

**HURRICANE • HIGH PERFORMANCE • SOLID CARBIDE • (5X) DRILL • STRAIGHT SHANK • ULTRA-BRONZE COATED**

HURRICANE • COOLANT FED

**NEW**

SERIES: 919

SIZES1/8" - 9/16"
INCH

High Performance, Solid Carbide, (5X) drill. Designed for ultra performance drilling in a broad range of materials, including mild steel, alloy steel, stainless steel, and super alloys. This solid carbide coolant drill combined with our advanced Ultra-Bronze coating makes this your drill of choice.

MATERIAL	BRIGHT	DARK	ULTRA-BRONZE
SOLID CARBIDE			●
SPECIFICATIONS			
Helix: 30°			
Point: 142°			
Web: Constant Rolled Heel			

DIAMETER		SHANK (IN.)	OAL (IN.)	FLUTE LENGTH (IN.)	PART NUMBER
INCH	DECIMAL				
1/8	0.1250	1/8	3.00	1.125	919-01250
9/64	0.1406	5/32	3.15	1.260	919-01406
5/32	0.1562	5/32	3.15	1.260	919-01562
11/64	0.1719	3/16	3.23	1.500	919-01719
3/16	0.1875	3/16	3.23	1.500	919-01875
13/64	0.2031	15/64	3.23	1.580	919-02031
7/32	0.2187	15/64	3.23	1.580	919-02187
15/64	0.2344	15/64	3.23	1.580	919-02344
1/4	0.2500	1/4	3.30	1.740	919-02500
17/64	0.2656	5/16	3.58	1.890	919-02656
9/32	0.2812	5/16	3.58	1.890	919-02812
19/64	0.2969	5/16	3.58	1.890	919-02969
5/16	0.3125	5/16	3.58	1.890	919-03125
21/64	0.3281	25/64	4.06	2.170	919-03281
11/32	0.3438	25/64	4.06	2.170	919-03438
23/64	0.3594	25/64	4.06	2.170	919-03594
3/8	0.3750	25/64	4.06	2.170	919-03750
25/64	0.3906	25/64	4.06	2.170	919-03906
13/32	0.4062	15/32	4.72	2.360	919-04062
27/64	0.4219	15/32	4.72	2.360	919-04219
7/16	0.4375	15/32	4.72	2.600	919-04375
15/32	0.4688	15/32	4.72	2.600	919-04688
31/64	0.4844	1/2	4.75	2.830	919-04844
1/2	0.5000	1/2	4.75	2.830	919-05000
33/64	0.5156	35/64	5.28	3.030	919-05156
35/64	0.5469	35/64	5.28	3.030	919-05469
9/16	0.5625	5/8	5.51	3.150	919-05625

TECHNICAL TIPS



We offer drill resharpening and reconditioning for all of our Drills. We also offer a variety of specialized drill points for specific applications. Please contact us for further information.



Visit our website at www.coolantfedtooling.com for technical information and our latest product offerings.



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HURRICANE • COOLANT FED



NEW

SERIES: M919

SIZES

3.0-14.0
MM

High Performance, Solid Carbide, (5X) metric drill. Designed for ultra performance drilling in a broad range of materials, including mild steel, alloy steel, stainless steel, and super alloys. This solid carbide coolant drill combined with our advanced Ultra-Bronze coating makes this your drill of choice.

MATERIAL	BRIGHT	DARK	ULTRA-BRONZE
SOLID CARBIDE			●
SPECIFICATIONS			
Helix: 30°			
Point: 142°			
Web: Constant Rolled Heel			

TOOL DIAMETER		SHANK DIA. (MM)	OAL (MM)	FLUTE LENGTH (MM)	PART NUMBER
MM	DECIMAL				
3.0	0.1181	3.0	75	24	M919-01181
3.2	0.1260	4.0	80	32	M919-01260
3.3	0.1299	4.0	80	32	M919-01299
3.4	0.1339	4.0	80	32	M919-01339
3.5	0.1378	4.0	80	32	M919-01378
3.7	0.1457	4.0	80	32	M919-01457
3.8	0.1496	4.0	80	32	M919-01496
4.0	0.1575	4.0	80	32	M919-01575
4.2	0.1654	5.0	82	38	M919-01654
4.5	0.1772	5.0	82	38	M919-01772
4.6	0.1811	5.0	82	38	M919-01811
4.8	0.1890	5.0	82	38	M919-01890
4.9	0.1929	5.0	82	38	M919-01929
5.0	0.1968	5.0	82	38	M919-01968
5.1	0.2008	6.0	82	40	M919-02008
5.2	0.2047	6.0	82	40	M919-02047
5.3	0.2087	6.0	82	40	M919-02087
5.4	0.2126	6.0	82	40	M919-02126
5.5	0.2165	6.0	82	40	M919-02165
5.7	0.2244	6.0	82	40	M919-02244
5.8	0.2283	6.0	82	40	M919-02283
5.9	0.2323	6.0	82	40	M919-02323
6.0	0.2362	6.0	82	40	M919-02362
6.1	0.2402	8.0	91	48	M919-02402
6.2	0.2441	8.0	91	48	M919-02441
6.3	0.2480	8.0	91	48	M919-02480
6.4	0.2520	8.0	91	48	M919-02520
6.5	0.2559	8.0	91	48	M919-02559
6.8	0.2667	8.0	91	48	M919-02677
6.9	0.2717	8.0	91	48	M919-02717
7.0	0.2756	8.0	91	48	M919-02756
7.2	0.2835	8.0	91	48	M919-02835
7.4	0.2913	8.0	91	48	M919-02913

