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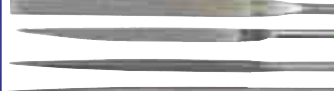
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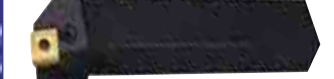
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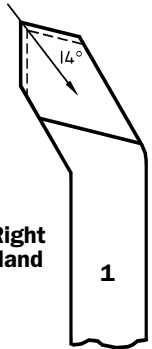
Cutting Tools

Section 1 Product Groups 010 - 154



Manufactured from top quality sintered steels. For use on a wide range of applications from roughing to finishing.
Manufactured to **BS 1296 : Part 3 : 1978.**

Light Turning & Facing

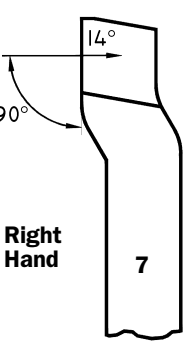


Right Hand
1

Rake & Clearance Angles	
Top Rake	14°
Front Clearance	6°
Approach Angle	-2°
Trail Angle	15°
Side Clearance	6°
Corner Radius	-

Shank (mm)	Overall Length	Order Code
12 x 12	100	-0120K
16 x 16	110	-0160K
20 x 20	125	-0200K

Knife or Side Cutting

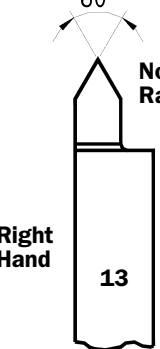


Right Hand
7

Rake & Clearance Angles	
Top Rake	14°
Front Clearance	6°
Approach Angle	-2°
Trail Angle	4 - 10°
Side Clearance	6°
Corner Radius	-

Shank (mm)	Overall Length	Order Code
12 x 12	100	-1120K
16 x 16	110	-1160K
20 x 20	125	-1200K

External Screw Cutting

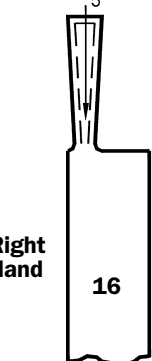


Right Hand
13

Rake & Clearance Angles	
Top Rake	0°
Front Clearance	12°
Approach Angle	30°
Trail Angle	60°
Side Clearance	60°
Corner Radius	-

Shank (mm)	Overall Length	Order Code
12 x 12	100	-2120K
16 x 16	110	-2160K
20 x 20	125	-2200K

Parting Off

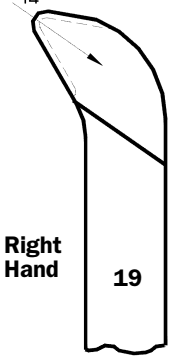


Right Hand
16

Rake & Clearance Angles	
Top Rake	5°
Front Clearance	6°
Approach Angle	90°
Trail Angle	0°
Side Clearance	1-2°
Corner Radius	-

Shank (mm)	Overall Length	Order Code
12 x 12	100	-3120K
16 x 16	110	-3160K
20 x 20	125	-3200K

Facing

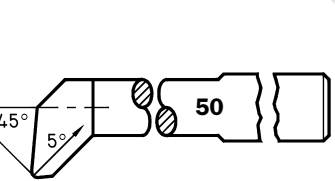


Right Hand
19

Rake & Clearance Angles	
Top Rake	14°
Front Clearance	6°
Approach Angle	-30°
Trail Angle	15°
Side Clearance	6°
Corner Radius	3 - 8°

Shank (mm)	Overall Length	Order Code
12 x 12	100	-5120K
16 x 16	110	-5160K
20 x 20	125	-5200K

Boring Tools



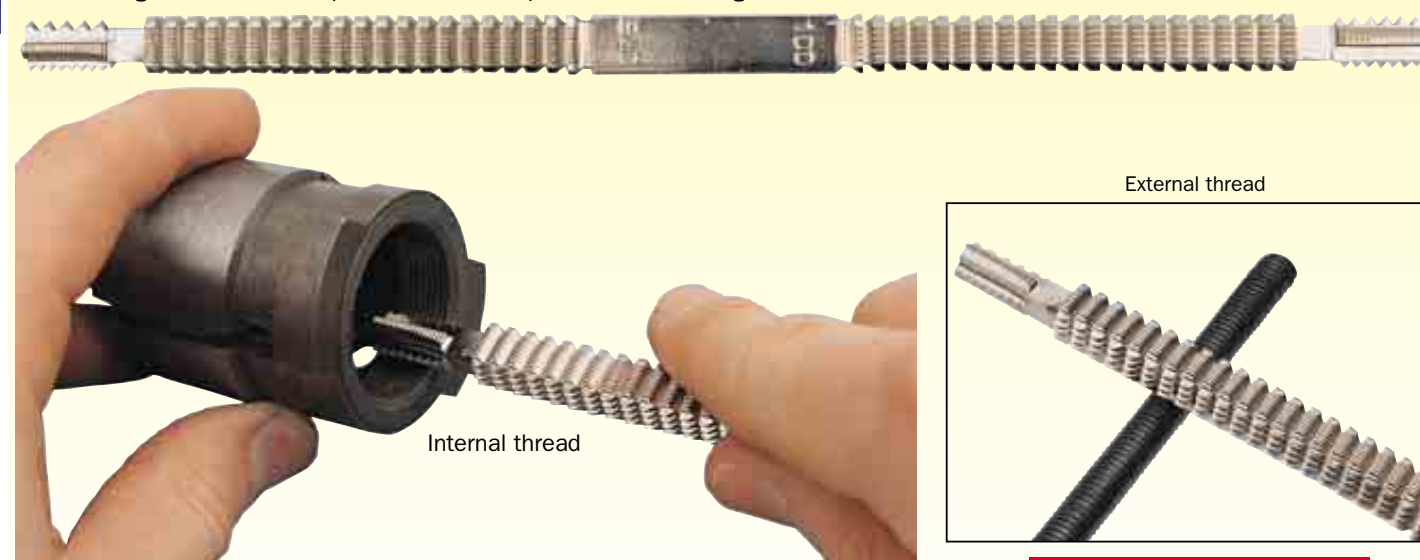
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Rake & Clearance Angles	
Top Rake	5°
Front Clearance	6°
Approach Angle	-1°
Trail Angle	4°
Side Clearance	6°
Corner Radius	-3°
Cutting Angle	30°

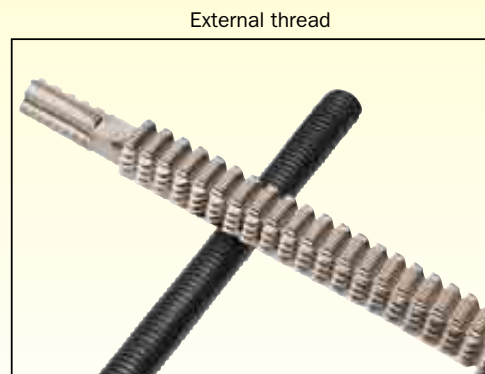
Shank (mm)	Overall Length	Order Code
12 x 12	100	-8120K
16 x 16	110	-8160K
20 x 20	125	-8200K

SHERWOOD *Thread Restoring*
QUALITY CUTTING TOOLS *Files*

For restoring threads where taps and dies are impractical. Restore right and left hand, internal and external threads.



Thread Type	Range	Order Code
ISO	.80 to 3mm	-9020C
Whit/BSF	10 tpi to 24 tpi	-9001A
UNF/UNC	11 tpi to 24 tpi	-9010B
BSP	11 tpi to 28 tpi	-9030D



For Thread Repair Kits

See **Group 620**



HSS Multi Diameter Step Drills

HSS

Produce good quality holes in a wide variety of materials, using either a bench drill or light pedestal drilling machine. Each tool cuts concentric holes in a range of specific sizes. For material up to 1/8" (3mm) thick.



Size	Range	No. of Steps	Weight each	Order Code
0/5	4 - 12mm	5	30g	-0500K
0/9	4 - 12mm	9	30g	-0509K
1	4 - 20mm	9	70g	-0510K
2	4 - 30mm	14	200g	-0520K
3	6 - 38mm	12	299g	-0530K
5	4 - 39mm	13	320g	-0560K
9	6 - 37mm	12	310g	-0600K

HSS Sheet Metal Step Drill Set

HSS

Three piece step drill set.

Sizes include:

4 - 12mm (9 step, 6mm shank),
4 - 20mm (9 step, 8mm shank) and
4 - 30mm (14 step, 10mm shank).



**3
PIECES**

Number of Pieces	Range	Weight	Order Code
3	4 - 30mm	275g	-0260K

HSS Taper Sheet & Tube Drills

For producing clean holes in sheet metal and other thin walled materials. Efficient cutting geometry, no pre-drilled pilot hole and the diameter of the finished hole is infinitely variable within the range of each drill, according to depth of feed.



HSS



Range	Shank Diameter	Overall Length	Weight each	Order Code
3 - 14mm	6	57	30g	-1100K
8 - 20mm	8	66	60g	-1110K
16 - 30mm	9	74	140g	-1120K
26 - 40mm	9	85	300g	-1130K



HSS-E (5% Co) Countersinks Single Hole

Manufactured from HSS-E cobalt for deburring and chamfering. Straight shank. Manufactured to **BS328 : Part 5 : 1983**. Inclusive angle 90°.



HSS-Co. 5%



Cutting Range	Shank Diameter	Overall Length	Weight each	Order Code
2 - 5mm	6	32.0	15g	-2090K
5 - 10mm	8	30.5	25g	-2100K
10 - 15mm	10	37.5	25g	-2150K
15 - 20mm	12	48.0	110g	-2200K
20 - 25mm	15	56.5	225g	-2250K
25 - 30mm	15	55.0	315g	-2300K
30 - 35mm	15	60.5	315g	-2350K

Countersink Set

HSS-Co. 5%

6 Piece Set

Straight shank, ground flute 90° angle.

Sizes: 2 - 5mm, 5 - 10mm, 10 - 15mm, 15 - 20mm, 20 - 25mm and 25 - 30mm.

Supplied in wooden box.



**6
PIECES**

Inclined Angles for Countersunk Socket Head Screws			
Thread Series	Standard	Thread Size	Countersink Angle
Metric	BS EN ISO 10642	up to M20 over M20.	90° 60°
UNC/UNF	ANSI B 18.3	No.0 to 1"	82°
BSW/BSF	BS 2470	1/8" TO 1"	90°
BA	BS 2470	8BA TO 0BA	90°

Number of Pieces	Shank Style	Weight each	Order Code
6	Straight	1.2kg	-9020B

GROUP 020 COUNTERSINKS



**HSS (5% Co)
Countersinks**

Manufactured from M35 HSS and used for the deburring and chamfering of most metals and plastics.
Manufactured to **BS 328 : Part 5 : 1983**.

Inclined Angles for Countersunk Socket Head Screws

Thread Series	Standard	Thread Size	Countersink Angle
Metric	BS EN ISO 10642	up to M20 over M20	90° 60°
UNC/UNF	ANSI B 18.3	No.0 to 1"	82°
BSW/BSF	BS 2470	1/8" TO 1"	90°
BA	BS 2470	8BA TO 0BA	90°

Multi Flute - Straight Shank, Rose Pattern

Inclusive angle 90°.



Cutting Range	Shank Diameter	Overall Length	Weight each	Order Code SHR-020
9.5mm	4.8mm	52mm	10g	-2040K
12.7mm	4.8mm	52mm	10g	-2060K
15.8mm	6.3mm	52mm	20g	-2080K

HSS (5% Co) High Performance Countersinks

A chatter-free cutter giving an excellent burr-free finish. Capable of deburring and countersinking in one stroke with no 'back-off' of tool. Also free countersinking of aluminium with no secondary bulge. For special applications and exotic materials, a choice of hard coatings is available.

HSS-Co. 5%

60° Countersink



60° Countersink

Cutting Diameter	Shank (mm)	Length (mm)	Weight each	Order Code SHR-020
8.3mm	6	46	12g	-6000K
10.4mm	6	47	13g	-6050K
12.4mm	8	58	24g	-6100K
16.5mm	8	60	29g	-6150K
20.5mm	10	65	48g	-6200K
25.0mm	10	69	70g	-6300K

90° Countersink



90° Countersink

Order Code SHR-020
-5000K
-5050K
-5100K
-5150K
-5200K
-5250K

100° Countersink



100° Countersink

Order Code SHR-020
-5500K
-5550K
-5600K
-5650K
-5700K
-5750K

90° Heavy Duty

Manufactured from HSS-E cobalt steel for deburring and chamfering of most metals and plastics.
Manufactured to **BS328 : Part 5 : 1983**.



