



HSS Extra Length Drills - Steam Tempered

HSS

Metalworking

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 : Part 1 : 1986**.



Series E100 - Metric

Dia. (mm)	Flute Length	Overall Length	Order Code SHR-024	Dia. (mm)	Flute Length	Overall Length	Order Code SHR-024	Dia. (mm)	Flute Length	Overall Length	Order Code SHR-024
1.50	80.0	125.0	-2091B	5.00	150.0	200.0	-2116D	9.00	200.0	250.0	-2141F
1.50	100.0	160.0	-2092C	5.00	200.0	250.0	-2117E	9.00	250.0	315.0	-2142G
2.00	100.0	160.0	-2095F	5.00	250.0	315.0	-2118F	9.00	300.0	400.0	-2143H
2.50	80.0	125.0	-2097H	5.00	300.0	400.0	-2119G	9.50	200.0	250.0	-2144J
2.50	100.0	160.0	-2098J	5.50	150.0	200.0	-2120H	9.50	250.0	315.0	-2145K
2.50	150.0	200.0	-2098L	5.50	200.0	250.0	-2121J	10.00	200.0	250.0	-2146L
3.00	100.0	160.0	-2099K	6.00	150.0	200.0	-2123L	10.00	250.0	315.0	-2147M
3.00	150.0	200.0	-2100L	6.00	200.0	250.0	-2124M	10.00	300.0	400.0	-2148N
3.00	200.0	250.0	-2101M	6.00	250.0	315.0	-2125N	10.50	200.0	250.0	-2149P
3.30	100.0	160.0	-2102N	6.00	300.0	400.0	-2126P	10.50	250.0	315.0	-2150Q
3.30	150.0	200.0	-2102Q	6.50	150.0	200.0	-2127Q	11.00	200.0	250.0	-2152S
3.50	100.0	160.0	-2103P	6.50	200.0	250.0	-2128R	11.00	250.0	315.0	-2153T
3.50	200.0	250.0	-2105R	6.50	250.0	315.0	-2129S	11.00	300.0	400.0	-2154V
4.00	100.0	160.0	-2107T	7.00	150.0	200.0	-2130T	12.00	200.0	250.0	-2155W
4.00	150.0	200.0	-2108V	7.00	200.0	250.0	-2131V	12.00	250.0	315.0	-2156X
4.00	200.0	250.0	-2109W	7.00	250.0	315.0	-2132W	12.00	300.0	400.0	-2157Y
4.00	250.0	315.0	-2110X	7.50	250.0	315.0	-2135N	13.00	250.0	315.0	-2158N
4.50	100.0	160.0	-2111Y	8.00	200.0	250.0	-2136A	13.00	300.0	400.0	-2159A
4.50	150.0	200.0	-2112N	8.00	250.0	315.0	-2137B	14.00	250.0	315.0	-2160B
4.50	200.0	250.0	-2113A	8.00	300.0	400.0	-2138C	14.00	300.0	400.0	-2161C
4.50	250.0	315.0	-2114B	8.50	200.0	250.0	-2139D				
5.00	100.0	160.0	-2115C	8.50	250.0	315.0	-2140E				

Series E100 - Inch Sizes

Dia. (Inch)	Flute Length	Overall Length	Order Code SHR-024	Dia. (Inch)	Flute Length	Overall Length	Order Code SHR-024	Dia. (Inch)	Flute Length	Overall Length	Order Code SHR-024
3/16"	100.0	160.0	-1991B	3/16"	150.0	200.0	-2012N	5/16"	250.0	315.0	-2037B
3/32"	100.0	160.0	-1995F	3/16"	200.0	250.0	-2013A	3/8"	150.0	200.0	-2046Y
1/8"	100.0	160.0	-1998J	3/16"	200.0	315.0	-2014B	3/8"	200.0	250.0	-2047M
1/8"	150.0	200.0	-1999K	7/32"	150.0	200.0	-2019G	3/8"	250.0	315.0	-2048N
1/8"	200.0	250.0	-2000L	7/32"	200.0	250.0	-2020H	3/8"	300.0	400.0	-2049P
1/8"	250.0	315.0	-2001M	1/4"	150.0	200.0	-2024M	13/32"	250.0	315.0	-2052S
5/32"	100.0	160.0	-2004Q	1/4"	200.0	250.0	-2025N	1/2"	200.0	250.0	-2059A
5/32"	150.0	200.0	-2005R	1/4"	250.0	315.0	-2026P	1/2"	300.0	400.0	-2061C
11/64"	150.0	200.0	-2009W	1/4"	300.0	400.0	-2027Q				
3/16"	100.0	160.0	-2011Y	5/16"	150.0	200.0	-2035N				



HSS Reduced Shank Drills (Blacksmiths)

General purpose drills for light duty work, for drilling steels, cast iron, nickel brass and graphite. Reduced parallel shank 1/2". Point angle: 118°, helix angle: normal, web thickness: standard, tolerance of diameter: h8, tolerance of shank: 0.01/0.08. Manufactured to works standard.



HSS

Inch

Dia.	Flute Length	Overall Length	Order Code SHR-025	Dia.	Flute Length	Overall Length	Order Code SHR-025
3/16"	3 1/16"	6"	-1764E	3/4"	3 1/16"	6"	-1776S
5/8"	3 1/16"	6"	-1768J	13/16"	3 3/8"	6"	-1780X
4 1/64"	3 1/16"	6"	-1769K	7/8"	3 3/8"	6"	-1784B
1 1/16"	3 1/16"	6"	-1772N	1"	3 3/8"	6"	-1792K



6
PIECES



HSS Extra Length 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**.

HSS
METRIC

mm	
3.0 - 10.0	
3.0 x 160mm	6.0 x 200mm
4.0 x 160mm	8.0 x 250mm
5.0 x 200mm	10.0 x 250mm
Number of Pieces	Order Code
6	SHR-025
	-8600K

