

**SWISS+TECH HSS TiN Tipped Centre Drills**

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

**HSS TiN-tip METRIC**



**Metric**

Diameter		Pilot Length		Overall Length	Order Code
Body	Pilot	Min.	Max.		
3.15	1.0	1.3	1.9	31.5	-5142A
4.00	1.60	2.0	2.8	35.5	-5143A
5.00	2.00	2.5	3.3	40.0	-5144A
6.30	2.50	3.1	4.1	45.0	-5145A
8.00	3.15	3.9	4.9	50.0	-5146A
10.00	4.00	5.0	6.2	56.0	-5147A
12.50	5.00	6.3	7.5	63.0	-5148A

**HSS 5 Metric Set**

60° inclusive angle. Manufactured to **BS 328 : Part 2 : 1986, DIN 333A, ISO 866, ISO 2540, ISO 2541.**

Sizes: 5 x 2mm, 6.3 x 2.5mm, 8 x 3.15mm 10 x 4mm and 12.5 x 5mm.

**HSS TiN-tip**



**5 PIECES**

Weight each	Order Code
120g	-5155A

**HSS TiN Tipped Centre Drills HSS TiN-tip INCH**

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



**Inch**

Size	Diameter		Pilot Length		Overall Length	Order Code
	Body	Pilot	Min.	Max.		
BS1	1/8"	3/64"	1/16"	5/64"	1 1/2"	-5133A
BS2	3/16"	1/16"	5/64"	5/32"	1 3/4"	-5134A
BS3	1/4"	3/32"	1/8"	5/32"	2"	-5135A
BS4	5/16"	7/8"	5/32"	3/16"	2 1/4"	-5136A
BS5	7/16"	3/16"	1/4"	9/32"	2 1/2"	-5137A

**HSS TiN Tipped BS Set**

Designed with spiral flutes and various lengths and forms to give high quality centre holes. TiN coating on working parts. 60° inclusive angle. Manufactured to **BS 328 : Part 2 : 1986, DIN 333A, ISO 866, ISO 2540, ISO 2541.**

Sizes: BS1, BS2, BS3, BS4 and BS5.

**HSS TiN-tip**



**5 PIECES**

Weight each	Order Code
114g	-5140A

**SHERWOOD HSS Centre Drills**

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.**

**HSS METRIC**



**C100 Series - Metric**

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 Metric Set**

60° inclusive angle. Manufactured to **BS 328 : Part 2 : 1986, DIN 333A, ISO 866, ISO 2540, ISO 2541.**

Sizes: 5 x 2mm, 6.3 x 2.5mm, 8 x 3.15mm 10 x 4mm and 12.5 x 5mm.

**HSS**



**5 PIECES**

Weight each	Order Code
120g	-9150K

**HSS Centre Drills HSS INCH**

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.**



**C100 Series - Inch**

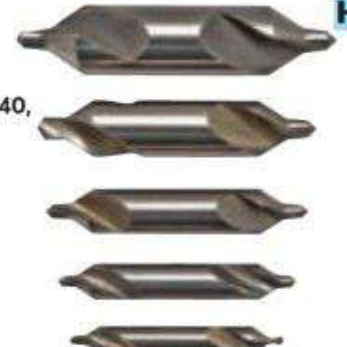
Size	Diameter		Pilot Length		Overall Length	Order Code
	Body	Pilot	Min.	Max.		
BS00	1/8"	0.025"	0.025"	0.030"	1 1/8"	-1827L
BS0	1/8"	1/32"	3/64"	1/16"	1 1/4"	-1828M
BS1	1/8"	3/64"	1/16"	5/64"	1 1/2"	-1829A
BS2	3/16"	1/16"	5/64"	5/32"	1 3/4"	-1830B
BS3	1/4"	3/32"	1/8"	5/32"	2"	-1831C
BS4	5/16"	1/8"	5/32"	3/16"	2 1/4"	-1832D
BS5	7/16"	3/16"	1/4"	9/32"	2 1/2"	-1833E
BS6	5/8"	1/4"	5/16"	3/8"	3"	-1835G
BS7	3/4"	5/16"	13/32"	15/32"	3 1/2"	-1836H

**HSS BS Set**

60° inclusive angle. Manufactured to **BS 328 : Part 2 : 1986, DIN 333A, ISO 866, ISO 2540, ISO 2541.**

Sizes: BS1, BS2, BS3, BS4 and BS5.