Cutting Diameter	Shank Diameter	Weight each	Order Code SHR-020
8.0mm	8mm	20g	-0790K
10.0mm	8mm	20g	-0890K
12.5mm	8mm	30g	-0990K
16.0mm	10mm	45g	-1090K
20.0mm	10mm	60g	-1110K
25.0mm	10mm	80g	-1130K

3 Flute -Taper Shank

90° Inclusive Angle



HSS-Co. 5%



Diameter (mm)	Morse Taper	Weight each	Order Code SHR-020
16.0mm	1MT	750g	-1550K
20.0mm	2MT	180g	-1570K
25.0mm	2MT	215g	-1590K
31.5mm	2MT	255g	-1690K
40.0mm	3MT	585g	-1790K
50.0mm	3MT	770g	-1890K

Multi Flute - Straight Shank, Heavy Duty

Inclusive angle 90°.



Diameter (mm)	Shank Diameter	Overall Length	Weight each	Order Code SHR-020
12.7	6.30mm	40mm	22g	-2000K

HSS (5% Co) High Performance Multi Flute Countersink Set

6 Piece

Manufactured from HSS-E cobalt for deburring and chamfering.
Straight shank, ground flute, 90° angle.

Sizes: 8, 10, 12.5, 16, 20 and 25mm.

Manufactured to **BS328 : Part 5 : 1983**.

Inclusive angle 90°.

**6
PIECES**



No. of Pieces	Shank Style	Weight	Order Code SHR-020
6	Straight	433g	-9010A

For the general purpose countersinking of tool steel, cast irons, high silicon aluminium, bronze and non-metallic materials such as resin fibre-glass and laminates. Available in three flute with eccentric relief and six flute with conventional relief. Manufactured to **USCTI Standards**.

3 Flute 90°



6 Flute 90°



* Brazed steel shank				
Cutting Diameter	Shank Diameter	Overall Length	Weight each	Order Code KEN-120
1/4"	1/4"	2"	30g	-0790K
3/8"	1/4" *	2 13/16"	40g	-0890K
1/2"	1/4" *	2 7/8"	50g	-0990K
5/8"	3/8" *	3"	90g	-1090K
3/4"	1/2" *	3"	130g	-1110K

* Brazed steel shank				
Cutting Diameter	Shank Diameter	Overall Length	Weight each	Order Code KEN-120
1/4"	1/4"	2"	30g	-1790K
3/8"	1/4" *	2 13/16"	40g	-1890K
1/2"	1/4" *	2 7/8"	50g	-1990K
5/8"	3/8" *	3"	90g	-2090K
3/4"	1/2" *	3"	130g	-2110K



**Solid Counterbores
HSS-Co 5%**

HSS-Co 5%



Spiral flute, 3 flute. Medium duty. Used for milling of pre-drilled holes to allow bolt or cap head screws to lie flush with the component surface. Manufactured to **BS328: 5:1983**.

NEW

Threaded Shank



Plain Shank



Bolt Size	Pilot Dia.	Cutter Dia.	Overall Length	Weight each	Order Code SHR-021
4mm	4.3	8.0	65.0	10g	-3040K
5mm	5.3	10.0	70.0	10g	-3050K
6mm	6.4	11.0	76.0	20g	-3060K
8mm	8.4	15.0	87.3	60g	-3080K
10mm	10.5	18.0	89.0	70g	-3100K
12mm	13.0	20.0	108.0	110g	-3120K

Bolt Size	Pilot Dia.	Cutter Dia.	Overall Length	Weight each	Order Code SHR-021
3mm	3.4	6.0	65.0	10g	-3520K
4mm	4.3	8.0	65.0	10g	-3560K
5mm	5.3	10.0	70.0	10g	-3580K
6mm	6.4	11.0	76.0	20g	-3600K
8mm	8.4	15.0	87.3	60g	-3620K
10mm	10.5	18.0	89.0	70g	-3640K
12mm	13.0	20.0	108.0	110g	-3660K

7 Piece Sets

Sizes: M3, M4, M5, M6, M8, M10, M12.
Manufactured to **BS328 : 5 : 1983**.
Supplied in fitted wooden cases.



Threaded Shank



Plain Shank

Number of Pieces	Shank Style	Weight each	Order Code SHR-021
7	Threaded		-9020B
7	Plain		-9010A

**7
PIECES**

GROUP 025 DRILLS - CENTRE/SPOTTING



High Speed Steel Centre Drills



HSS

Designed with spiral flutes and various lengths and forms to give high quality centre holes that suit most applications. 60° inclusive angle.

Manufactured to **BS 328 : Part 2 : 1986, DIN 333A, ISO 866, ISO 2540, ISO 2541.**



Series C100

Size	Pilot Length		Overall Length	Diameter		Order Code
	Min	Max		Body	Pilot	
BS0	3/64"	1/16"	1 1/4"	1/8"	1/32"	-1828M
BS1	1/16"	5/64"	1 1/2"	1/8"	3/64"	-1829A
BS2	5/64"	3/32"	1 3/4"	3/16"	1/16"	-1830B
BS3	1/8"	5/32"	2"	1/4"	3/32"	-1831C
BS4	5/32"	3/16"	2 1/4"	5/16"	1/8"	-1832D
BS5	1/4"	9/32"	2 1/2"	7/16"	3/16"	-1833E
BS6	5/16"	3/8"	3"	5/8"	1/4"	-1835G
BS7	13/32"	15/32"	3 1/2"	3/4"	5/16"	-1836H

High Speed Steel Centre Drills

HSS

Designed with spiral flutes and various lengths and forms to give high quality centre holes that suit most applications. 60° inclusive angle. Manufactured to **BS 328 : Part 2 : 1986, DIN 333A, ISO 866, ISO 2540, ISO 2541.**



Diameter		Pilot Length		Overall Length	Weight each	Order Code
Body	Pilot	Min	Max			
3.15	0.80	1.1	1.5	31.5	2g	-1843X
3.15	1.00	1.3	1.9	31.5	2g	-1844A
3.15	1.25	1.6	2.2	31.5	3g	-1845B
4.00	1.60	2.0	2.8	35.5	3g	-1846C
5.00	2.00	2.5	3.3	40.0	5g	-1847D
6.30	2.50	3.1	4.1	45.0	9g	-1848E
8.00	3.15	3.9	4.9	50.0	7g	-1849F
10.00	4.00	5.0	6.2	56.0	28g	-1850G
12.50	5.00	6.3	7.5	63.0	45g	-1851H
16.00	6.30	8.0	9.2	71.0	71g	-1852J
20.00	8.00	10.0	11.5	83.0	102g	-1852M
25.00	10.00	12.8	14.2	103.0	197g	-1852N

HSS Bell Type Centre Drills

Manufactured to **BS 328 :**

Part 2 : 1986, DIN 333, ISO 2540.

EXTENDED RANGE

HSS



Inch Series

Size	Diameter		Overall Length	Order Code
	Body	Pilot		
BS1B	1/8"	3/64"	1 1/2"	-1853A
BS2B	3/16"	1/16"	1 3/4"	-1854B
BS3B	1/4"	3/32"	2"	-1855C
BS4B	1/8"	5/16"	2 1/4"	-1856D
BS5B	7/16"	5/32"	2 1/2"	-1858F

Metric Series

Diameter		Overall Length	Order Code
Body	Pilot		
4.00	1.00	35.50	-1861K
5.00	1.25	40.00	-1861L
6.30	1.60	45.00	-1861N
8.00	2.00	50.00	-1861P
10.00	2.50	56.00	-1861Q
11.20	3.15	60.00	-1861R
14.00	4.00	67.00	-1861S
18.00	5.00	75.00	-1861T
20.00	6.30	80.00	-1861V

High Speed Steel Extra Length Centre Drills

Ground flute, for drilling centre holes on components prior to machining. Extra length drills particularly useful for drilling centre holes in recesses. Manufactured to

BS 328 : Part 1 : 1986, DIN333A : ISO 86, ISO2540, ISO2541.

Diameter (mm)		Overall Length	Weight each	Order Code
Body	Point			
4.00	1.00	120		-1866H
5.00	1.60	120		-1866K
6.00	2.00	120		-1866N

KENNEDY Carbide Centre Drills

Used to produce 60° centres in components for subsequent manufacturing operations to be carried out. Tool life is extended and difficult materials may be drilled.

60° included angle.

118° drill point.

Manufactured

to **BS 328.**



CARBIDE



Tolerances

Size	Diameter		Overall Length	Weight each	Order Code
	Body	Drill			
No.1	1/8"	3/64"	1 1/2"	10g	-9010K
No.2	3/16"	5/64"	1 7/8"	10g	-9020K
No.3	1/4"	7/64"	2"	20g	-9030K
No.4	5/16"	1/8"	2 1/8"	30g	-9040K
No.5	7/16"	3/16"	2 3/4"	70g	-9050K
No.6	1/2"	7/32"	3"	90g	-9060K

SHERWOOD Carbide Centre Drills

CARBIDE

NEW

Used to produce 60° centres in components for subsequent manufacturing operations to be carried out. Tool life is extended and difficult materials may be drilled.

60° included angle.

118° drill point.

Manufactured

to **BS 328.**



Inch

Size	Pilot Length		Overall Length	Diameter		Order Code
	Min	Max		Body	Pilot	
BS1	1/16"	5/64"	1 1/2"	1/8"	3/64"	-8010K
BS2	5/64"	3/32"	1 3/4"	3/16"	1/16"	-8020K
BS3	1/8"	5/32"	2"	1/4"	3/32"	-8030K
BS4	5/32"	3/16"	2 1/4"	5/16"	1/8"	-8040K
BS5	1/4"	9/32"	2 1/2"	7/16"	3/16"	-8050K
BS6	5/16"	3/8"	3"	5/8"	1/4"	-8060K

Metric

Diameter		Pilot Length		Overall Length	Weight each	Order Code
Body	Pilot	Min	Max			
4.00	1.60	2.0	2.8	35.5		-8110K
5.00	2.00	2.5	3.3	40.0		-8120K
6.30	2.50	3.1	4.1	45.0		-8130K
8.00	3.15	3.9	4.9	50.0		-8140K
10.00	4.00	5.0	6.2	56.0		-8150K
12.50	5.00	6.3	7.5	63.0		-8160K
16.00	6.30	8.0	9.2	71.0		-8180K

Carbide Spotting Drills

CARBIDE

NEW

Designed for close tolerance hole location.

Carbide spot drills are more wear resistant than HSS spot drills. Suitable for continuous production on aluminium, plastics, free cutting steels, cast iron, titanium and some aerospace materials. The stability of carbide makes the tool more rigid and less likely to deflect, maintaining a higher level of accuracy. Operators should note that continuous heavy shock loading may cause the tool to fail due to its brittleness.



Diameter (mm)	Flute Length	Overall Length	Weight each	Order Code
4.00	12	46		-8540K
6.00	16	66		-8560K
8.00	21	79		-8580K
10.00	24	89		-8600K
12.00	30	102		-8620K
16.00	35	115		-8660K
20.00	40	131		-8700K

HSS





High Speed Steel Spotting Drills

HSS

Special drill for accurate and fast spotting on NC machines, jig drills and other capital-intensive boring machines. For countersinking and chamfering of tapping holes in one operation.

Please note: Only suitable for shallow depth drilling.

Series C520 - 90° Point



Diameter (mm)	Flute Length	Overall Length	Weight per 5	Order Code SHR-025
4.00	12	46		-2528Z
6.00	16	66	100g	-2529A
8.00	21	79	155g	-2530B
10.00	24	89	265g	-2531C
12.00	30	102	434g	-2532D
16.00	35	115	175g	-2533E
20.00	40	131	298g	-2534F

Series C530 - 120° Point



Diameter (mm)	Flute Length	Overall Length	Weight per 5	Order Code SHR-025
6.00	20	66	100g	-2535G
8.00	16	79	155g	-2536H
10.00	21	89	265g	-2537J
12.00	30	102	434g	-2538K
16.00	35	115	175g	-2539L
20.00	40	131	298g	-2540M

High Speed Steel SCD Drills

Stub centering drills designed for sheet metal drilling and spot centring operations with a strong supporting web and a reduced chisel edge to help penetration.

HSS

NEW



Series S510 - 135° Split Point

Diameter (Inch)	Flute Length	Overall Length	Order Code SHR-025
3/32"	9/16"	1 11/16"	-1400C
1/8"	11/16"	1 15/16"	-1400F
5/32"	1 1/16"	2 5/32"	-1400J

Series S510 Continued

Diameter (Inch)	Flute Length	Overall Length	Order Code SHR-025
3/16"	1 1/16"	2 7/16"	-1400M
1/4"	3/4"	2 3/4"	-1400Q

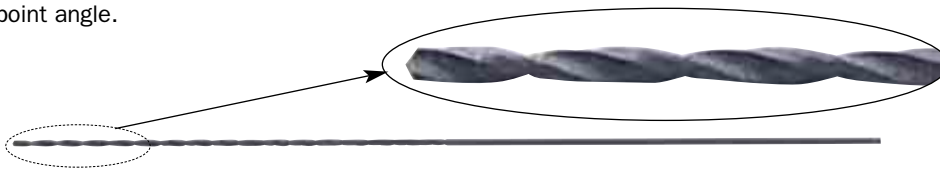
HSS Straight Shank Quick Spiral, Extra Length Vent Drills

Sherwood HSS quick spiral extra length Vent drills are designed for drilling the initial vent hole in aluminium tyre moulds, and are also used in the tyre industry for clean-out work post production where the high helix and extra reach are ideal for the efficient evacuation of waste rubber. Manufactured to works standard. 118° point angle.