Non-Stocked Items

TOOL DIAMETER		SHANK DIA. (MM)	OAL (MM)	FLUTE LENGTH (MM)	PART NUMBER
MM	DECIMAL				
7.5	0.2953	8.0	91	48	M919-02953
7.6	0.2992	8.0	91	48	M919-02992
7.7	0.3031	8.0	91	48	M919-03031
7.8	0.3071	8.0	91	48	M919-03071
8.0	0.3150	8.0	91	48	M919-03150
8.1	0.3189	10.0	103	55	M919-03189
8.2	0.3228	10.0	103	55	M919-03228
8.3	0.3268	10.0	103	55	M919-03268
8.5	0.3346	10.0	103	55	M919-03346
8.8	0.3465	10.0	103	55	M919-03465
8.9	0.3504	10.0	103	55	M919-03504
9.0	0.3543	10.0	103	55	M919-03543
9.2	0.3622	10.0	103	55	M919-03622
9.25	0.3642	10.0	103	55	M919-03642
9.3	0.3661	10.0	103	55	M919-03661
9.5	0.3740	10.0	103	55	M919-03740
9.7	0.3819	10.0	103	55	M919-03819
9.8	0.3858	10.0	103	55	M919-03858
10.0	0.3937	10.0	103	55	M919-03937
10.2	0.4016	12.0	120	60	M919-04016
10.5	0.4134	12.0	120	60	M919-04134
11.0	0.4331	12.0	120	60	M919-04331
11.2	0.4409	12.0	120	66	M919-04409
11.5	0.4527	12.0	120	66	M919-04527
11.7	0.4606	12.0	120	66	M919-04606
12.0	0.4724	12.0	120	66	M919-04724
12.1	0.4764	14.0	126	72	M919-04764
12.5	0.4921	14.0	126	72	M919-04921
12.8	0.5039	14.0	126	72	M919-05039
13.0	0.5118	14.0	126	72	M919-05118
13.5	0.5315	14.0	134	77	M919-05315
13.7	0.5394	14.0	134	77	M919-05394
14.0	0.5512	14.0	134	77	M919-05512

Non-Stocked Items

TECHNICAL TIPS



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**HURRICANE • HIGH PERFORMANCE • SOLID CARBIDE • (7X) DRILL • STRAIGHT SHANK • ULTRA-BRONZE COATED****HURRICANE • COOLANT FED**

SERIES: 920

SIZES1/8"-1/2"
INCH

High Performance, Solid Carbide, (7X) drill. Designed for ultra performance drilling in a broad range of materials, including mild steel, alloy steel, stainless steel, and super alloys. This solid carbide coolant drill combined with our advanced Ultra-Bronze coating makes this your drill of choice.

MATERIAL	BRIGHT	DARK	ULTRA-BRONZE
SOLID CARBIDE			●
SPECIFICATIONS			
Helix: 30°			
Point: 142°			
Web: Constant Rolled Heel			

TOOL DIAMETER		SHANK INCH	OAL INCH	FLUTE LENGTH INCH	PART NUMBER
INCH	DECIMAL				
1/8	0.1250	1/8	3.500	1.500	920-01250
9/64	0.1406	5/32	3.625	1.750	920-01406
5/32	0.1562	5/32	3.625	1.750	920-01562
11/64	0.1719	3/16	3.940	1.750	920-01719
3/16	0.1875	3/16	3.940	1.750	920-01875
13/64	0.2031	15/64	3.940	2.000	920-02031
7/32	0.2187	15/64	3.940	2.000	920-02187
15/64	0.2344	15/64	3.940	2.000	920-02344
1/4	0.2500	1/4	4.310	2.250	920-02500
17/64	0.2656	5/16	4.310	2.375	920-02656
9/32	0.2812	5/16	4.625	2.750	920-02812
19/64	0.2969	5/16	4.625	2.750	920-02969

TOOL DIAMETER		SHANK INCH	OAL INCH	FLUTE LENGTH INCH	PART NUMBER
INCH	DECIMAL				
5/16	0.3125	5/16	4.625	2.750	920-03125
21/64	0.3281	25/64	5.000	3.150	920-03281
11/32	0.3438	25/64	5.000	3.150	920-03438
23/64	0.3594	25/64	5.312	3.340	920-03594
3/8	0.3750	25/64	5.312	3.340	920-03750
25/64	0.3906	25/64	5.312	3.340	920-03906
13/32	0.4062	15/32	5.875	3.625	920-04062
27/64	0.4219	15/32	5.875	3.625	920-04219
7/16	0.4375	15/32	6.100	4.000	920-04375
15/32	0.4688	15/32	6.100	4.000	920-04688
31/64	0.4844	1/2	6.299	4.132	920-04844
1/2	0.5000	1/2	6.299	4.132	920-05000

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SERIES: M920

SIZES3.0-12.0
MM

High Performance, Solid Carbide, (7X) metric drill. Designed for ultra performance drilling in a broad range of materials, including mild steel, alloy steel, stainless steel, and super alloys. This solid carbide coolant drill combined with our advanced Ultra-Bronze coating makes this your drill of choice.