**HSS**



**5 PIECES**

Weight each	Order Code
114g	-9160K



**HSS Extra Length Centre Drills**

**HSS**

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.**



**Metric**

Diameter (mm)		Overall Length	Weight each	Order Code SHR-024
Body	Point			
4.00	1.00	120	19g	-1866H
5.00	1.60	120	25g	-1866K
6.00	2.00	120	31g	-1866N
8.00	2.50	120	49g	-1866R
10.00	3.15	120	69g	-1866W
12.50	5.00	120	86g	-1866X

**Inch**

Size	Diameter		Overall Length	Order Code SHR-024
	Body	Pilot		
BS1	1/8"	3/64"	4"	-1881A
BS2	3/16"	1/16"	4"	-1882B
BS3	1/4"	3/32"	4"	-1883C
BS4	5/16"	1/8"	4"	-1884D
BS5	7/16"	3/16"	4"	-1885E

**HSS Bell Type Centre Drills**

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

**HSS**



**Metric**

Diameter		Overall Length	Order Code SHR-024
Body	Pilot		
4.00	1.00	35.5	-1861K
5.00	1.25	40.0	-1861L
6.30	1.60	45.0	-1861N
8.00	2.00	50.0	-1861P
10.00	2.50	56.0	-1861Q
11.20	3.15	60.0	-1861R
14.00	4.00	67.0	-1861S
18.00	5.00	75.0	-1861T

**Inch**

Size	Diameter		Overall Length	Order Code SHR-024
	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	5/16"	1/8"	2 1/4"	-1856D
BS5B	7/16"	5/32"	2 1/2"	-1858F

**Carbide Centre Drills**

**CARBIDE**

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.**

**Tolerances**  
Cutting Diameter +0.0005"  
Shank Diameter +0.0010"



**Inch**

Size	Diameter		Overall Length	Weight each	Order Code SHR-158
	Body	Drill			
BS1	1/8"	3/64"	1 1/2"	10g	-8010K
BS2	3/16"	1/16"	1 3/8"	10g	-8020K
BS3	1/4"	3/64"	2"	20g	-8030K
BS4	5/16"	1/8"	2 1/8"	30g	-8040K

**Metric**

Diameter		Pilot Length		Overall Length	Weight each	Order Code SHR-158
Body	Pilot	Min.	Max.			
5.00	2.00	2.5	3.3	40.0	5g	-8120K
6.30	2.50	3.1	4.1	45.0	9g	-8130K
8.00	3.15	3.9	4.9	50.0	7g	-8140K
10.00	4.00	5.0	6.2	56.0	28g	-8150K
12.50	5.00	6.3	7.5	63.0	45g	-8160K



**Carbide Centre Drills**

**CARBIDE**

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.**

**Tolerances**  
Cutting Diameter +0.0005"  
Shank Diameter +0.0010"



**Inch**

Size	Diameter		Overall Length	Weight each	Order Code KEN-158
	Body	Drill			
BS1	1/8"	3/64"	1 1/2"	10g	-9010K
BS2	3/16"	1/16"	1 3/8"	10g	-9020K
BS3	1/4"	3/64"	2"	20g	-9030K
BS4	5/16"	1/8"	2 1/8"	30g	-9040K
BS5	7/16"	3/16"	2 3/4"	70g	-9050K
BS6	1/2"	3/32"	3"	90g	-9060K



**HSS (SCD) Stub Centring Drills**

**HSS**

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



**135° Split Point - Series S510 - Metric**

Diameter (mm)	Flute Length	Overall Length	Order Code SHR-025
2.0	14.0	43.0	-1396A
3.0	18.0	49.0	-1396C
4.0	18.0	55.0	-1396E
5.0	18.0	62.0	-1396G
6.0	18.0	70.0	-1396J

**135° Split Point - Series S510 - Inch**

Diameter (Inch)	Flute Length	Overall Length	Order Code SHR-025
3/32"	9/16"	1 11/16"	-1400C
1/8"	11/16"	1 3/8"	-1400F
5/32"	11/16"	2 5/32"	-1400J
3/16"	11/16"	2 1/16"	-1400M
1/4"	3/4"	2 3/4"	-1400Q