HSS

QUICK SPIRAL

NEW



Metric

Diameter (mm)	Flute Length	Overall Length	Order Code SHR-025
0.60	40.0mm	60mm	-2180D
0.70	40.0	76	-2180H
0.75	50.0	100	-2181P

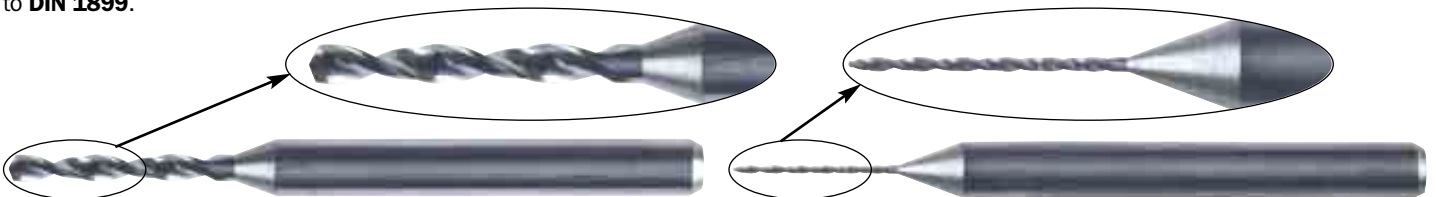
Inch

Diameter	Flute Length	Overall Length	Order Code SHR-025
3/64" (0.0469)	50.0mm	150mm	-2177R
1/16" (0.0625)	76.0mm	101mm	-2178D

Carbide Printed Circuit Board Drills

Solid carbide printed circuit board drills. Suitable for drilling through printed circuit boards. Shank diameter 3.175mm, 38mm overall length. Manufactured to **DIN 1899**.

CARBIDE



Metric

Diameter (mm)	Flute Length	Order Code SHR-158
0.40	5.5mm	-3004D
0.45	5.5mm	-3005E
0.50	5.5mm	-3006F
0.55	7.0mm	-3007G
0.60	7.0mm	-3008H
0.65	7.0mm	-3009J
0.70	9.5mm	-3010K
0.75	9.5mm	-3011L
0.80	9.5mm	-3012M

Metric Continued

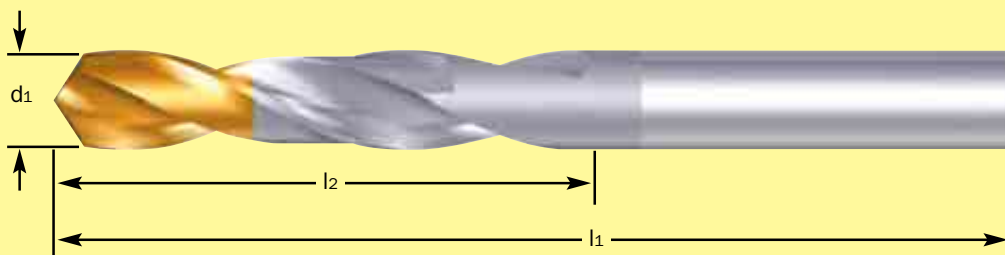
Diameter (mm)	Flute Length	Order Code SHR-158
0.85	9.5mm	-3013N
0.90	9.5mm	-3014P
0.95	9.5mm	-3015Q
1.00	10.5mm	-3016R
1.10	10.5mm	-3018T
1.20	10.5mm	-3020W
1.30	10.5mm	-3022Y
1.40	10.5mm	-3025A
1.50	10.0mm	-3027C

PRODUCTS ARE ONLY AVAILABLE VIA YOUR DISTRIBUTOR

GROUP 025 DRILLS - STUB

Dimensions - Stub Drills to BS 328 / DIN 1897

The majority of stub drills feature in this catalogue comply with the above standards in terms of overall and working dimensions. The tables of sizes below apply to all of these products. In order to save space in the catalogue we are not repeating these dimensions after this page. Any drills which are made to different standards/dimensions will have them listed accordingly in the tables for those products.



d1 mm h8	Inch	Inch Dec.	l2 mm	l1 mm	d1 mm h8	Inch	Inch Dec.	l2 mm	l1 mm	d1 mm h8	Inch	Inch Dec.	l2 mm	l1 mm	d1 mm h8	Inch	Inch Dec.	l2 mm	l1 mm
0.50		0.0196	3	20	3.80		0.1496	22	55	7.40		0.2913	34	74	11.30		0.4448	47	95
0.60		0.0236	3.5	21	3.90		0.1535	22	55	7.50		0.2952	34	74	11.50		0.4527	47	95
0.70		0.0275	4.5	23	3.97	5/32	0.1562	22	55	7.60		0.2992	37	79	11.60		0.4566	47	95
0.79	1/32	0.0312	5	24	4.00		0.1574	22	55	7.70		0.3031	37	79	11.70		0.4606	47	95
0.80		0.0314	5	24	4.10		0.1614	22	55	7.80		0.3070	37	79	11.80		0.4645	47	95
0.90		0.0354	5.5	25	4.20		0.1653	22	55	7.90		0.3110	37	79	11.90		0.4685	51	102
1.00		0.0393	6	26	4.30		0.1692	24	58	7.94	5/16	0.3125	37	79	12.00		0.4724	51	102
1.10		0.0433	7	28	4.37	11/64	0.1720	24	58	8.00		0.3149	37	79	12.10		0.4763	51	102
1.19	3/64	0.0468	8	30	4.40		0.1732	24	58	8.10		0.3188	37	79	12.20		0.4803	51	102
1.20		0.0472	8	30	4.50		0.1771	24	58	8.20		0.3228	37	79	12.50		0.4921	51	102
1.30		0.0511	8	30	4.60		0.1811	24	58	8.30		0.3267	37	79	12.70	1/2	0.5000	51	102
1.40		0.0551	9	32	4.70		0.1850	24	58	8.40		0.3307	37	79	13.00		0.5118	51	102
1.50		0.0590	9	32	4.76	3/16	0.1874	26	62	8.50		0.3346	37	79	13.50		0.5314	54	107
1.59	1/16	0.0625	10	34	4.80		0.1889	26	62	8.60		0.3385	40	84	14.00		0.5511	54	107
1.60		0.0629	10	34	4.90		0.1929	26	62	8.70		0.3425	40	84	14.29	9/16	0.5625	56	111
1.70		0.0669	10	34	5.00		0.1968	26	62	8.73	11/32	0.3437	40	84	14.50		0.5708	56	111
1.80		0.0708	11	36	5.10		0.2007	26	62	8.80		0.3464	40	84	15.00		0.5905	56	111
1.90		0.0748	11	36	5.16	13/64	0.2031	26	62	8.90		0.3503	40	84	15.50		0.6102	58	115
1.98	5/64	0.0779	12	38	5.20		0.2047	26	62	9.00		0.3543	40	84	15.88	5/8	0.6251	58	115
2.00		0.0787	12	38	5.30		0.2086	26	62	9.10		0.3582	40	84	16.00		0.6299	58	115
2.10		0.0826	12	38	5.40		0.2125	28	66	9.20		0.3622	40	84	16.50		0.6496	60	119
2.20		0.0866	13	40	5.50		0.2165	28	66	9.30		0.3661	40	84	17.00		0.6692	60	119
2.25		0.0885	13	40	5.56	7/32	0.2188	28	66	9.40		0.3700	40	84	17.46	11/16	0.6874	62	123
2.30		0.0905	13	40	5.60		0.2204	28	66	9.50		0.3740	40	84	17.50		0.6889	62	123
2.38	3/32	0.0937	14	43	5.70		0.2244	28	66	9.53	3/8	0.3751	43	89	18.00		0.7086	62	123
2.40		0.0944	14	43	5.80		0.2283	28	66	9.60		0.3779	43	89	18.50		0.7283	64	127
2.50		0.0984	14	43	5.90		0.2322	28	66	9.70		0.3818	43	89	19.00		0.7480	64	127
2.60		0.1023	14	43	5.95	15/64	0.2342	28	66	9.80		0.3858	43	89	19.05	3/4	0.7500	66	131
2.65		0.1043	14	43	6.00		0.2362	28	66	9.90		0.3897	43	89	19.50		0.7677	66	131
2.70		0.1062	16	46	6.10		0.2401	31	70	10.00		0.3937	43	89	20.00		0.7874	66	131
2.78	7/64	0.1094	16	46	6.20		0.2440	31	70	10.10		0.3976	43	89	20.50		0.8070	68	136
2.80		0.1102	16	46	6.30		0.2480	31	70	10.20		0.4015	43	89	20.64	13/16	0.8125	68	136
2.90		0.1141	16	46	6.35	1/4	0.2500	31	70	10.30		0.4055	43	89	21.00		0.8267	68	136
3.00		0.1181	16	46	6.40		0.2519	31	70	10.32	13/32	0.4062	43	89	22.00		0.8661	70	141
3.10		0.1220	18	49	6.50		0.2559	31	70	10.40		0.4094	43	89	22.23	7/8	0.8751	70	141
3.18	1/8	0.1251	18	49	6.60		0.2598	31	70	10.50		0.4133	43	89	23.00		0.9055	72	146
3.20		0.1259	18	49	6.70		0.2637	31	70	10.60		0.4173	43	89	23.81	15/16	0.9374	75	151
3.25		0.1279	18	49	6.80		0.2677	34	74	10.70		0.4212	47	95	24.00		0.9448	75	151
3.30		0.1299	18	49	6.90		0.2716	34	74	10.80		0.4251	47	95	25.00		0.9842	75	151
3.40		0.1338	20	52	7.00		0.2755	34	74	10.90		0.4291	47	95	25.40	1"	1.0000	78	156
3.50		0.1377	20	52	7.10		0.2795	34	74	11.00		0.4330	47	95	26.99	1 1/16	1.0625	81	162
3.57	9/64	0.1405	20	52	7.14	9/32	0.2811	34	74	11.10		0.4370	47	95	28.58	1 1/8	1.1251	84	168
3.60		0.1417	20	52	7.20		0.2834	34	74	11.11	7/16	0.4374	47	95	30.16	1 3/16	1.1874	87	174
3.70		0.1456	20	52	7.30		0.2874	34	74	11.20		0.4409	47	95	31.75	1 1/4	1.2500	90	180

SHERWOOD QUALITY CUTTING TOOLS High Speed Steel General Purpose Stub Drills - Bright Finish

General purpose drills for use on automatics and turret lathes. Suitable for drilling steels, cast iron, alloy steel and malleable cast iron. Point angle: 118°, helix angle: normal, web thickness: standard, relief angle: 10°-20°, tolerance of diameter: h8, tolerance of shank: f11.

Manufactured to BS 328: Part 1: 1986/DIN 1897.



Metric							
Dia. (mm)	Order Code SHR-025	Dia. (mm)	Order Code SHR-025	Dia. (mm)	Order Code SHR-025	Dia. (mm)	Order Code SHR-025
2.00	-1170D	3.30	-1170W	4.90	-1171S	8.00	-1173Z
2.50	-1170L	3.50	-1170Z	5.00	-1171V	8.50	-1174J
3.00	-1170R	4.00	-1171E	6.00	-1172K	10.00	-1175K
3.20	-1170T	4.20	-1171H	7.00	-1172Y	12.00	-1177M

NEW

HSS



For Dimensions
See Above



High Speed Steel General Purpose Stub Drills

General purpose drills for use on automatics and turret lathes. Suitable for drilling steels, cast iron, alloy steel and malleable cast iron. Point angle: 118°, helix angle: normal, web thickness: standard, relief angle: 10° - 20°, tolerance of diameter: h8, tolerance of shank: f11.
Manufactured to **BS 328: Part 1: 1986/DIN 1897**.