MATERIAL	BRIGHT	DARK	ULTRA-BRONZE
SOLID CARBIDE			●
SPECIFICATIONS			
Helix: 30°			
Point: 142°			
Web: Constant Rolled Heel			

TOOL DIAMETER		SHANK MM	OAL MM	FLUTE LENGTH MM	PART NUMBER
MM	DECIMAL				
3.0	0.1181	3.0	81	33	M920-01181
3.2	0.1260	4.0	92	44	M920-01260
3.3	0.1299	4.0	92	44	M920-01299
3.4	0.1339	4.0	92	44	M920-01339
3.5	0.1378	4.0	92	44	M920-01378
3.7	0.1457	4.0	92	44	M920-01457
3.8	0.1496	4.0	92	44	M920-01496
4.0	0.1575	4.0	92	44	M920-01575
4.2	0.1654	5.0	100	45	M920-01654
4.5	0.1772	5.0	100	45	M920-01772
4.6	0.1811	5.0	100	45	M920-01811
4.8	0.1890	5.0	100	45	M920-01890
4.9	0.1929	5.0	100	45	M920-01929
5.0	0.1968	5.0	100	45	M920-01968
5.1	0.2008	6.0	100	51	M920-02008
5.2	0.2047	6.0	100	51	M920-02047
5.3	0.2087	6.0	100	51	M920-02087
5.4	0.2126	6.0	100	51	M920-02126
5.5	0.2165	6.0	100	51	M920-02165
5.7	0.2244	6.0	100	51	M920-02244
5.8	0.2283	6.0	100	51	M920-02283
5.9	0.2323	6.0	100	51	M920-02323
6.0	0.2362	6.0	100	51	M920-02362
6.1	0.2402	8.0	109	60	M920-02402
6.2	0.2441	8.0	109	60	M920-02441
6.3	0.2480	8.0	109	60	M920-02480
6.4	0.2520	8.0	109	60	M920-02520
6.5	0.2559	8.0	109	60	M920-02559
6.8	0.2667	8.0	109	60	M920-02677
6.9	0.2717	8.0	109	60	M920-02717

Non-Stocked Items

TOOL DIAMETER		SHANK MM	OAL MM	FLUTE LENGTH MM	PART NUMBER
MM	DECIMAL				
7.0	0.2756	8.0	109	60	M920-02756
7.2	0.2835	8.0	118	70	M920-02835
7.4	0.2913	8.0	118	70	M920-02913
7.5	0.2953	8.0	118	70	M920-02953
7.6	0.2992	8.0	118	70	M920-02992
7.7	0.3031	8.0	118	70	M920-03031
7.8	0.3071	8.0	118	70	M920-03071
8.0	0.3150	8.0	118	70	M920-03150
8.1	0.3189	10.0	127	80	M920-03189
8.2	0.3228	10.0	127	80	M920-03228
8.3	0.3268	10.0	127	80	M920-03268
8.5	0.3346	10.0	127	80	M920-03346
8.8	0.3465	10.0	127	80	M920-03465
8.9	0.3504	10.0	127	80	M920-03504
9.0	0.3543	10.0	127	80	M920-03543
9.2	0.3622	10.0	136	85	M920-03622
9.25	0.3642	10.0	136	85	M920-03642
9.3	0.3661	10.0	136	85	M920-03661
9.5	0.3740	10.0	136	85	M920-03740
9.7	0.3819	10.0	136	85	M920-03819
9.8	0.3858	10.0	136	85	M920-03858
10.0	0.3937	10.0	136	85	M920-03937
10.2	0.4016	12.0	149	93	M920-04016
10.5	0.4134	12.0	149	93	M920-04134
11.0	0.4331	12.0	149	93	M920-04331
11.2	0.4409	12.0	155	102	M920-04409
11.5	0.4527	12.0	155	102	M920-04527
11.7	0.4606	12.0	155	102	M920-04606
12.0	0.4724	12.0	155	102	M920-04724

Non-Stocked Items



HIGH PERFORMANCE JOBBER LENGTH • SOLID CARBIDE • TIN COATED • STRAIGHT SHANK

SERIES 910 • COOLANT-FED



SERIES: 910

SIZES

3/16"-1/2"
INCH

High performance, C2 10% Micro Grain Carbide drill with helical coolant holes designed for deep holes 5x diameter. Successfully drills stainless such as 304 and 315, nickel alloy materials, cast iron aluminum and some carbon steels. Increase production with higher speed/feed rates and decreased cycle times.

MATERIAL	BRIGHT	DARK	TIN
C2 MICROGRAIN			●
SPECIFICATIONS			
Helix: 30° Standard			
Point: 135° S point			
Web: Standard			

TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
INCH	DECIMAL				
* 3/16	0.1875	0.1875	1-5/8	2-3/4	910-01875
* 13/64	0.2031	0.2031	1-3/4	3	910-02031
* 7/32	0.2187	0.2187	1-3/4	3	910-02187
* 15/64	0.2344	0.2344	2	3-1/4	910-02344
* 1/4	0.2500	0.2500	2	3-1/4	910-02500
* 17/64	0.2656	0.2656	2-1/8	3-1/2	910-02656
* 9/32	0.2812	0.2812	2-1/8	3-1/2	910-02812
* 19/64	0.2969	0.2969	2-3/8	3-3/4	910-02969
* 5/16	0.3125	0.3125	2-3/8	3-3/4	910-03125
* 21/64	0.3281	0.3281	2-1/2	4	910-03281
* 11/32	0.3438	0.3438	2-1/2	4	910-03438
* 23/64	0.3594	0.3594	2-3/4	4-1/4	910-03594

