



HSS Straight Shank Long Series Drills - Steam Tempered

HSS

Metalworking

General purpose drills to drill steels with tensile strength up to 1,000N/mm², cast steel, grey cast iron, malleable cast iron, nickel brass and graphite. Point angle: 118°, helix angle: normal, web thickness: normal, relief angle: 10° - 20°, tolerance of diameter: h8, tolerance of f11.
Manufactured to BS 328; Part 1: 1986, DIN 340 RN, ISO 494.



Series L100 - Metric

Dia. (mm)	Flute Length	Overall Length	Order Code SHR-025	Dia. (mm)	Flute Length	Overall Length	Order Code SHR-025	Dia. (mm)	Flute Length	Overall Length	Order Code SHR-025
1.00	33.0	56.0	-1420A	4.70	82.0	126.0	-1473H	10.10	121.0	184.0	-1538D
1.20	41.0	65.0	-1422C	4.80	87.0	132.0	-1475K	10.20	121.0	184.0	-1539E
1.30	41.0	65.0	-1423D	4.90	87.0	132.0	-1476L	10.40	121.0	184.0	-1542H
1.40	45.0	70.0	-1424E	5.00	87.0	132.0	-1477M	10.50	121.0	184.0	-1543J
1.50	45.0	70.0	-1425F	5.10	87.0	132.0	-1478N	11.00	128.0	195.0	-1549Q
1.60	50.0	76.0	-1426G	5.20	87.0	132.0	-1479P	11.50	128.0	195.0	-1555X
1.70	50.0	76.0	-1427H	5.30	87.0	132.0	-1481R	11.80	128.0	195.0	-1559B
1.80	53.0	80.0	-1429K	5.40	91.0	139.0	-1482S	12.00	134.0	205.0	-1561D
1.90	53.0	80.0	-1431M	5.50	91.0	139.0	-1483T	12.50	134.0	205.0	-1567K
2.00	56.0	85.0	-1433P	5.90	91.0	139.0	-1488N	13.00	134.0	205.0	-1573R
2.10	56.0	85.0	-1435R	6.00	91.0	139.0	-1489A	14.00	140.0	214.0	-1583C
2.30	59.0	90.0	-1439W	6.10	97.0	148.0	-1490B	15.00	144.0	220.0	-1587G
2.40	62.0	95.0	-1441Y	6.20	97.0	148.0	-1491C	16.00	149.0	227.0	-1591L
2.50	62.0	95.0	-1443A	6.30	97.0	148.0	-1493E	16.50	154.0	235.0	-1593N
2.60	62.0	95.0	-1445C	6.40	97.0	148.0	-1494F	17.00	154.0	235.0	-1595Q
2.80	66.0	100.0	-1449G	6.50	97.0	148.0	-1495G				
2.90	66.0	100.0	-1451J	6.60	97.0	148.0	-1496H				
3.00	66.0	100.0	-1453L	6.70	97.0	148.0	-1497J				
3.10	69.0	106.0	-1454M	6.80	102.0	156.0	-1499L				
3.20	69.0	106.0	-1455N	6.90	102.0	156.0	-1500M				
3.30	69.0	106.0	-1457Q	7.00	102.0	156.0	-1501N				
3.40	73.0	112.0	-1458R	7.20	102.0	156.0	-1503Q				
3.50	73.0	112.0	-1459S	7.50	102.0	156.0	-1507V				
3.60	73.0	112.0	-1460T	7.70	109.0	165.0	-1509X				
3.70	73.0	112.0	-1461V	8.00	109.0	165.0	-1513B				
3.80	78.0	119.0	-1463X	8.20	109.0	165.0	-1515D				
3.90	78.0	119.0	-1464Y	8.30	109.0	165.0	-1517F				
4.00	78.0	119.0	-1465N	8.50	109.0	165.0	-1519H				
4.10	78.0	119.0	-1466A	8.70	115.0	175.0	-1521K				
4.20	78.0	119.0	-1467B	9.00	115.0	175.0	-1525P				
4.30	82.0	126.0	-1469D	9.50	115.0	175.0	-1531W				
4.50	82.0	126.0	-1471F	10.00	121.0	184.0	-1537C				



HSS Long Series Drill Set

Used for deep hole drilling in most materials. (Not suitable for the drilling of holes in crankshafts).
Manufactured to BS 328 : Part 1 : 1986.