HSS



For Dimensions
See Page 24

EXTENDED RANGE



Series S100 Metric

Dia. (mm)	Order Code SHR-025
1.00	-1227H
1.50	-1233P
1.80	-1236S
2.00	-1240X
2.10	-1242N
2.20	-1243A
2.30	-1245C
2.40	-1246D
2.50	-1248F
2.60	-1250H
2.65	-1251J
2.70	-1252K
2.80	-1253L
2.90	-1255N
3.00	-1257Q
3.10	-1258R
3.20	-1259S
3.30	-1260T
3.40	-1261V
3.50	-1262W
3.60	-1263X
3.70	-1264Y
3.80	-1265N
3.90	-1266A
4.00	-1267B
4.10	-1268C
4.20	-1269D
4.30	-1270E
4.40	-1271F
4.50	-1272G
4.60	-1273H
4.70	-1274J
4.80	-1275K
4.90	-1276L
5.00	-1277M
5.10	-1278N
5.20	-1279P
5.30	-1280Q
5.40	-1281R
5.50	-1282S

Dia. (mm)	Order Code SHR-025
5.60	-1283T
5.70	-1284V
5.80	-1285W
5.90	-1286X
6.00	-1287Y
6.10	-1288N
6.20	-1289A
6.30	-1290B
6.40	-1291C
6.50	-1292D
6.60	-1293E
6.70	-1294F
6.80	-1295G
6.90	-1296H
7.00	-1297J
7.10	-1298K
7.20	-1299L
7.30	-1300M
7.40	-1301N
7.50	-1302P
7.60	-1303Q
7.70	-1304R
7.80	-1305S
7.90	-1306T
8.00	-1307V
8.10	-1308W
8.20	-1309X
8.30	-1310Y
8.40	-1311N
8.50	-1312A
8.60	-1313B
8.70	-1314C
8.80	-1315D
8.90	-1316E
9.00	-1317F
9.10	-1318G
9.20	-1319H
9.40	-1321K
9.50	-1322L
9.60	-1323M

Dia. (mm)	Order Code SHR-025
9.70	-1324N
9.80	-1325P
10.00	-1327R
10.10	-1328S
10.20	-1329T
10.30	-1330V
10.40	-1331W
10.50	-1332X
10.80	-1335A
11.00	-1337C
11.10	-1338D
11.50	-1342H
12.00	-1347N
12.20	-1349Q
12.50	-1352T
12.60	-1353V
13.00	-1357N
13.50	-1359B
14.00	-1361D
14.10	-1361G
14.50	-1362E
14.70	-1362H
14.80	-1362R
15.00	-1363F
15.50	-1364G
16.00	-1365H
16.50	-1366J
17.00	-1367K
17.50	-1368L
18.00	-1369M
18.50	-1370N
19.00	-1371P
19.50	-1372Q
20.00	-1373R
21.00	-1374S
22.00	-1375T
23.00	-1376V
24.00	-1377W
25.00	-1378X

Series S100 Inch Size

Dia. (in)	Order Code SHR-025
1/16"	-1194C
5/64"	-1194D
3/32"	-1194E
7/64"	-1194F
1/8"	-1194G
9/64"	-1194H
5/32"	-1194J
11/64"	-1194K
3/16"	-1194L
13/64"	-1194M
7/32"	-1194N
15/64"	-1194P
1/4"	-1194Q
17/64"	-1194R
9/32"	-1194S
5/16"	-1194V
21/64"	-1194W
11/32"	-1194X
3/8"	-1194Z
13/32"	-1195B
7/16"	-1195D
1/2"	-1195H
9/16"	-1195M
5/8"	-1195R
3/4"	-1196A
1"	-1196S

SWISS+TECH High Speed Steel TiN Coated Stub Drills Metric

General purpose drill for use on automatics and turret lathes. Suitable for drilling steels, cast iron, alloy steel and malleable cast iron. TiN coating provides longer tool life or increased cutting speeds. Point angle: 118°, helix angle: normal, web thickness: normal, tolerance of diameter: h8, tolerance of shank: f11.
Manufactured to **BS 328, DIN 1897 RN**.



HSS TiN

EXTENDED RANGE



For Dimensions
See Page 24



Series 2001 Metric

Dia. (mm)	Order Code SWT-125
1.00	-2010A
1.10	-2011A
1.20	-2012A
1.30	-2013A
1.40	-2014A
1.50	-2015A
1.60	-2016A
1.80	-2018A
1.90	-2019A
2.00	-2020A
2.10	-2021A
2.40	-2024A
2.50	-2025A
3.00	-2030A
3.20	-2032A

Dia. (mm)	Order Code SWT-125
3.30	-2033A
3.40	-2034A
3.50	-2035A
3.80	-2038A
4.00	-2040A
4.20	-2042A
4.30	-2043A
4.50	-2045A
4.70	-2047A
4.80	-2048A
5.00	-2050A
5.10	-2051A
5.20	-2052A
5.50	-2055A

Dia. (mm)	Order Code SWT-125
5.60	-2056A
6.00	-2060A
6.10	-2061A
6.20	-2062A
6.30	-2063A
6.40	-2064A
6.50	-2065A
6.80	-2068A
7.00	-2070A
7.50	-2075A
7.90	-2079A
8.00	-2080A
8.20	-2082A
8.50	-2085A

Dia. (mm)	Order Code SWT-125
8.60	-2086A
8.70	-2087A
9.00	-2090A
9.10	-2091A
9.20	-2092A
9.40	-2094A
9.50	-2095A
10.00	-2100A
10.20	-2102A
10.50	-2105A
11.00	-2110A
11.50	-2115A
12.00	-2120A
13.00	-2130A

PRODUCTS ARE ONLY AVAILABLE VIA YOUR DISTRIBUTOR

SWISS+TECH *HSS-Co. 8% Heavy Duty Cobalt Stub Drills*

Heavy duty drill made of 8% cobalt material with excellent heat resistance. For drilling steels up to 1,400N/mm², stainless steel, heat resistant steels and bronze. Ideally suited for volume production on automatics. Point angle: 135°, helix angle: normal, web thickness: strengthened, tolerance of diameter: h8, tolerance of shank: f11. Manufactured to **BS 328, DIN 1897RN**. Point to **DIN 1412C**.



HSS-Co. 8%

EXTENDED RANGE

DIN 1897
BS 328
For Dimensions
See Page 24



Series 2010 Metric

Dia. (mm)	Order Code SWT-125	Dia. (mm)	Order Code SWT-125	Dia. (mm)	Order Code SWT-125	Dia. (mm)	Order Code SWT-125
1.00	-2210A	3.40	-2234A	5.80	-2258A	8.20	-2282A
1.10	-2211A	3.50	-2235A	5.90	-2259A	8.30	-2283A
1.20	-2212A	3.60	-2236A	6.00	-2260A	8.40	-2284A
1.30	-2213A	3.70	-2237A	6.10	-2261A	8.50	-2285A
1.40	-2214A	3.80	-2238A	6.20	-2262A	8.70	-2287A
1.50	-2215A	3.90	-2239A	6.30	-2263A	8.80	-2288A
1.60	-2216A	4.00	-2240A	6.40	-2264A	9.00	-2290A
1.70	-2217A	4.10	-2241A	6.50	-2265A	9.40	-2294A
1.80	-2218A	4.20	-2242A	6.60	-2266A	9.50	-2295A
2.00	-2220A	4.30	-2243A	6.70	-2267A	10.00	-2300A
2.10	-2221A	4.50	-2245A	6.80	-2268A	10.20	-2302A
2.30	-2223A	4.60	-2246A	7.00	-2270A	10.40	-2304A
2.40	-2224A	4.70	-2247A	7.10	-2271A	10.50	-2305A
2.50	-2225A	4.80	-2248A	7.20	-2272A	11.00	-2310A
2.60	-2226A	4.90	-2249A	7.40	-2274A	11.50	-2315A
2.80	-2228A	5.00	-2250A	7.50	-2275A	11.80	-2318A
2.90	-2229A	5.10	-2251A	7.70	-2277A	12.00	-2320A
3.00	-2230A	5.20	-2252A	7.80	-2278A	12.10	-2321A
3.10	-2231A	5.50	-2255A	7.90	-2279A	12.20	-2322A
3.20	-2232A	5.60	-2256A	8.00	-2280A	12.50	-2325A
3.30	-2233A	5.70	-2257A	8.10	-2281A	13.00	-2330A

HSS-Co. 8% TiN Coated Heavy Duty Stub Drills

Heavy duty drill made of 8% cobalt material with excellent heat resistance. For drilling steels up to 1,400N/mm², stainless steel, heat resistant steels and bronze. Ideally suited for volume production on automatics. TiN coating provides longer tool life or increased cutting speeds. Point angle: 135°, helix angle: normal, web thickness: strengthened, tolerance of diameter: h8, tolerance of shank: f11. Manufactured to **BS 328, DIN 1897RN**. Point to **DIN 1412C**.

HSS-Co. 8%

TiN

EXTENDED RANGE

DIN 1897
BS 328
For Dimensions
See Page 24



Series 2020 Metric

Dia. (mm)	Order Code SWT-125	Dia. (mm)	Order Code SWT-125	Dia. (mm)	Order Code SWT-125	Dia. (mm)	Order Code SWT-125
1.00	-2410A	3.60	-2436A	5.90	-2459A	8.50	-2485A
1.20	-2412A	3.70	-2437A	6.00	-2460A	9.00	-2490A
1.40	-2414A	3.80	-2438A	6.10	-2461A	9.20	-2492A
1.50	-2415A	3.90	-2439A	6.20	-2462A	9.50	-2495A
1.60	-2416A	4.00	-2440A	6.30	-2463A	9.60	-2496A
1.70	-2417A	4.10	-2441A	6.40	-2464A	9.70	-2497A
1.80	-2418A	4.20	-2442A	6.50	-2465A	9.80	-2498A
1.90	-2419A	4.30	-2443A	6.60	-2466A	10.00	-2500A
2.00	-2420A	4.40	-2444A	6.70	-2467A	10.20	-2502A
2.20	-2422A	4.50	-2445A	6.80	-2468A	10.60	-2506A
2.30	-2423A	4.70	-2447A	6.90	-2469A	11.00	-2510A
2.40	-2424A	4.80	-2448A	7.00	-2470A	11.10	-2511A
2.50	-2425A	4.90	-2449A	7.10	-2471A	11.20	-2512A
2.60	-2426A	5.00	-2450A	7.20	-2472A	11.50	-2515A
2.70	-2427A	5.10	-2451A	7.40	-2474A	11.70	-2517A
2.80	-2428A	5.20	-2452A	7.50	-2475A	11.80	-2518A
3.00	-2430A	5.30	-2453A	7.70	-2477A	12.00	-2520A
3.10	-2431A	5.40	-2454A	7.80	-2478A	12.10	-2521A
3.20	-2432A	5.50	-2455A	7.90	-2479A	12.20	-2522A
3.30	-2433A	5.60	-2456A	8.00	-2480A	12.30	-2523A
3.40	-2434A	5.70	-2457A	8.10	-2481A	12.50	-2525A
3.50	-2435A	5.80	-2458A	8.20	-2482A	13.00	-2530A

KENNEDY *Carbide*
QUALITY INDUSTRIAL TOOLING *Stub Length Drills*

For drilling into steel, cast steel, cast iron, chilled cast iron, malleable cast iron, non-ferrous materials and abrasive plastic.
Point angle: 118°, helix angle: 30°, tolerance of diameter: h7, tolerance of shank: h6.
Manufactured to **DIN 6539**.



CARBIDE

Tolerances

Cutting Dia. +0.000mm - 0.015mm.
Shank Dia. +0.000mm - 0.030mm.



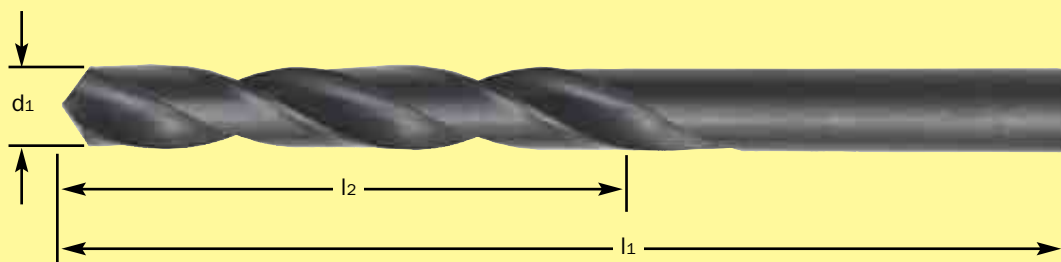
Metric									
Diameter (mm)	Flute Length	Overall Length	Weight each	Order Code KEN-158	Diameter (mm)	Flute Length	Overall Length	Weight each	Order Code KEN-158
1.0	6.0	26	40g	-3100K	4.1	22.0	55	50g	-3410K
1.1	6.0	26	40g	-3110K	4.2	22.0	55	50g	-3420K
1.2	8.0	30	40g	-3120K	4.3	24.0	58	50g	-3430K
1.3	8.0	30	40g	-3130K	4.4	24.0	58	50g	-3440K
1.4	9.0	32	40g	-3140K	4.5	24.0	58	50g	-3450K
1.5	9.0	32	40g	-3150K	4.6	24.0	58	50g	-3460K
1.6	10.0	34	40g	-3160K	4.7	24.0	58	50g	-3470K
1.7	10.0	34	40g	-3170K	4.8	26.0	62	50g	-3480K
1.8	11.0	36	40g	-3180K	4.9	26.0	62	55g	-3490K
1.9	11.0	36	40g	-3190K	5.0	26.0	62	55g	-3500K
2.0	12.0	38	40g	-3200K	5.1	26.0	62	55g	-3510K
2.1	12.0	38	40g	-3210K	5.2	26.0	62	55g	-3520K
2.2	13.0	40	40g	-3220K	5.4	28.0	66	55g	-3540K
2.3	13.0	40	40g	-3230K	5.5	28.0	66	55g	-3550K
2.4	14.0	43	40g	-3240K	5.6	28.0	66	55g	-3560K
2.5	14.0	43	40g	-3250K	5.8	28.0	66	55g	-3580K
2.6	14.0	43	40g	-3260K	6.0	28.0	66	55g	-3600K
2.7	16.0	46	40g	-3270K	6.1	31.0	70	60g	-3610K
2.8	16.0	46	40g	-3280K	6.2	31.0	70	60g	-3620K
2.9	16.0	46	40g	-3290K	6.3	31.0	70	60g	-3630K
3.0	16.0	46	40g	-3300K	6.5	31.0	70	60g	-3650K
3.1	18.0	49	45g	-3310K	6.8	31.0	70	60g	-3680K
3.2	18.0	49	45g	-3320K	7.0	34.0	74	60g	-3700K
3.3	18.0	49	45g	-3330K	7.5	34.0	74	60g	-3750K
3.4	20.0	52	45g	-3340K	8.0	37.0	79	120g	-3800K
3.5	20.0	52	45g	-3350K	8.5	37.0	79	120g	-3850K
3.6	20.0	52	45g	-3360K	9.0	40.0	84	125g	-3900K
3.7	20.0	52	45g	-3370K	9.5	40.0	84	125g	-3950K
3.8	22.0	55	45g	-3380K	10.0	43.0	89	170g	-4100K
3.9	22.0	55	45g	-3390K	11.0	47.0	95	195g	-4110K
4.0	22.0	55	45g	-3400K	12.0	57.0	102	270g	-4120K