* **Outgoing Items**

TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
INCH	DECIMAL				
* 3/8	0.3750	0.3750	2-3/4	4-1/4	910-03750
* 25/64	0.3906	0.3906	2-7/8	4-1/2	910-03906
* 13/32	0.4062	0.4062	2-7/8	4-1/2	910-04062
* 27/64	0.4219	0.4219	2-7/8	4-1/2	910-04219
* 7/16	0.4375	0.4375	2-7/8	4-1/2	910-04375
* 29/64	0.4531	0.4531	3	4-3/4	910-04531
* 15/32	0.4688	0.4688	3	4-3/4	910-04688
* 31/64	0.4844	0.4844	3	4-3/4	910-04844
* 1/2	0.5000	0.5000	3	4-3/4	910-05000

* **Outgoing Items**

HIGH PERFORMANCE JOBBER LENGTH • SOLID CARBIDE • TiAIN COATED • STRAIGHT SHANK

SERIES 911 • COOLANT-FED



SERIES: 911

SIZES

3/16" - 1/2"
INCH

High performance, C5 tough steel grade carbide with helical coolant holes for deep holes 5x diameter. Designed with a special shaped chisel edge for drilling tough low carbon steel applications at high speeds while maintaining accuracy, straightness and finish. Increase production with higher speed/feed rates and decreased cycle times.

MATERIAL	BRIGHT	DARK	TiAIN
C5 MICROGRAIN			●
SPECIFICATIONS			
Helix: 30° Standard			
Point: 135° S point			
Web: Standard			

TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
INCH	DECIMAL				
* 3/16	0.1875	0.1875	1-5/8	2-3/4	911-01875
* 13/64	0.2031	0.2031	1-3/4	3	911-02031
* 7/32	0.2187	0.2187	1-3/4	3	911-02187
* 15/64	0.2344	0.2344	2	3-1/4	911-02344
* 1/4	0.2500	0.2500	2	3-1/4	911-02500
* 17/64	0.2656	0.2656	2-1/8	3-1/2	911-02656
* 9/32	0.2812	0.2812	2-1/8	3-1/2	911-02812
* 19/64	0.2969	0.2969	2-3/8	3-3/4	911-02969
* 5/16	0.3125	0.3125	2-3/8	3-3/4	911-03125
* 21/64	0.3281	0.3281	2-1/2	4	911-03281
* 11/32	0.3438	0.3438	2-1/2	4	911-03438

* **Outgoing Items**

TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
INCH	DECIMAL				
* 23/64	0.3593	0.3594	2-3/4	4-1/4	911-03594
* 3/8	0.3750	0.3750	2-3/4	4-1/4	911-03750
* 25/64	0.3906	0.3906	2-7/8	4-1/2	911-03906
* 13/32	0.4062	0.4062	2-7/8	4-1/2	911-04062
* 27/64	0.4219	0.4219	2-7/8	4-1/2	911-04219
* 7/16	0.4375	0.4375	2-7/8	4-1/2	911-04375
* 29/64	0.4531	0.4531	3	4-3/4	911-04531
* 15/32	0.4688	0.4688	3	4-3/4	911-04688
* 31/64	0.4844	0.4844	3	4-3/4	911-04844
* 1/2	0.5000	0.5000	3	4-3/4	911-05000

* **Outgoing Items**



HIGH PERFORMANCE JOBBER LENGTH • METRIC • SOLID CARBIDE • TIN COATED • STRAIGHT SHANK

SERIES M910 • COOLANT-FED



SERIES: M910

SIZES

4.0-11.0
MM

High performance, C2 10% Micro Grain Carbide drill with helical coolant holes designed for deep holes 5x diameter. Successfully drills stainless such as 304 and 315, nickel alloy materials, cast iron aluminum and some carbon steels. Increase production with higher speed/feed rates and decreased cycle times.

C2 MICROGRAIN	BRIGHT	DARK	TIN
			●
SPECIFICATIONS			
Helix: 30° Standard			
Point: 135° S point			
Web: Standard			

TOOL DIAMETER		SHANK DIA. (MM)	FLUTE LENGTH (MM)	OAL (MM)	PART NUMBER
MM	DECIMAL				
* 4.00	0.1575	6.0	36	74	M910-01575
* 4.50	0.1772	6.0	36	74	M910-01772
* 4.80	0.1890	6.0	44	82	M910-01890
* 5.00	0.1968	6.0	44	82	M910-01968
* 5.50	0.2165	6.0	44	82	M910-02165
* 5.80	0.2283	6.0	44	82	M910-02283
* 6.00	0.2362	6.0	44	82	M910-02362
* 6.50	0.2559	8.0	53	91	M910-02559
* 6.80	0.2677	8.0	53	91	M910-02677
* 7.00	0.2756	8.0	53	91	M910-02756
* 7.50	0.2953	8.0	53	91	M910-02953
* 7.80	0.3071	8.0	53	91	M910-03071

* Outgoing Items

TOOL DIAMETER		SHANK DIA. (MM)	FLUTE LENGTH (MM)	OAL (MM)	PART NUMBER
MM	DECIMAL				
* 8.00	0.3150	8.0	53	91	M910-03150
* 8.50	0.3346	10.0	61	103	M910-03346
* 8.80	0.3465	10.0	61	103	M910-03465
* 9.00	0.3543	10.0	61	103	M910-03543
* 9.50	0.3740	10.0	61	103	M910-03750
* 9.80	0.3858	10.0	61	103	M910-03858
* 10.00	0.3937	10.0	61	103	M910-03937
* 10.20	0.4016	12.0	71	118	M910-04016
* 10.50	0.4134	12.0	71	118	M910-04134
* 10.80	0.4252	12.0	71	118	M910-04252
* 11.00	0.4331	12.0	71	118	M910-04331

* Outgoing Items

HIGH PERFORMANCE JOBBER LENGTH • METRIC • SOLID CARBIDE • TiAIN COATED • STRAIGHT SHANK

SERIES M911 • COOLANT-FED



SERIES: M911

SIZES

4.0-11.0
MM

High performance, C5 tough steel grade carbide with helical coolant holes for deep holes 5x diameter. Designed with a special shaped chisel edge for drilling tough low carbon steel applications at high speeds while maintaining accuracy, straightness and finish. Increase production with higher speed/feed rates and decreased cycle times.

