                  | 134-505  | <b>17.50</b> |
|           | 5.50*        | .2165          | 57                | 93                  | 134-506  | <b>17.70</b> |
| 7/32      | 5.56         | .2188          | 57                | 93                  | 134-507  | <b>17.50</b> |
|           | 5.60         | .2205          | 57                | 93                  | 134-508  | <b>17.70</b> |
|           | 5.70         | .2244          | 57                | 93                  | 134-509  | <b>17.60</b> |
|           | 5.80         | .2283          | 57                | 93                  | 134-510  | <b>17.60</b> |
|           | 5.90         | .2323          | 57                | 93                  | 134-511  | <b>17.60</b> |
| 15/64     | 5.95         | .2344          | 57                | 93                  | 134-512  | <b>17.70</b> |

\* = Tap Drill sizes

| Size (in) | Decimal (mm) | Decimal Equiv. | Flute Length (mm) | Overall Length (mm) | Code No. | Price \$     |
|-----------|--------------|----------------|-------------------|---------------------|----------|--------------|
|           | 6.00*        | .2362          | 57                | 93                  | 134-513  | <b>17.70</b> |
|           | 6.10         | .2402          | 63                | 101                 | 134-514  | <b>24.90</b> |
|           | 6.20         | .2441          | 63                | 101                 | 134-515  | <b>24.90</b> |
|           | 6.30         | .2480          | 63                | 101                 | 134-516  | <b>25.00</b> |
| 1/4       | 6.35         | .2500          | 63                | 101                 | 134-517  | <b>25.00</b> |
|           | 6.40         | .2520          | 63                | 101                 | 134-518  | <b>25.00</b> |
|           | 6.50         | .2559          | 63                | 101                 | 134-519  | <b>25.00</b> |
|           | 6.60*        | .2598          | 63                | 101                 | 134-520  | <b>28.80</b> |
|           | 6.70         | .2638          | 63                | 101                 | 134-521  | <b>28.80</b> |
| 17/64     | 6.75         | .2656          | 69                | 109                 | 134-522  | <b>26.40</b> |
|           | 6.80*        | .2677          | 69                | 109                 | 134-523  | <b>26.40</b> |
|           | 6.90*        | .2717          | 69                | 109                 | 134-524  | <b>26.40</b> |
|           | 7.00*        | .2756          | 69                | 109                 | 134-525  | <b>26.40</b> |
|           | 7.10         | .2795          | 69                | 109                 | 134-526  | <b>26.40</b> |
| 9/32      | 7.14         | .2812          | 69                | 109                 | 134-527  | <b>27.00</b> |
|           | 7.20         | .2835          | 69                | 109                 | 134-528  | <b>27.00</b> |
|           | 7.30         | .2874          | 69                | 109                 | 134-529  | <b>27.00</b> |
|           | 7.40         | .2913          | 69                | 109                 | 134-530  | <b>27.00</b> |
|           | 7.50         | .2953          | 69                | 109                 | 134-531  | <b>27.00</b> |
| 19/64     | 7.54         | .2969          | 75                | 117                 | 134-532  | <b>27.00</b> |
|           | 7.60         | .2992          | 75                | 117                 | 134-533  | <b>27.90</b> |
|           | 7.70         | .3031          | 75                | 117                 | 134-534  | <b>27.90</b> |
|           | 7.80         | .3071          | 75                | 117                 | 134-535  | <b>27.90</b> |
|           | 7.90         | .3110          | 75                | 117                 | 134-536  | <b>28.00</b> |
| 5/16      | 7.94         | .3125          | 75                | 117                 | 134-537  | <b>28.20</b> |
|           | 8.00*        | .3150          | 75                | 117                 | 134-538  | <b>28.20</b> |
|           | 8.10         | .3189          | 75                | 117                 | 134-539  | <b>34.00</b> |
|           | 8.20         | .3228          | 75                | 117                 | 134-540  | <b>34.10</b> |
|           | 8.30         | .3268          | 75                | 117                 | 134-541  | <b>34.10</b> |
| 21/64     | 8.33         | .3281          | 75                | 117                 | 134-542  | <b>34.10</b> |
|           | 8.40         | .3307          | 75                | 117                 | 134-543  | <b>34.60</b> |
|           | 8.50*        | .3346          | 75                | 117                 | 134-544  | <b>28.40</b> |
|           | 8.60         | .3386          | 81                | 125                 | 134-545  | <b>35.30</b> |
|           | 8.70         | .3425          | 81                | 125                 | 134-546  | <b>35.30</b> |
| 11/32     | 8.73         | .3438          | 81                | 125                 | 134-547  | <b>35.30</b> |
|           | 8.80         | .3465          | 81                | 125                 | 134-548  | <b>35.60</b> |
|           | 8.90         | .3504          | 81                | 125                 | 134-549  | <b>35.60</b> |