PRODUCTS ARE ONLY AVAILABLE VIA YOUR DISTRIBUTOR

Dimensions - Jobber Drills to BS 328 / DIN 338

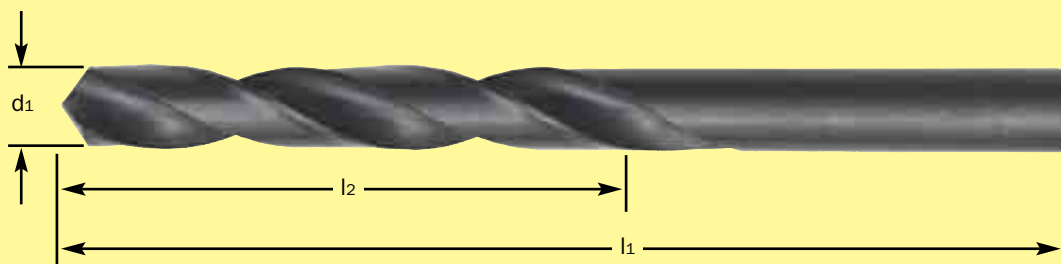
The majority of jobber drills featured in this catalogue comply with the above standards in terms of overall and working dimensions. The tables of sizes below apply to all of these products. In order to save space in the catalogue we are not repeating these dimensions after this page. Any drills which are made to different standards/dimensions will have them listed accordingly in the tables for those products.



d1 mm	No/ h8	Inch Letter	Dec.	l2 mm	l1 mm	d1 mm	No/ h8	Inch Letter	Dec.	l2 mm	l1 mm	d1 mm	No/ h8	Inch Letter	Dec.	l2 mm	l1 mm	d1 mm	No/ h8	Inch Letter	Dec.	l2 mm	l1 mm
0.2		0.0078		2.5	19	0.94	63	0.037		11	32	2.15		0.0846		27	53	3.66	27	0.144		39	70
0.25		0.0098		3	19	0.95		0.0374		11	32	2.18	44	0.0858		27	53	3.7		0.1456		39	70
0.3		0.0118		3	19	0.97	62	0.0381		12	34	2.2		0.0866		27	53	3.73	26	0.1468		39	70
0.32		0.0125		4	19	0.98		0.0385		12	34	2.25		0.0885		27	53	3.75		0.1476		39	70
0.34	80	0.0133		4	19	0.99	61	0.0389		12	34	2.26	43	0.0889		27	53	3.8		0.1496		43	75
0.35		0.0137		4	19	1		0.0393		12	34	2.3		0.0905		27	53	3.8	25	0.1496		43	75
0.37	79	0.0145		4	19	1.02	60	0.0401		12	34	2.35		0.0925		27	53	3.86	24	0.1519		43	75
0.38		0.0149		4	19	1.04	59	0.0409		12	34	2.38	3/32	0.0937		30	57	3.9		0.1535		43	75
0.4	1/64	0.0157		5	20	1.05		0.0413		12	34	2.38	42	0.0937		30	57	3.91	23	0.1539		43	75
0.4		0.0157		5	20	1.07	58	0.0421		14	36	2.4		0.0944		30	57	3.97	5/32	0.1562		43	75
0.41	78	0.0161		5	20	1.09	57	0.0429		14	36	2.44	41	0.096		30	57	3.99	22	0.157		43	75
0.42		0.0165		5	20	1.1		0.0433		14	36	2.45		0.0964		30	57	4		0.1574		43	75
0.45		0.0177		5	20	1.15		0.0452		14	36	2.49	40	0.098		30	57	4.04	21	0.159		43	75
0.46	77	0.0181		5	20	1.18	56	0.0464		14	36	2.5		0.0984		30	57	4.09	20	0.161		43	75
0.48		0.0188		5	20	1.19	3/64	0.0468		16	38	2.53	39	0.0996		30	57	4.1		0.1614		43	75
0.5		0.0196		6	22	1.2		0.0472		16	38	2.55		0.1003		30	57	4.2		0.1653		43	75
0.51	76	0.02		6	22	1.25		0.0492		16	38	2.58	38	0.1015		30	57	4.22	19	0.1661		43	75
0.52		0.0204		6	22	1.3		0.0511		16	38	2.6		0.1023		30	57	4.25		0.1673		43	75
0.53	75	0.0208		6	22	1.32	55	0.0519		16	38	2.64	37	0.1039		30	57	4.3		0.1692		47	80
0.55		0.0216		7	24	1.35		0.0531		18	40	2.65		0.1043		30	57	4.31	18	0.1696		47	80
0.57	74	0.0224		7	24	1.4		0.0551		18	40	2.7		0.1062		33	61	4.37	11/64	0.172		47	80
0.58		0.0228		7	24	1.4	54	0.0551		18	40	2.71	36	0.1066		33	61	4.39	17	0.1728		47	80
0.6		0.0236		7	24	1.45		0.057		18	40	2.75		0.1082		33	61	4.4		0.1732		47	80
0.61	73	0.024		8	26	1.5		0.059		18	40	2.78	7/64	0.1094		33	61	4.5		0.1771		47	80
0.62		0.0244		8	26	1.51	53	0.0594		20	43	2.79	35	0.1098		33	61	4.5	16	0.1771		47	80
0.64	72	0.0251		8	26	1.55		0.061		20	43	2.8		0.1102		33	61	4.57	15	0.1799		47	80
0.65		0.0255		8	26	1.59	1/16	0.0625		20	43	2.82	34	0.111		33	61	4.6		0.1811		47	80
0.66	71	0.0259		8	26	1.6		0.0629		20	43	2.85		0.1122		33	61	4.62	14	0.1818		47	80
0.68		0.0267		9	28	1.61	52	0.0633		20	43	2.87	33	0.1129		33	61	4.7		0.185		47	80
0.7		0.0275		9	28	1.65		0.0649		20	43	2.9		0.1141		33	61	4.7	13	0.185		47	80
0.71	70	0.0279		9	28	1.7		0.0669		20	43	2.95		0.1161		33	61	4.75		0.187		47	80
0.72		0.0283		9	28	1.7	51	0.0669		22	46	2.95	32	0.1161		33	61	4.76	3/16	0.1874		52	86
0.74	69	0.0291		9	28	1.75		0.0688		22	46	3		0.1181		33	61	4.8		0.1889		52	86
0.75		0.0295		9	28	1.78	50	0.07		22	46	3.05	31	0.12		36	65	4.8	12	0.1889		52	86
0.78		0.0307		10	30	1.8		0.0708		22	46	3.1		0.122		36	65	4.85	11	0.1909		52	86
0.79	1/32	0.0311		10	30	1.85		0.0728		22	46	3.15		0.124		36	65	4.9		0.1929		52	86
0.79	68	0.0311		10	30	1.85	49	0.0728		22	46	3.18	1/8	0.1251		36	65	4.92	10	0.1937		52	86
0.8		0.0314		10	30	1.9		0.0748		22	46	3.2		0.1259		36	65	4.98	9	0.196		52	86
0.81	67	0.0318		10	30	1.93	48	0.0759		24	49	3.25		0.1279		36	65	5		0.1968		52	86
0.82		0.0322		10	30	1.95		0.0767		24	49	3.26	30	0.1283		36	65	5.06	8	0.1992		52	86
0.84	66	0.033		10	30	1.98	5/64	0.0779		24	49	3.3		0.1299		36	65	5.1		0.2007		52	86
0.85		0.0334		10	30	1.99	47	0.0783		24	49	3.4		0.1338		39	70	5.11	7	0.2011		52	86
0.88		0.0346		11	32	2		0.0787		24	49	3.45	29	0.1358		39	70	5.16	13/64	0.2031		52	86
0.89	65	0.035		11	32	2.05		0.0807		24	49	3.5		0.1377		39	70	5.18	6	0.2039		52	86
0.9		0.0354		11	32	2.06	46	0.0811		24	49	3.57	9/64	0.1405		39	70	5.2		0.2047		52	86
0.91	64	0.0358		11	32	2.08	45	0.0818		24	49	3.57	28	0.1405		39	70	5.22	5	0.2055		52	86
0.92		0.0362		11	32	2.1		0.0826		24	49	3.6		0.1417		39	70	5.25		0.2066		52	86