C5 MICROGRAIN	BRIGHT	DARK	TiAIN
			●
SPECIFICATIONS			
Helix: 30° Standard			
Point: 135° S point			
Web: Standard			

TOOL DIAMETER		SHANK DIA. (MM)	FLUTE LENGTH (MM)	OAL (MM)	PART NUMBER
MM	DECIMAL				
* 4.00	0.1575	6.0	36	74	M911-01575
* 4.50	0.1772	6.0	36	74	M911-01772
* 4.80	0.1890	6.0	44	82	M911-01890
* 5.00	0.1968	6.0	44	82	M911-01968
* 5.50	0.2165	6.0	44	82	M911-02165
* 5.80	0.2283	6.0	44	82	M911-02283
* 6.00	0.2362	6.0	44	82	M911-02362
* 6.50	0.2559	8.0	53	91	M911-02559
* 6.80	0.2677	8.0	53	91	M911-02677
* 7.00	0.2756	8.0	53	91	M911-02756
* 7.50	0.2953	8.0	53	91	M911-02953
* 7.80	0.3071	8.0	53	91	M911-03071

* Outgoing Items

TOOL DIAMETER		SHANK DIA. (MM)	FLUTE LENGTH (MM)	OAL (MM)	PART NUMBER
MM	DECIMAL				
* 8.00	0.3150	8.0	53	91	M911-03150
* 8.50	0.3346	10.0	61	103	M911-03346
* 8.80	0.3465	10.0	61	103	M911-03465
* 9.00	0.3543	10.0	61	103	M911-03543
* 9.50	0.3740	10.0	61	103	M911-03750
* 9.80	0.3858	10.0	61	103	M911-03858
* 10.00	0.3937	10.0	61	103	M911-03937
* 10.20	0.4016	12.0	71	118	M911-04016
* 10.50	0.4134	12.0	71	118	M911-04134
* 10.80	0.4252	12.0	71	118	M911-04252
* 11.00	0.4331	12.0	71	118	M911-04331

* Outgoing Items



HIGH PERFORMANCE EXTENDED LENGTH TWIST DRILL • SOLID CARBIDE/ULTRA-GOLD COATED/TWO FLUTE PARABOLIC • COMMON SHANK

SERIES 912 • COOLANT-FED



SERIES: 912

SIZES

3/16" - 17/32"
INCH

The Helical Wear Resistant (HWR) point is self-centering, eliminating the need for center drilling and is a low torque, free chip forming design with excellent edge retention when combined with this unique flute form. The parabolic flute eliminates the necessity of "pecking" to clear chips while allowing for much longer useful tool life in regrinding. The combination of unique flute and point configuration provides up to 2.5 times the strength of conventional drill designs. Recommended for non-ferrous materials such as aluminum and aluminum alloys, free machining stainless steel, steel and cast iron and composites.

MATERIAL	BRIGHT	DARK	ULTRA GOLD
Solid Carbide			●
SPECIFICATIONS			
Helix: 30°-40° Variable			
Point: 142° HWR			
Web: Parabolic			

TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
INCH	DECIMAL				
3/16	0.1875	0.2500	4	6	912-01875
13/64	0.2031	0.2500	4	6	912-02031
7/32	0.2188	0.2500	4	6	912-02188
15/64	0.2344	0.2500	4	6	912-02344
1/4	0.2500	0.2500	4	6	912-02500
17/64	0.2656	0.3750	4	6	912-02656
9/32	0.2812	0.3750	4	6	912-02812
19/64	0.2969	0.3750	4	6	912-02969
5/16	0.3125	0.3750	4	6	912-03125
21/64	0.3281	0.3750	4	6	912-03281
11/32	0.3438	0.3750	4	6	912-03438
23/64	0.3594	0.3750	4	6	912-03594
3/8	0.3750	0.3750	4	6	912-03750
25/64	0.3906	0.5000	4	6	912-03906
13/32	0.4062	0.5000	4	6	912-04062
27/64	0.4219	0.5000	4	6	912-04219
7/16	0.4375	0.5000	4	6	912-04375
29/64	0.4531	0.5000	4	6	912-04531
15/32	0.4688	0.5000	4	6	912-04688
31/64	0.4844	0.5000	4	6	912-04844
1/2	0.5000	0.5000	4	6	912-05000
33/64	0.5156	0.6250	4	6	912-05156
17/32	0.5312	0.6250	4	6	912-05312

HIGH PERFORMANCE EXTENDED LENGTH TWIST DRILL • SOLID CARBIDE/ULTRA-GOLD COATED/THREE FLUTE PARABOLIC • COMMON SHANK

SERIES 914 • COOLANT-FED



SERIES: 914

SIZES

3/16" - 17/32"
INCH

Designed for a broad spectrum of materials from aluminum, brass, bronze and cast iron to stainless and hardened steels. This design generally provides for a rounder and straighter hole with closer hole tolerances and better hole wall finishes than most conventional two flute drills. Our special 150° point cuts all the way to the center which will allow the drill to start immediately without "walking" while providing excellent chip formation without tearing at or near the center like most other manufacturers' three lip points.