# YELLOW RING JOBBER DRILLS



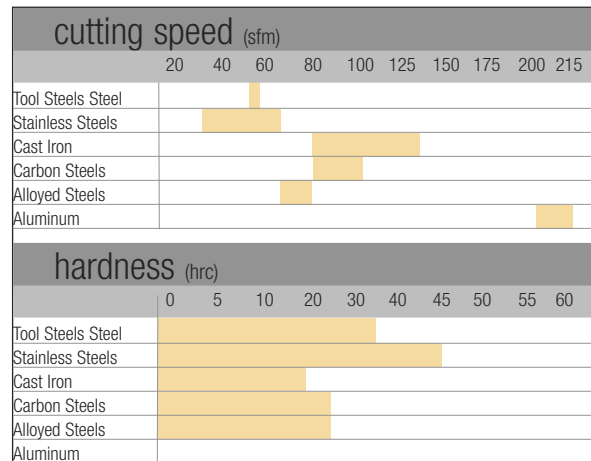
Designed for deep hole drilling with extremely efficient chip evacuation, without the need for frequent drill withdrawal. A heavy web and parabolic flute shape provide increased stability enabling drilling of accurate straight holes up to 5 x D.

| Size (in) | Decimal (mm) | Decimal Equiv. | Flute Length (mm) | Overall Length (mm) | Code No.     | Price \$     |
|-----------|--------------|----------------|-------------------|---------------------|--------------|--------------|
| 9.00      | .3543        | 81             | 125               | 134-550             | <b>35.60</b> |              |
| 9.10      | .3583        | 81             | 125               | 134-551             | <b>35.90</b> |              |
| 23/64     | 9.13         | .3594          | 81                | 125                 | 134-552      | <b>35.90</b> |
| 9.20      | .3622        | 81             | 125               | 134-553             | <b>37.00</b> |              |
| 9.30      | .3661        | 81             | 125               | 134-554             | <b>37.00</b> |              |
| 9.40*     | .3701        | 81             | 125               | 134-555             | <b>37.00</b> |              |
| 9.50      | .3740        | 81             | 125               | 134-556             | <b>37.00</b> |              |
| 3/8       | 9.52         | .3750          | 87                | 133                 | 134-557      | <b>36.90</b> |
| 9.60      | .3780        | 87             | 133               | 134-558             | <b>44.80</b> |              |
| 9.70      | .3819        | 87             | 133               | 134-559             | <b>44.80</b> |              |
| 9.80      | .3858        | 87             | 133               | 134-560             | <b>44.80</b> |              |
| 9.90*     | .3898        | 87             | 133               | 134-561             | <b>45.00</b> |              |
| 25/64     | 9.92         | .3906          | 87                | 133                 | 134-562      | <b>45.00</b> |
| 10.00     | .3937        | 87             | 133               | 134-563             | <b>25.20</b> |              |
| 10.20*    | .4016        | 87             | 133               | 134-565             | <b>45.80</b> |              |
| 13/32     | 10.32        | .4063          | 87                | 133                 | 134-567      | <b>45.80</b> |
| 10.50     | .4134        | 87             | 133               | 134-569             | <b>46.80</b> |              |
| 27/64     | 10.72        | .4220          | 87                | 133                 | 134-572      | <b>46.80</b> |
| 10.80*    | .4252        | 87             | 133               | 134-573             | <b>47.50</b> |              |
| 11.00     | .4331        | 94             | 142               | 134-575             | <b>57.90</b> |              |
| 7/16      | 11.11        | .4374          | 94                | 142                 | 134-577      | <b>57.90</b> |
| 11.50*    | .4528        | 94             | 142               | 134-581             | <b>59.20</b> |              |
| 29/64     | 11.51        | .4531          | 94                | 142                 | 134-582      | <b>59.20</b> |
| 11.80     | .4646        | 94             | 142               | 134-585             | <b>60.10</b> |              |

| Size (in) | Decimal (mm) | Decimal Equiv. | Flute Length (mm) | Overall Length (mm) | Code No.     | Price \$     |
|-----------|--------------|----------------|-------------------|---------------------|--------------|--------------|
| 15/32     | 11.91        | .4689          | 101               | 151                 | 134-587      | <b>60.50</b> |
| 12.00*    | .4724        | 101            | 151               | 134-588             | <b>61.90</b> |              |
| 12.20*    | .4803        | 101            | 151               | 134-590             | <b>62.70</b> |              |
| 31/64     | 12.30        | .4882          | 101               | 151                 | 134-592      | <b>62.80</b> |
| 12.50*    | .4961        | 101            | 151               | 134-594             | <b>64.10</b> |              |
| 1/2       | 12.70        | .5000          | 101               | 151                 | 134-597      | <b>64.30</b> |

\* = Tap Drill sizes

| cutting conditions |   |            |                |                     |
|--------------------|---|------------|----------------|---------------------|
| Materials          |   |            |                | Cutting Speed (SFM) |
| Main Group         | Sub-Group                               | Condition  | Hardness (HRC) |                     |
| Tool Steels        | A2, A6, L7, 01, 02, 06, M1, M2, D2, P20 | Annealed   | <35            | 50-55               |
| Stainless Steel    | 200 Series,                             | Annealed   | <28            | 50-60               |
|                    | 300 Series,                             | Annealed   | <28            | 30-60               |
|                    | 400 Series                              | Annealed   | <29            | 55-65               |
|                    | 400 Series                              | Hardened   | <45            | 50-60               |
| Cast Iron          | Soft, Hard, Malleable                   |            | <18            | 80-135              |
| Carbon Steels      | 1020 thr 1060, 1090                     | Normalized | <22            | 80-100              |
| Alloyed Steels     | 1435,4140,4615,5140                     | Normalized | <22            | 65-80               |
| Aluminum           | Alloys, Cast                            | -          | -              | 200-215             |



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