Dimensions - Jobber Drills to BS 328 / DIN 338

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d_1 mm	No/ Letter	Inch Dec.	l_2 mm	l_1 mm	d_1 mm	No/ Letter	Inch Dec.	l_2 mm	l_1 mm	d_1 mm	No/ Letter	Inch Dec.	l_2 mm	l_1 mm	d_1 mm	No/ Letter	Inch Dec.	l_2 mm	l_1 mm
5.3		0.2086	52	86	7.49	M	0.2948	69	109	9.92	$25/64$	0.3905	87	133	13		0.5118	101	151
5.31	4	0.209	57	93	7.5		0.2952	69	109	10		0.3937	87	133	13.1	$33/64$	0.5157	101	151
5.4		0.2125	57	93	7.54	$19/64$	0.2968	75	117	10.08	X	0.3968	87	133	13.1		0.5157	101	151
5.41	3	0.2129	57	93	7.6		0.2992	75	117	10.1		0.3976	87	133	13.2		0.5196	101	151
5.5		0.2165	57	93	7.67	N	0.3019	75	117	10.2		0.4015	87	133	13.25		0.5216	108	160
5.56	$7/32$	0.2188	57	93	7.7		0.3031	75	117	10.25		0.4035	87	133	13.3		0.5236	108	160
5.6		0.2204	57	93	7.75		0.3051	75	117	10.26	Y	0.4039	87	133	13.4		0.5275	108	160
5.61	2	0.2208	57	93	7.8		0.307	75	117	10.3		0.4055	87	133	13.49	$17/32$	0.5311	108	160
5.7		0.2244	57	93	7.9		0.311	75	117	10.32	$13/32$	0.4062	87	133	13.5		0.5314	108	160
5.75		0.2263	57	93	7.94	$5/16$	0.3125	75	117	10.4		0.4094	87	133	13.6		0.5354	108	160
5.79	1	0.2279	57	93	8		0.3149	75	117	10.49	Z	0.4129	87	133	13.7		0.5393	108	160
5.8		0.2283	57	93	8.03	O	0.3161	75	117	10.5		0.4133	87	133	13.75		0.5413	108	160
5.9		0.2322	57	93	8.1		0.3188	75	117	10.6		0.4173	87	133	13.8		0.5433	108	160
5.94	A	0.2338	57	93	8.2		0.3228	75	117	10.7		0.4212	94	142	13.89	$35/64$	0.5468	108	160
5.95	$15/64$	0.2342	57	93	8.2	P	0.3228	75	117	10.72	$27/64$	0.422	94	142	13.9		0.5472	108	160
6		0.2362	57	93	8.25		0.3248	75	117	10.75		0.4232	94	142	14		0.5511	108	160
6.03	B	0.2374	63	101	8.3		0.3267	75	117	10.8		0.4251	94	142	14.25		0.561	114	169
6.1		0.2401	63	101	8.33	$21/64$	0.3279	75	117	10.9		0.4291	94	142	14.29	$9/16$	0.5625	114	169
6.15	C	0.2421	63	101	8.4		0.3307	75	117	11		0.433	94	142	14.5		0.5708	114	169
6.2		0.244	63	101	8.43	Q	0.3318	75	117	11.1		0.437	94	142	14.68	$37/64$	0.5779	114	169
6.25		0.246	63	101	8.5		0.3346	75	117	11.11	$7/16$	0.4374	94	142	14.75		0.5807	114	169
6.25	D	0.246	63	101	8.6		0.3385	81	125	11.2		0.4409	94	142	15		0.5905	114	169
6.3		0.248	63	101	8.61	R	0.3389	81	125	11.25		0.4429	94	142	15.08	$19/32$	0.5937	120	178
6.35	$1/4$	0.25	63	101	8.7		0.3425	81	125	11.3		0.4448	94	142	15.25		0.6003	120	178
6.35	E	0.25	63	101	8.73	$11/32$	0.3437	81	125	11.4		0.4488	94	142	15.48	$39/64$	0.6094	120	178
6.4		0.2519	63	101	8.75		0.3444	81	125	11.5		0.4527	94	142	15.5		0.6102	120	178
6.5		0.2559	63	101	8.8		0.3464	81	125	11.51	$29/64$	0.4531	94	142	15.75		0.62	120	178
6.53	F	0.257	63	101	8.84	S	0.348	81	125	11.6		0.4566	94	142	15.88	$5/8$	0.6251	120	178
6.6		0.2598	63	101	8.9		0.3503	81	125	11.7		0.4606	94	142	16		0.6299	120	178
6.63	G	0.261	63	101	9		0.3543	81	125	11.75		0.4625	94	142	16.27	$41/64$	0.6405	125	184
6.7		0.2637	63	101	9.09	T	0.3578	81	125	11.8		0.4645	94	142	16.5		0.6496	125	184
6.75	$17/64$	0.2657	69	109	9.1		0.3582	81	125	11.9		0.4685	101	151	16.67	$21/32$	0.6562	125	184
6.75		0.2657	69	109	9.13	$23/64$	0.3594	81	125	11.91	$15/32$	0.4688	101	151	17		0.6692	125	184
6.76	H	0.2661	69	109	9.2		0.3622	81	125	12		0.4724	101	151	17.07	$43/64$	0.672	130	191
6.8		0.2677	69	109	9.25		0.3641	81	125	12.1		0.4763	101	151	17.46	$11/16$	0.6874	130	191
6.9		0.2716	69	109	9.3		0.3661	81	125	12.2		0.4803	101	151	17.5		0.6889	130	191
6.91	I	0.272	69	109	9.35	U	0.3681	81	125	12.25		0.4822	101	151	18		0.7086	130	191
7		0.2755	69	109	9.4		0.37	81	125	12.3		0.4842	101	151	18.5		0.7283	135	198
7.04	J	0.2771	69	109	9.5		0.374	81	125	12.3	$31/64$	0.4842	101	151	19		0.748	135	198
7.1		0.2795	69	109	9.53	$3/8$	0.3751	87	133	12.4		0.4881	101	151	19.5		0.7677	140	205
7.14	$9/32$	0.2811	69	109	9.58	V	0.3771	87	133	12.5		0.4921	101	151	20		0.7874	140	205
7.14	K	0.2811	69	109	9.6		0.3779	87	133	12.6		0.496	101	151	5.41	3	0.2129	57	93
7.2		0.2834	69	109	9.7		0.3818	87	133	12.7		0.5	101	151					
7.25		0.2854	69	109	9.75		0.3838	87	133	12.7	$1/2$	0.5	101	151					
7.3		0.2874	69	109	9.8		0.3858	87	133	12.75		0.5019	101	151					
7.37	L	0.2901	69	109	9.8	W	0.3858	87	133	12.8		0.5039	101	151					
7.4		0.2913	69	109	9.9		0.3897	87	133	12.9		0.5078	101	151					

GROUP 025 DRILLS - STANDARD LENGTH

SENATOR High Speed Steel
QUALITY TOOLING Roll Forged Jobber Drills

For HSS Ground Flute Jobber Drills
for industrial applications, please see pages 31 to 32

Senator jobber drills are roll forged from HSS, ensuring uninterrupted grain structure. This provides exceptional strength and durability. Tips are ground for effective cutting. Suitable for drilling wood, plastic, carbon and plain steels where the cutting efficiency of ground flute is not required.

Manufactured to **BS 328 : Part 1 : 1986 & DIN 338 Type N.**



For Dimensions
See Pages
28 - 29



HSS

Metric

Dia. (mm)	Order Code SEN-025	Dia. (mm)	Order Code SEN-025	Dia. (mm)	Order Code SEN-025	Dia. (mm)	Order Code SEN-025
1.00	-0040N	3.80	-0091T	6.60	-0124E	11.00	-0177M
1.10	-0042Q	3.90	-0092V	6.70	-0125F	11.50	-0183T
1.20	-0044S	4.00	-0093W	6.80	-0127H	12.00	-0189A
1.30	-0046V	4.10	-0094X	6.90	-0128J	12.50	-0195G
1.40	-0048X	4.20	-0095Y	7.00	-0129K	13.00	-0201N
1.50	-0050N	4.30	-0097A	7.10	-0130L	14.00	-0213B
1.60	-0052B	4.40	-0098B	7.20	-0131M		
1.70	-0054D	4.50	-0099C	7.30	-0133P		
1.80	-0056F	4.60	-0100D	7.40	-0134Q		
1.90	-0058H	4.70	-0101E	7.50	-0135R		
2.00	-0060K	4.80	-0103G	7.70	-0137T		
2.10	-0062M	4.90	-0104H	7.80	-0139W		
2.20	-0064P	5.00	-0105J	7.90	-0140X		
2.30	-0066R	5.10	-0106K	8.00	-0141Y		
2.40	-0068T	5.20	-0107L	8.10	-0142N		
2.50	-0070W	5.30	-0109N	8.20	-0143A		
2.60	-0072Y	5.40	-0110P	8.30	-0145C		
2.70	-0074A	5.50	-0111Q	8.40	-0146D		
2.80	-0076C	5.60	-0112R	8.50	-0147E		
2.90	-0078E	5.70	-0113S	8.60	-0148F		
3.00	-0080G	5.80	-0115V	8.70	-0149G		
3.10	-0081H	5.90	-0116W	8.80	-0151J		
3.20	-0083K	6.00	-0117X	8.90	-0152K		
3.30	-0085M	6.10	-0118Y	9.00	-0153L		
3.40	-0086N	6.20	-0119N	9.50	-0159S		
3.50	-0087P	6.30	-0121B	10.00	-0165N		
3.60	-0088Q	6.40	-0122C	10.20	-0167B		
3.70	-0089R	6.50	-0123D	10.50	-0171F		

EXTENDED RANGE

Dia. (inch)	Order Code SEN-025
1/16"	-0001D
3/32"	-0001F
7/64"	-0001G
1/8"	-0001H
9/64"	-0001J
5/32"	-0001K
11/64"	-0001L
3/16"	-0001M
13/64"	-0001N
7/32"	-0001P
1/4"	-0001R
5/16"	-0001W
3/8"	-0002A
7/16"	-0002E
1/2"	-0002J

High Speed Steel Roll Forged Jobber Drills

Roll forged from HSS, ensuring uninterrupted grain structure. This provides exceptional strength and durability. Tips are ground for effective cutting. Suitable for drilling wood, plastic, carbon and plain steels where the cutting efficiency of ground flute is not required.

Manufactured to **BS 328 : Part 1 : 1986 & DIN 338 Type N.**

METRIC
0.5 increments

1.0 to 10.0

19
PIECES

19 Piece Set
Contents (mm):

1.0	3.0	5.0	7.0	9.0
1.5	3.5	5.5	7.5	9.5
2.0	4.0	6.0	8.0	10.0
2.5	4.5	6.5	8.5	

Weight each

Order Code
SEN-025

0.65kg

-9250K

METRIC
0.5 increments

1.0 to 13.0

25
PIECES

25 Piece Set
Contents (mm):

1.0	3.5	6.0	8.5	11.0
1.5	4.0	6.5	9.0	11.5
2.0	4.5	7.0	9.5	12.0
2.5	5.0	7.5	10.0	12.5
3.0	5.5	8.0	10.5	13.0

Weight each

Order Code
SEN-025

1.60kg

-9150K

18 Piece Drill Set

Sizes 3, 4, 5, 6, 8 and 10mm.
Supplied in 'dial a drill' case for easy selection.

6 x each drills
Wood, Masonry and HSS



Weight each

Order Code
SEN-025

452g

-9500K

18
PIECES

METRIC
0.1 increments

6.0 to 10.0

41
PIECES

41 Piece Set
Contents (mm):

6.0	6.9	7.8	8.7	9.6
6.1	7.0	7.9	8.8	9.7
6.2	7.1	8.0	8.9	9.8
6.3	7.2	8.1	9.0	9.9
6.4	7.3	8.2	9.1	10.0
6.5	7.4	8.3	9.2	
6.6	7.5	8.4	9.3	
6.7	7.6	8.5	9.4	
6.8	7.7	8.6	9.5	

Weight each

Order Code
SEN-025

2.10kg

-9110K

METRIC
0.1 increments

1.0 to 6.0

51
PIECES

51 Piece Set
Contents (mm):

1.0	1.9	2.8	3.7	4.6	5.5
1.1	2.0	2.9	3.8	4.7	5.6
1.2	2.1	3.0	3.9	4.8	5.7
1.3	2.2	3.1	4.0	4.9	5.8
1.4	2.3	3.2	4.1	5.0	5.9
1.5	2.4	3.3	4.2	5.1	6.0
1.6	2.5	3.4	4.3	5.2	
1.7	2.6	3.5	4.4	5.3	
1.8	2.7	3.6	4.5	5.4	

Weight each

Order Code
SEN-025

0.60kg

-9060K



HSS Jobber Drills Metric - Bright Finish

General purpose drills for steels, cast steel, grey cast iron, malleable cast iron, nickel brass, aluminium alloy and graphite. Point angle: 118°, helix angle: normal, web thickness: standard, relief angle: 10°-20°, tolerance of diameter: h8, tolerance of shank: f11. Manufactured to **BS 328/DIN 338RN**.

Bright finish

Drills with a bright finish are supplied in the as-ground condition and such tools are used generally in the machining of non-ferrous materials.

For Black Oxidised Finish Drills



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For Dimensions
See Pages
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HSS

METRIC



Series J100

PRICED PER 10

Dia. (mm)	Order Code
1.00	-0231B
1.10	-0231D
1.20	-0231F
1.30	-0231H
1.40	-0231K
1.50	-0231M
1.60	-0231P
1.70	-0231R
1.80	-0231T
1.90	-0231W
1.95	-0231Y
2.00	-0232A
2.10	-0232C
2.20	-0232E
2.30	-0232G
2.40	-0232J
2.50	-0232L
2.60	-0232N
2.70	-0232Q
2.80	-0232S
2.90	-0232V
3.00	-0232X
3.10	-0232Z
3.20	-0233B

PRICED PER 10

Dia. (mm)	Order Code
3.30	-0233D
3.40	-0233F
3.50	-0233H
3.60	-0233K
3.70	-0233M
3.80	-0233P
3.90	-0233R
4.00	-0233T
4.10	-0233W
4.20	-0233Y
4.30	-0234A
4.40	-0234C
4.50	-0234E
4.60	-0234G
4.70	-0234J
4.80	-0234L
4.90	-0234N
5.00	-0234Q
5.10	-0234S
5.20	-0234V
5.30	-0234X
5.40	-0234Z
5.50	-0235B
5.60	-0235D

PRICED PER 10

Dia. (mm)	Order Code
5.70	-0235F
5.80	-0235H
5.90	-0235K
6.00	-0235M
6.10	-0235P
6.20	-0235R
6.30	-0235T
6.40	-0235W
6.50	-0235Y
6.60	-0236A
6.70	-0236C
6.80	-0236E
6.90	-0236G
7.00	-0236J
7.10	-0236L
7.20	-0236N
7.30	-0236Q
7.40	-0236S
7.50	-0236V
7.60	-0236X
7.70	-0236Z
7.80	-0237B
7.90	-0237D
8.00	-0237F

PRICED PER 10

Dia. (mm)	Order Code
8.10	-0237H
8.20	-0237K
8.30	-0237M
8.40	-0237P
8.50	-0237R
8.60	-0237T
8.70	-0237W
8.80	-0237Y
9.00	-0238A
9.30	-0238G
9.50	-0238L
9.60	-0238N
10.00	-0238X
10.20	-0239B
10.50	-0239H
11.00	-0239T
11.50	-0239Z
12.00	-0240E
12.50	-0240K
13.00	-0240R
Price /1	
14.00	-0241C
15.00	-0241G
16.00	-0241L

High Speed Steel Drill Blanks

Jobber length blank hardened and ground all over. Accurately ground without back taper. Diameter tolerance: h8. Manufactured to **DIN 338**.