MATERIAL	BRIGHT	DARK	ULTRA GOLD
Solid Carbide			●
SPECIFICATIONS			
Helix: 30°-40° Variable			
Point: 150° 3 Flute			
Web: Standard			

TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
INCH	DECIMAL				
3/16	0.1875	0.2500	4	6	914-01875
13/64	0.2031	0.2500	4	6	914-02031
7/32	0.2188	0.2500	4	6	914-02188
15/64	0.2344	0.2500	4	6	914-02344
1/4	0.2500	0.2500	4	6	914-02500
17/64	0.2656	0.3750	4	6	914-02656
9/32	0.2812	0.3750	4	6	914-02812
19/64	0.2969	0.3750	4	6	914-02969
5/16	0.3125	0.3750	4	6	914-03125
21/64	0.3281	0.3750	4	6	914-03281
11/32	0.3438	0.3750	4	6	914-03438
23/64	0.3594	0.3750	4	6	914-03594
3/8	0.3750	0.3750	4	6	914-03750
25/64	0.3906	0.5000	4	6	914-03906
13/32	0.4062	0.5000	4	6	914-04062
27/64	0.4219	0.5000	4	6	914-04219
7/16	0.4375	0.5000	4	6	914-04375
29/64	0.4531	0.5000	4	6	914-04531
15/32	0.4688	0.5000	4	6	914-04688
31/64	0.4844	0.5000	4	6	914-04844
1/2	0.5000	0.5000	4	6	914-05000
33/64	0.5156	0.6250	4	6	914-05156
17/32	0.5312	0.6250	4	6	914-05312




HIGH PERFORMANCE JOBBER LENGTH TWIST DRILL • SOLID CARBIDE/AITIN COATED • COMMON

SERIES 916 • COOLANT-FED / SERIES M916 (METRIC) • COOLANT-FED



NEW



MATERIAL	BRIGHT	DARK	AITIN
Solid Carbide			●

SPECIFICATIONS

Helix: 27° Standard

Point: 142° HP

Web: Standard

SERIES: 916 SERIES: M916

SIZES	SIZES
3/16" - 1/2" INCH	5.0 - 11.0 MM

10% Micro-grain Solid Carbide. High performance solid carbide drill designed for drilling in stainless steels and high temperature alloy materials. 142 high performance point in conjunction with the AITIN coating improves chip clearance and extends tool life in these difficult to machine materials. Common shank sizes for use with Shrink-Fit © and other precision toolholders. Depths to 5x diameter.

SERIES 916 • COOLANT-FED

SERIES M916 (METRIC) • COOLANT-FED

TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
INCH	DECIMAL				
3/16	0.1875	0.1875	1-5/8	2-3/4	916-01875
13/64	0.2031	0.2344	1-3/4	3	916-02031
7/32	0.2187	0.2500	1-3/4	3	916-02187
15/64	0.2344	0.2500	2	3-1/4	916-02344
1/4	0.2500	0.2500	2	3-1/4	916-02500
17/64	0.2656	0.3125	2-1/8	3-1/2	916-02656
9/32	0.2812	0.3125	2-1/8	3-1/2	916-02812
19/64	0.2969	0.3125	2-3/8	3-3/4	916-02969
5/16	0.3125	0.3125	2-3/8	3-3/4	916-03125
21/64	0.3281	0.3750	2-1/2	4	916-03281
11/32	0.3438	0.3750	2-1/2	4	916-03438
23/64	0.3594	0.3750	2-3/4	4-1/4	916-03594
3/8	0.3750	0.3750	2-3/4	4-1/4	916-03750
25/64	0.3906	0.4375	2-7/8	4-1/2	916-03906
13/32	0.4062	0.4375	2-7/8	4-1/2	916-04062
27/64	0.4219	0.4375	2-7/8	4-1/2	916-04219
7/16	0.4375	0.4375	2-7/8	4-1/2	916-04375
29/64	0.4531	0.5000	3	4-3/4	916-04531
15/32	0.4688	0.5000	3	4-3/4	916-04688
31/64	0.4844	0.5000	3	4-3/4	916-04844
1/2	0.5000	0.5000	3	4-3/4	916-05000

TOOL DIAMETER		SHANK DIA. (MM)	FLUTE LENGTH (MM)	OAL (MM)	PART NUMBER
MM	DECIMAL				
5.00	0.1968	6.0	44	82	M916-01968
5.50	0.2165	6.0	44	82	M916-02165
5.80	0.2283	6.0	44	82	M916-02283
6.00	0.2362	6.0	44	82	M916-02362
6.50	0.2559	8.0	53	91	M916-02559
6.80	0.2677	8.0	53	91	M916-02677
7.00	0.2756	8.0	53	91	M916-02756
7.50	0.2953	8.0	53	91	M916-02953
7.80	0.3071	8.0	53	91	M916-03071
8.00	0.3150	8.0	53	91	M916-03150
8.50	0.3346	10.0	61	103	M916-03346
8.80	0.3465	10.0	61	103	M916-03465
9.00	0.3543	10.0	61	103	M916-03543
9.50	0.3740	10.0	61	103	M916-03740
9.80	0.3858	10.0	61	103	M916-03858
10.00	0.3937	10.0	61	103	M916-03937
10.20	0.4016	12.0	71	118	M916-04016
10.50	0.4134	12.0	71	118	M916-04134
11.00	0.4331	12.0	71	118	M916-04331

TECHNICAL TIPS



Visit our website at www.coolantfedtooling.com for technical information and our latest product offerings.