METRIC HSS



10
PIECES

mm		
2.0 - 10.0		
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	
Number of Pieces	Order Code	
10	SHR-025	
	-8540K	



HSS Straight Shank Long Series Drills - Bright Finish

HSS

General purpose drills to drill steels with tensile strength up to 1,000N/mm², cast steel, grey cast iron, malleable cast iron, nickel brass and graphite. Point angle: 118°, helix angle: normal, web thickness: normal, relief angle: 10° - 20°, tolerance of diameter: h8, tolerance of fl1. Manufactured to **BS 328; Part 1: 1986, DIN 340 RN, ISO 494**. 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.



Series L100B - Metric

Dia. (mm)	Flute Length	Overall Length	Order Code SHR-025	Dia. (mm)	Flute Length	Overall Length	Order Code SHR-025	Dia. (mm)	Flute Length	Overall Length	Order Code SHR-025
1.00	33.0	56.0	-1630A	3.30	69.0	106.0	-1631Q	6.50	97.0	148.0	-1633X
1.20	41.0	65.0	-1630E	3.50	73.0	112.0	-1631V	6.80	120.0	156.0	-1634D
1.50	45.0	70.0	-1630J	4.00	78.0	119.0	-1632C	7.00	120.0	156.0	-1634H
2.00	56.0	85.0	-1630Q	4.20	78.0	119.0	-1632F	8.00	109.0	165.0	-1635A
2.50	62.0	95.0	-1630Y	4.50	82.0	126.0	-1632L	8.50	109.0	165.0	-1635L
2.80	66.0	100.0	-1631B	5.00	87.0	132.0	-1632W	10.00	121.0	184.0	-1636N
3.00	66.0	100.0	-1631H	6.00	91.0	139.0	-1633P	12.00	134.0	205.0	-1637P
3.20	69.0	106.0	-1631N	6.30	97.0	148.0	-1633S				

SWISS+TECH HSS-Co Straight Shank Long Series Drills

HSS-Co

HEAVY DUTY

Heavy duty drill used for deep holes in steels with a tensile strength up to 1,400 N/mm². Stainless steels, heat and acid-resistant steels and hard bronze. Point angle: 135°. Helix angle: normal. Web thickness: strengthened. Relief angle: normal. Tolerance of diameter: h8. Tolerance of shank: f11. Manufacturing Standard: **DIN 340/BS328**.



Series 4000 - Metric

Diameter (mm)	Flute Length	Overall Length	Weight per 10	Order Code SWT-125	Diameter (mm)	Flute Length	Overall Length	Weight per 10	Order Code SWT-125
3.00	66.0	100.0	51g	-4030A	5.50	91.0	139.0	213g	-4055A
3.20	69.0	106.0	65g	-4032A	6.00	91.0	139.0	238g	-4060A
3.50	73.0	112.0	68g	-4035A	6.50	97.0	148.0	300g	-4065A
4.00	78.0	119.0	106g	-4040A	8.00	109.0	165.0	496g	-4080A
5.00	87.0	132.0	184g	-4050A	8.50	109.0	165.0	548g	-4085A
5.20	87.0	132.0	180g	-4052A					

SENATOR HSS Roll Forged Jobber Drill Sets

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**.

x 0.5mm
1.0 - 10.0



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	

19
PIECES

Weight each: 0.65kg
Order Code: **SEN-025 -9250K**

x 0.5mm
1.0 - 13.0



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

25
PIECES

Weight each: 1.60kg
Order Code: **SEN-025 -9150K**