For Dimensions
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HSS

METRIC



Series J400 - Metric

PRICED PER 10

Dia. (mm)	Order Code
1.00	-2398F
1.10	-2400H
1.20	-2402K
1.30	-2404M
1.40	-2406P
1.50	-2408R
1.60	-2410T
1.70	-2412W
1.80	-2414Y
1.90	-2416A
2.00	-2418C
2.10	-2420E
2.20	-2422G
2.30	-2424J
2.40	-2426L
2.50	-2428N
2.60	-2430Q
2.70	-2432S
2.80	-2434V
2.90	-2436X
3.00	-2438N
3.10	-2439A
3.20	-2440B
3.30	-2442D

PRICED PER 10

Dia. (mm)	Order Code
3.40	-2443E
3.50	-2444F
3.60	-2445G
3.70	-2446H
3.80	-2448K
3.90	-2449L
4.00	-2450M
4.10	-2451N
4.20	-2452P
4.30	-2454R
4.40	-2455S
4.50	-2456T
4.60	-2457V
4.70	-2458W
4.80	-2460Y
4.90	-2461N
5.00	-2462A
5.10	-2463B
5.20	-2464C
5.30	-2466E
5.40	-2467F
5.50	-2468G
5.60	-2469H
5.70	-2470J

PRICED PER 10

Dia. (mm)	Order Code
5.80	-2472L
5.90	-2473M
6.00	-2474N
6.10	-2475P
6.20	-2476Q
6.30	-2478S
6.40	-2479T
6.50	-2480V
6.60	-2481W
6.70	-2482X
6.80	-2484N
6.90	-2485A
7.00	-2486B
7.10	-2487C
7.20	-2488D
7.30	-2490F
7.40	-2491G
7.50	-2492H
7.60	-2493J
7.70	-2494K
7.80	-2496M
7.90	-2497N
8.00	-2498P
8.10	-2499Q

PRICED PER 10

Dia. (mm)	Order Code
8.20	-2500R
8.30	-2502T
8.40	-2503V
8.50	-2504W
8.60	-2505X
8.70	-2506Y
8.80	-2508A
8.90	-2509B
9.00	-2510C
9.10	-2511D
9.20	-2512E
9.30	-2514G
9.40	-2515H
9.50	-2516J
9.60	-2517K
9.80	-2520N
9.90	-2521P
10.00	-2522Q
10.50	-2523R
11.00	-2524S
11.50	-2525T
12.00	-2526V
12.50	-2527W
13.00	-2528X

PRODUCTS ARE ONLY AVAILABLE VIA YOUR DISTRIBUTOR

GROUP 025 DRILLS - STANDARD LENGTH



**HSS Jobber Drills -
Steam Tempered**

**EXTENDED
RANGE**



Series J100

General purpose drills for steels, cast steel, grey cast iron, malleable cast iron, nickel brass, aluminium alloy and graphite. Point angle: 118°, helix angle: normal, web thickness: standard, relief angle: 10°-20°, tolerance of diameter: h8, tolerance of shank: f11. Manufactured to **BS 328/DIN 338RN**.

Black finish (W-finish)

This is the most common surface finish and is the result of a steam tempering operation in which steam is passed over the product during a controlled tempering cycle, producing a black oxide layer. Black tools are generally recommended for ferrous applications where the oxide layer aids chip flow, helps to dissipate heat by retaining some coolant on the tool surface and also helps to prevent the tool from staining.



DIN 338
BS 328

For Dimensions
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**For Bright Finish
Jobber Drills**

See
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Metric		PRICED PER 10
Dia. (mm)	Order Code SHR-025	
0.25	-0010X	
0.30	-0012A	
0.35	-0014F	
0.40	-0016L	
0.42	-0017N	
0.45	-0018P	
0.48	-0019Q	
0.50	-0020R	
0.52	-0021S	
0.55	-0022T	
0.58	-0023V	
0.60	-0024W	
0.62	-0025X	
0.65	-0026Y	
0.68	-0027N	
0.70	-0028A	
0.72	-0029B	
0.75	-0030C	
0.78	-0031D	
0.80	-0032E	
0.82	-0033F	
0.85	-0034G	
0.88	-0035H	
0.90	-0036J	
0.92	-0037K	
0.95	-0038L	
0.98	-0039M	
1.00	-0040N	
1.05	-0041P	
1.10	-0042Q	
1.15	-0043R	
1.20	-0044S	
1.25	-0045T	
1.30	-0046V	
1.35	-0047W	
1.40	-0048X	
1.45	-0049Y	
1.50	-0050N	
1.55	-0051A	
1.60	-0052B	
1.65	-0053C	
1.70	-0054D	
1.75	-0055E	
1.80	-0056F	
1.85	-0057G	
1.90	-0058H	
1.95	-0059J	
2.00	-0060K	
2.05	-0061L	
2.10	-0062M	
2.15	-0063N	
2.20	-0064P	
2.25	-0065Q	
2.30	-0066R	
2.35	-0067S	
2.40	-0068T	
2.45	-0069V	
2.50	-0070W	
2.55	-0071X	
2.60	-0072Y	
2.65	-0073N	
2.70	-0074A	
2.75	-0075B	
2.80	-0076C	
2.85	-0077D	
2.90	-0078E	
2.95	-0079F	

Metric continued		PRICED PER 10
Dia. (mm)	Order Code SHR-025	
3.00	-0080G	
3.10	-0081H	
3.15	-0082J	
3.20	-0083K	
3.25	-0084L	
3.30	-0085M	
3.40	-0086N	
3.45	-0087D	
3.50	-0087P	
3.60	-0088Q	
3.65	-0089D	
3.70	-0089R	
3.75	-0090S	
3.80	-0091T	
3.90	-0092V	
4.00	-0093W	
4.05	-0094L	
4.10	-0094X	
4.20	-0095Y	
4.25	-0096N	
4.30	-0097A	
4.40	-0098B	
4.50	-0099C	
4.60	-0100D	
4.70	-0101E	
4.75	-0102F	
4.80	-0103G	
4.85	-0103X	
4.90	-0104H	
5.00	-0105J	
5.10	-0106K	
5.20	-0107L	
5.25	-0108M	
5.30	-0109N	
5.40	-0110P	
5.50	-0111Q	
5.60	-0112R	
5.70	-0113S	
5.75	-0114T	
5.80	-0115V	
5.90	-0116W	
6.00	-0117X	
6.10	-0118Y	
6.20	-0119N	
6.25	-0120A	
6.30	-0121B	
6.40	-0122C	
6.50	-0123D	
6.60	-0124E	
6.70	-0125F	
6.75	-0126G	
6.80	-0127H	
6.90	-0128J	
7.00	-0129K	
7.10	-0130L	
7.20	-0131M	
7.30	-0133P	
7.40	-0134Q	
7.50	-0135R	
7.60	-0136S	
7.70	-0137T	
7.80	-0139W	
7.90	-0140X	
8.00	-0141Y	
8.10	-0142N	
8.20	-0143A	

Metric continued		PRICED PER 10
Dia. (mm)	Order Code SHR-025	
8.25	-0144B	
8.30	-0145C	
8.40	-0146D	
8.50	-0147E	
8.60	-0148F	
8.70	-0149G	
8.75	-0150H	
8.80	-0151J	
8.90	-0152K	
9.00	-0153L	
9.10	-0154M	
9.20	-0155N	
9.30	-0157Q	
9.40	-0158R	
9.50	-0159S	
9.60	-0160T	
9.70	-0161V	
9.80	-0163X	
9.90	-0164Y	
10.00	-0165N	
10.10	-0166A	
10.20	-0167B	
10.25	-0168C	
10.30	-0169D	
10.40	-0170E	
10.50	-0171F	
10.60	-0172G	
10.80	-0175K	
10.90	-0176L	
11.00	-0177M	
11.10	-0178N	
11.20	-0179P	
11.30	-0181R	
11.40	-0182S	
11.50	-0183T	
11.60	-0184V	
11.70	-0185W	
11.80	-0187Y	
11.90	-0188N	
12.00	-0189A	
12.10	-0190B	
12.20	-0191C	
12.25	-0192D	
12.30	-0193E	
12.40	-0194F	
12.50	-0195G	
12.60	-0196H	
12.70	-0197J	
12.80	-0199L	
12.90	-0200M	
13.00	-0201N	

Metric continued		PRICED PER 1
Dia. (mm)	Order Code SHR-025	
13.10	-0202P	
13.20	-0203Q	
13.30	-0205S	
13.40	-0206T	
13.50	-0207V	
13.60	-0208W	
13.70	-0209X	
13.75	-0210Y	
13.80	-0211N	
13.90	-0212A	
14.00	-0213B	
14.25	-0214C	
14.50	-0215D	
14.75	-0216E	
15.00	-0217F	

Metric continued		PRICED PER 1
Dia. (mm)	Order Code SHR-025	
15.25	-0218G	
15.50	-0219H	
15.75	-0220J	
16.00	-0221K	
16.50	-0222L	
17.00	-0223M	
17.50	-0224N	
18.00	-0225P	
18.50	-0226Q	
19.00	-0227R	
19.50	-0228S	
20.00	-0229T	

Inch		PRICED PER 10
Dia. (Inch)	Order Code SHR-025	
1/64"	-0001A	
1/32"	-0001B	
3/64"	-0001C	
1/16"	-0001D	
5/64"	-0001E	
3/32"	-0001F	
7/64"	-0001G	
1/8"	-0001H	
9/64"	-0001J	
5/32"	-0001K	
11/64"	-0001L	
3/16"	-0001M	
13/64"	-0001N	
7/32"	-0001P	
15/64"	-0001Q	
1/4"	-0001R	
17/64"	-0001S	
9/32"	-0001T	
19/64"	-0001V	
5/16"	-0001W	
21/64"	-0001X	
11/32"	-0001Y	
23/64"	-0001Z	
3/8"	-0002A	
25/64"	-0002B	
13/32"	-0002C	
27/64"	-0002D	
7/16"	-0002E	
29/64"	-0002F	
15/32"	-0002G	
31/64"	-0002H	
1/2"	-0002J	

Inch continued		PRICED PER 1
Dia. (Inch)	Order Code SHR-025	
33/64"	-0002K	
17/32"	-0002L	
35/64"	-0002M	
9/16"	-0002N	
37/64"	-0002P	
19/32"	-0002Q	
39/64"	-0002R	
5/8"	-0002S	
41/64"	-0002T	
21/32"	-0002V	
43/64"	-0002W	
11/16"	-0002X	
3/4"	-0003B	

SWISS+TECH

**HSS Straight Shank
TiN Tipped Jobber Drills**

Bright body with TiN coating on working part. For drilling in steel, cast steel alloyed and non-alloyed, grey cast iron, graphite and malleable cast iron.

Point angle: 118°, helix angle: normal, web thickness: standard, relief angle: normal, tolerance of diameter: h8, tolerance of shank: f11.

Manufactured to **BS 328, DIN 338**.

DIN
338

BS
328

**For Dimensions
See Pages
28 - 29**



HSS

TiN



**TiN Tipped -
Metric**

Dia. (mm)	Order Code SWT-125
1.00	-5010A
1.50	-5015A
1.60	-5016A
1.70	-5017A
1.80	-5018A
2.00	-5020A
2.10	-5021A
2.20	-5022A
2.30	-5023A
2.40	-5024A
2.50	-5025A
2.60	-5026A
2.70	-5027A
2.80	-5028A
2.90	-5029A
3.00	-5030A
3.10	-5031A
3.20	-5032A
3.30	-5033A
3.40	-5034A
3.50	-5035A
3.60	-5036A

Metric Continued

Dia. (mm)	Order Code SWT-125
3.70	-5037A
3.80	-5038A
3.90	-5039A
4.00	-5040A
4.10	-5041A
4.20	-5042A
4.30	-5043A
4.40	-5044A
4.50	-5045A
4.60	-5046A
4.70	-5047A
4.80	-5048A
4.90	-5049A
5.00	-5050A
5.10	-5051A
5.20	-5052A
5.30	-5053A
5.40	-5054A
5.50	-5055A
5.60	-5056A
5.70	-5057A
5.80	-5058A

Metric Continued

Dia. (mm)	Order Code SWT-125
5.90	-5059A
6.00	-5060A
6.10	-5061A
6.20	-5062A
6.30	-5063A
6.40	-5064A
6.50	-5065A
6.60	-5066A
6.70	-5067A
6.80	-5068A
6.90	-5069A
7.00	-5070A
7.20	-5072A
7.50	-5075A
8.00	-5080A
8.50	-5085A
9.00	-5090A
9.50	-5095A
10.00	-5100A
10.20	-5102A
10.50	-5105A
11.00	-5110A

Metric Continued

Dia. (mm)	Order Code SWT-125
12.00	-5120A
12.50	-5125A
13.00	-5130A

TiN Tipped - Inch Sizes

Dia. (Inch)	Order Code SWT-125
1/16"	-5002A
3/32"	-5002L
1/8"	-5003A
9/64"	-5003L
5/32"	-5004A
3/16"	-5004L
7/32"	-5005A
1/4"	-5005L
9/32"	-5006A
5/16"	-5006L
3/8"	-5007A
7/16"	-5007L
1/2"	-5008A

HSS TiN Coated Jobber Drills

General purpose drill, to drill steels with a tensile strength up to 1,000N/mm², cast steel, grey cast iron, malleable cast iron, nickel brass and graphite.