REQUIRED FOR SPEED AND FEED INFORMATION:

- Material being drilled
- Rockwell (Rc) or Brinell (Bhn) Hardness
- Diameter and Depth of Hole
- Vertical or Horizontal Orientation
- Coolant Pressure of the Machine Tools Coolant Pump
- Type of Tool Holders being used (i.e., Collet Chuck)



HIGH PERFORMANCE EXTENDED LENGTH TWIST DRILL • SOLID CARBIDE/AITIN COATED • COMMON

SERIES 917 • COOLANT-FED / SERIES M917 (METRIC) • COOLANT-FED

NEW



SERIES: 917	SERIES: M917
SIZES	SIZES
3/16" - 1/2" INCH	5.0 - 11.0 MM

10% Micro-grain Solid Carbide. High performance solid carbide drill designed for drilling in stainless steels and high temperature alloy materials. 142 high performance point in conjunction with the AITIN coating improves chip clearance and extends tool life in these difficult to machine materials. Common shank sizes for use with Shrink-Fit © and other precision toolholders. Depths to 7x diameter. Slotted coolant entry.

MATERIAL	BRIGHT	DARK	AITIN
Solid Carbide			●
SPECIFICATIONS			
Helix: 30° Standard			
Point: 142°			
Web: Standard			

SERIES 917 • COOLANT-FED

SERIES M917 (METRIC) • COOLANT-FED

TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
INCH	DECIMAL				
3/16	0.1875	0.1875	1-13/16	3-7/8	917-01875
7/32	0.2187	0.2344	2-1/8	4-13/64	917-02187
15/64	0.2344	0.2344	2-1/8	4-13/64	917-02344
1/4	0.2500	0.2500	2-1/4	4-3/8	917-02500
17/64	0.2656	0.3125	2-17/32	5	917-02656
9/32	0.2812	0.3125	2-17/32	5	917-02812
19/64	0.2969	0.3125	2-13/16	5	917-02969
5/16	0.3125	0.3125	2-13/16	5	917-03125
21/64	0.3281	0.3750	3-1/8	5-25/32	917-03281
11/32	0.3438	0.3750	3-1/8	5-25/32	917-03438
3/8	0.3750	0.3750	3-3/8	5-25/32	917-03750
25/64	0.3906	0.4375	3-11/16	6-3/4	917-03906
13/32	0.4062	0.4375	3-11/16	6-3/4	917-04062
27/64	0.4219	0.4375	3-15/16	6-3/4	917-04219
7/16	0.4375	0.4375	3-15/16	6-3/4	917-04375
1/2	0.5000	0.5000	4-1/2	7	917-05000

TOOL DIAMETER		SHANK DIA. (MM)	FLUTE LENGTH (MM)	OAL (MM)	PART NUMBER
MM	DECIMAL				
5.00	0.1968	5.0	45	98	M917-01968
5.50	0.2165	6.0	50	107	M917-02165
6.00	0.2362	6.0	55	107	M917-02362
6.50	0.2559	8.0	62	127	M917-02559
7.00	0.2756	8.0	67	127	M917-02756
7.50	0.2953	8.0	73	127	M917-02953
8.00	0.3150	8.0	73	127	M917-03150
8.50	0.3346	10.0	78	147	M917-03346
9.00	0.3543	10.0	83	147	M917-03543
9.50	0.3740	10.0	91	147	M917-03740
10.00	0.3937	10.0	91	147	M917-03937
10.50	0.4134	12.0	102	171	M917-04134
11.00	0.4331	12.0	102	171	M917-04331

COMMON MACHINING EQUATIONS

SFM =	RPM X Dia. / 3.82
RPM =	3.82 x SFM / Dia.
IPM =	IPT x No. Teeth x RPM
IPT =	IPM / (No. Teeth x RPM)
IPR =	IPM / RPM

- SFM:** SURFACE FEET PER MINUTE
- RPM:** REVOLUTIONS PER MINUTE
- IPM:** INCHES PER MINUTE
- IPT:** INCHES PER TOOTH
- IPR:** INCHES PER REVOLUTION

TECHNICAL TIPS



We offer drill resharpening and reconditioning for all of our Drills. We also offer a variety of specialized drill points for specific applications. Please contact us for further information.



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HIGH PERFORMANCE JOBBER LENGTH TWIST DRILL • SOLID CARBIDE • COMMON SHANK/AITIN COATED

SERIES 918 • COOLANT-FED / SERIES M918 (METRIC) • COOLANT-FED



SERIES: 918	SERIES: M918
SIZES	SIZES
3/16" - 1/2" INCH	6.00 - 11.00 MM

10% Micro-grain Solid Carbide. High performance solid carbide drill with double margin and 18 degree helix designed for drilling in gray and ductile cast iron and other ferrous materials. 142 high performance point and helix design, in conjunction with the AITIN coating, allows greater strength, and extends tool life in these applications. Common shank sizes for use with Shrink-Fit ® and other precision toolholders. Depths to 5x diameter.