TiN coating provides longer tool life. Point angle: 118°, helix angle: normal, web thickness: normal, relief angle: normal, tolerance of diameter: h8, tolerance of shank: f11.

Manufactured to **DIN 338 RN, DIN 338**.

DIN
338

BS
328

**For Dimensions
See Pages
28 - 29**

HSS

TiN

**EXTENDED
RANGE**



**Series 1001 -
Metric**

Dia. (mm)	Order Code SWT-125
1.00	-0010A
1.10	-0011A
1.20	-0012A
1.30	-0013A
1.40	-0014A
1.50	-0015A
1.60	-0016A
1.70	-0017A
1.80	-0018A
1.90	-0019A
2.00	-0020A
2.10	-0021A
2.20	-0022A
2.30	-0023A
2.40	-0024A
2.50	-0025A
2.60	-0026A
2.70	-0027A
2.80	-0028A
2.90	-0029A
3.00	-0030A
3.10	-0031A
3.20	-0032A
3.30	-0033A

Metric Continued

Dia. (mm)	Order Code SWT-125
3.40	-0034A
3.50	-0035A
3.60	-0036A
3.70	-0037A
3.80	-0038A
3.90	-0039A
4.00	-0040A
4.20	-0042A
4.30	-0043A
4.40	-0044A
4.50	-0045A
4.60	-0046A
4.70	-0047A
4.80	-0048A
4.90	-0049A
5.00	-0050A
5.10	-0051A
5.20	-0052A
5.30	-0053A
5.50	-0055A
5.60	-0056A
5.80	-0058A
6.00	-0060A
6.10	-0061A

Metric Continued

Dia. (mm)	Order Code SWT-125
6.20	-0062A
6.30	-0063A
6.40	-0064A
6.50	-0065A
6.60	-0066A
6.70	-0067A
6.80	-0068A
6.90	-0069A
7.00	-0070A
7.10	-0071A
7.20	-0072A
7.30	-0073A
7.40	-0074A
7.50	-0075A
7.70	-0077A
7.80	-0078A
7.90	-0079A
8.00	-0080A
8.10	-0081A
8.20	-0082A
8.30	-0083A
8.50	-0085A
8.60	-0086A
8.70	-0087A

Metric Continued

Dia. (mm)	Order Code SWT-125
8.90	-0089A
9.00	-0090A
9.10	-0091A
9.20	-0092A
9.30	-0093A
9.40	-0094A
9.50	-0095A
9.60	-0096A
9.70	-0097A
9.80	-0098A
10.00	-0100A
10.10	-0101A
10.20	-0102A
10.30	-0103A
10.50	-0105A
10.80	-0108A
11.00	-0110A
11.50	-0115A
11.80	-0118A
12.00	-0120A
12.10	-0121A
12.50	-0125A
13.00	-0130A

PRODUCTS ARE ONLY AVAILABLE VIA YOUR DISTRIBUTOR

GROUP 025 DRILLS - STANDARD LENGTH SETS

SHERWOOD QUALITY CUTTING TOOLS **HSS Ground Flute Jobber Drill Sets**

Industrial quality. Ground flute, blue finish, except for SHR-025-8520K (bright finish). Supplied in indexing metal cases. Manufactured to **BS328 : Part 1 : 1986, DIN 338N & ANSI B94 - 11M.**



METRIC
0.5 increments
1.0 to 10.5

Tapping sizes
1.9 to 10.2

HSS

32 Piece Set
Contents (mm):

1.0	2.6	3.8	5.5	7.9	10.2
1.5	2.9	4.0	6.0	8.0	10.5
1.9	3.0	4.2	6.5	8.5	
2.0	3.2	4.5	6.8	9.0	
2.1	3.3	5.0	7.0	9.5	
2.5	3.5	5.1	7.5	10.0	

Weight each	Order Code
1.10kg	SHR-025 -8470K



METRIC
0.1 increments
6.0 to 10.0

HSS

41 Piece Set
Contents (mm):

6.0	6.6	7.2	7.8	8.4	9.0	9.6
6.1	6.7	7.3	7.9	8.5	9.1	9.7
6.2	6.8	7.4	8.0	8.6	9.2	9.8
6.3	6.9	7.5	8.1	8.7	9.3	9.9
6.4	7.0	7.6	8.2	8.8	9.4	10.0
6.5	7.1	7.7	8.3	8.9	9.5	

Weight each	Order Code
2.20kg	SHR-025 -8420K



METRIC
0.1 increments
1.0 to 6.0

HSS

51 Piece Set
Contents (mm):

1.0	1.7	2.4	3.1	3.8	4.5	5.2	5.9
1.1	1.8	2.5	3.2	3.9	4.6	5.3	6.0
1.2	1.9	2.6	3.3	4.0	4.7	5.4	
1.3	2.0	2.7	3.4	4.1	4.8	5.5	
1.4	2.1	2.8	3.5	4.2	4.9	5.6	
1.5	2.2	2.9	3.6	4.3	5.0	5.7	
1.6	2.3	3.0	3.7	4.4	5.1	5.8	

Weight each	Order Code
0.72kg	SHR-025 -8380K



METRIC
0.5 increments
1.0 to 10.0

HSS

19 Piece Set
Contents (mm):

1.0	2.5	4.0	5.5	7.0	8.5	10.0
1.5	3.0	4.5	6.0	7.5	9.0	
2.0	3.5	5.0	6.5	8.0	9.5	

Weight each	Order Code
0.75kg	SHR-025 -8460K



METRIC
0.5 increments
1.0 to 13.0

HSS

25 Piece Sets
Contents (mm):

1.0	3.0	5.0	7.0	9.0	11.0	13.0
1.5	3.5	5.5	7.5	9.5	11.5	
2.0	4.0	6.0	8.0	10.0	12.0	
2.5	4.5	6.5	8.5	10.5	12.5	



Bright Finish

Finish	Weight each	Order Code
Blue	1.30kg	SHR-025 -8500K
Bright	1.30kg	SHR-025 -8520K

HSS Ground Flute Tap & Drill Set

Industrial quality. Ground flute, blue finish. Supplied in indexing metal cases. Manufactured to **BS328 : Part 1 : 1986, DIN 338N & ANSI B94 -11M.**



METRIC
HSS

28 Piece Tap & Drill Set
Taps (taper, second and bottom) - Contents (mm):

M3 M4	M5 M6	M8 M10	M12
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Tapping Drills - Contents (mm):

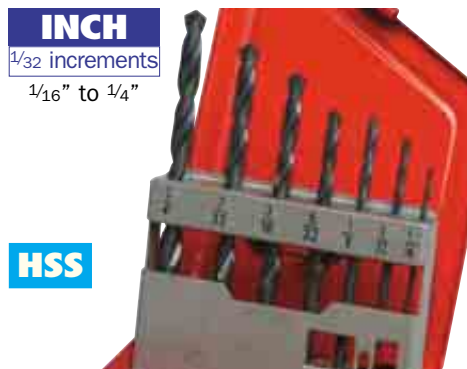
2.5 3.3	4.2 5.0	6.8 8.5	10.2
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Weight each	Order Code
10.72kg	SHR-025 -9960K



HSS Ground Flute Jobber Drill Sets

Industrial quality. Ground flute, blue finish. Supplied in indexing metal cases.
Manufactured to **BS328 : Part 1 : 1986, DIN 338N & ANSI B94 - 11M.**



7 Piece Set Contents:

1/16"	1/8"	3/16"	1/4"
3/32"	5/32"	7/32"	
Weight each	Order Code		
0.12kg	SHR-025		
	-8890K		



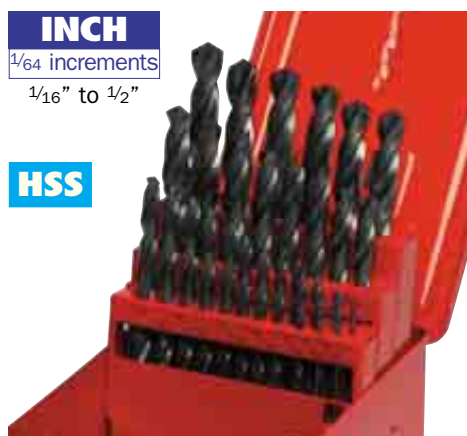
13 Piece Set Contents:

1/16"	7/64"	5/32"	13/64"	1/4"
5/64"	1/8"	11/64"	7/32"	
3/32"	9/64"	3/16"	15/64"	
Weight each	Order Code			
0.39kg	SHR-025			
	-8680K			



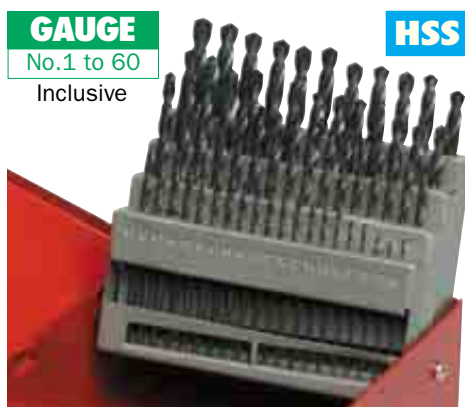
15 Piece Set Contents:

1/16"	5/32"	1/4"	11/32"	7/16"
3/32"	3/16"	9/32"	3/8"	15/32"
1/8"	7/32"	5/16"	13/32"	1/2"
Weight each	Order Code			
0.95kg	SHR-025			
	-8840K			



29 Piece Set Contents:

1/16"	5/32"	1/4"	11/32"	7/16"
5/64"	11/64"	17/64"	23/64"	29/64"
3/32"	3/16"	9/32"	3/8"	15/32"
7/64"	13/64"	19/64"	25/64"	31/64"
1/8"	7/32"	5/16"	13/32"	1/2"
9/64"	15/64"	21/64"	27/64"	
Weight each	Order Code			
1.40kg	SHR-025			
	-8800K			



60 Piece Set Contents: No.1 to 60 gauge inc.

Weight each	Order Code
0.72kg	SHR-025
	-8880K

Assorted Drill Set

100 Piece
Assorted inch and metric sizes up to 1/2" - 13mm.
Straight shank.
Supplied in a plastic case.
Set contents may vary.

NEW

Number Pieces	Order Code
100	PRO-901
	-0190A

HSS Long Series Extra Length Drill Sets

Used for deep hole drilling applications in most types of materials.
These drills are not recommended for the drilling of holes in crankshafts.
Manufactured to **BS 328 : Part 1 : 1986.**

HSS



Select-A-Drill Set - HSS

19 Piece Set
Set of 19 HSS drills in a 'dial-a-drill' style case.
With a clear top to view drills.

Contents:

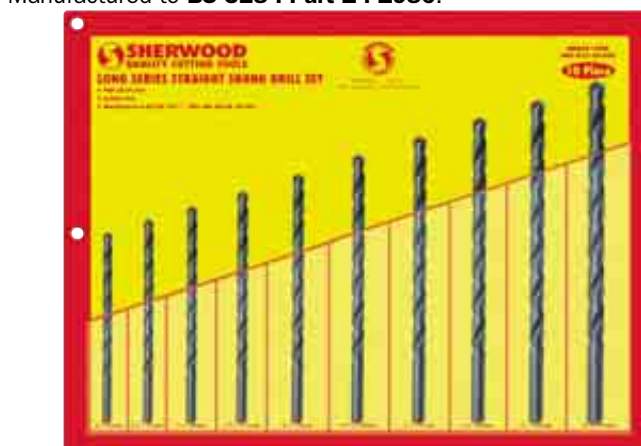
1.0, 1.5, 2.0, 2.5, 3.0, 3.5, 4.0, 4.5, 5.0, 5.5, 6.0, 6.5, 7.0, 7.5, 8.0, 8.5, 9.0, 9.5 and 10.0mm.

METRIC 0.5 increments

1.0 to 10.0mm

HSS

Number Pieces	Order Code
19	SHR-025
	-9000K



10 Piece Long Series Set Contents:

2.0 x 85mm	4.0 x 119mm	8.0 x 165mm
2.5 x 95mm	4.5 x 126mm	10.0 x 184mm
3.0 x 100mm	5.0 x 132mm	
3.5 x 112mm	6.0 x 139mm	

Drill Type	Order Code
Long	SHR-025
Extra L	-8540K
	-8600K



6 Piece Extra Length Series Set Contents:

3.0 x 160mm	6.0 x 200mm
4.0 x 160mm	8.0 x 250mm
5.0 x 200mm	10.0 x 250mm