MATERIAL	BRIGHT	DARK	AITIN
Solid Carbide			●
SPECIFICATIONS			
Helix: 18° Double Margin			
Point: 142° S point			
Web: Standard			

SERIES 918 • COOLANT-FED

TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
INCH	DECIMAL				
3/16	0.1875	0.1875	1-3/8	3-27/64	918-01875
7/32	0.2187	0.2344	1-11/16	3-45/64	918-02187
15/64	0.2344	0.2344	1-11/16	3-45/64	918-02344
1/4	0.2500	0.2500	1-3/4	3-7/8	918-02500
17/64	0.2656	0.3125	2	4-5/16	918-02656
9/32	0.2812	0.3125	2-3/16	4-5/16	918-02812
19/64	0.2969	0.3125	2-3/16	4-5/16	918-02969
5/16	0.3125	0.3125	2-3/16	4-5/16	918-03125
21/64	0.3281	0.3750	2-3/8	4-61/64	918-03281
11/32	0.3438	0.3750	2-5/8	4-61/64	918-03438
3/8	0.3750	0.3750	2-5/8	4-61/64	918-03750
25/64	0.3906	0.4375	2-7/8	5-47/64	918-03906
13/32	0.4062	0.4375	3-1/16	5-47/64	918-04062
27/64	0.4219	0.4375	3-1/16	5-47/64	918-04219
7/16	0.4375	0.4375	3-1/16	5-47/64	918-04375
1/2	0.5000	0.5000	3-1/4	5-7/8	918-05000

SERIES M918 (METRIC) • COOLANT-FED

TOOL DIAMETER		SHANK DIA. (MM)	FLUTE LENGTH (MM)	OAL (MM)	PART NUMBER
MM	DECIMAL				
6.00	0.2362	6.0	42	94	M918-02362
7.00	0.2756	8.0	52	110	M918-02756
8.00	0.3150	8.0	56	110	M918-03150
8.50	0.3346	10.0	62	126	M918-03346
9.00	0.3543	10.0	70	126	M918-03543
9.50	0.3740	10.0	70	126	M918-03740
10.00	0.3937	10.0	70	126	M918-03937
11.00	0.4331	12.0	78	146	M918-04331

HIGH PERFORMANCE JOBBER LENGTH TWIST DRILL • H.S. COBALT ASP 30 POWDERED METAL/HARDLUBE COATED • FAST SPIRAL, PARABOLIC FLUTE

SERIES 609 • COOLANT-FED



SERIES: 609	SERIES: 609
SIZES	SIZES
5/32" - 1/2" INCH	4.0 - 12.50 MM

Performs similar to carbide, but is more suitable for a wider range of materials and machine tools. The hardlube treatment with tungsten carbide is excellent for chip evacuation, extending tool life and cutting edge durability. Manufactured with ASP 30 Powdered Metal for longer life and consistent performance. 135 degree split point is suitable for drilling aluminum, tough alloys, standard alloys, stainless steel and tool steel.

MATERIAL	BRIGHT	DARK	HARDLUBE
ASP 30			●
SPECIFICATIONS			
Helix: 32° Parabolic			
Point: 135° Split Point			
Web: Heavy			

TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
INCH/MM	DECIMAL				
5/32	0.1562	0.1562	1-3/4	4-1/4	609-01562
4.00 MM	0.1575	0.1575	1-3/4	4-1/4	609-01575
11/64	0.1718	0.1718	1-3/4	4-1/4	609-01718
3/16	0.1875	0.1875	1-3/4	4-1/4	609-01875
13/64	0.2031	0.2031	1-3/4	4-1/4	609-02031
5.50 MM	0.2165	0.2165	1-3/4	4-1/4	609-02165
6.00 MM	0.2362	0.2362	1-3/4	4-1/4	609-02362
1/4	0.2500	0.2500	1-3/4	4-1/4	609-02500
6.50 MM	0.2559	0.2559	1-7/8	4-3/8	609-02559
17/64	0.2656	0.2656	1-7/8	4-3/8	609-02656
"1"	0.2720	0.2720	2	4-1/2	609-02720
9/32	0.2812	0.2812	2	4-1/2	609-02812
19/64	0.2968	0.2968	2	4-1/2	609-02968
5/16	0.3125	0.3125	2-3/16	4-3/4	609-03125
8.00 MM	0.3150	0.3150	2-1/4	4-3/4	609-03150
21/64	0.3281	0.3281	2-1/4	4-3/4	609-03281

TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
INCH/MM	DECIMAL				
8.50 MM	0.3346	0.3346	2-3/8	4-7/8	609-03346
11/32	0.3437	0.3437	2-3/8	4-7/8	609-03437
23/64	0.3593	0.3593	2-1/2	5	609-03593
"U"	0.3680	0.3680	2-5/8	5-1/8	609-03680
3/8	0.3750	0.3750	2-5/8	5-1/8	609-03750
25/64	0.3906	0.3906	2-3/4	5-3/8	609-03906
13/32	0.4062	0.4062	2-7/8	5-1/2	609-04062
27/64	0.4218	0.4218	3	5-5/8	609-04218
7/16	0.4375	0.4375	3	5-5/8	609-04375
29/64	0.4531	0.4531	3-1/8	5-3/4	609-04531
15/32	0.4687	0.4687	3-1/4	5-7/8	609-04687
12.00 MM	0.4724	0.4724	3-3/8	6	609-04724
31/64	0.4843	0.4843	3-3/8	6	609-04843
12.50 MM	0.4921	0.4921	3-1/2	6	609-04921
1/2	0.5000	0.5000	3-1/2	6	609-05000



SPOTTING DRILL • COBALT • STRAIGHT SHANK

SERIES 605 • COOLANT-FED



EXPANDED



SERIES: 605

SIZES

1/4" - 1"
INCH

High performance spot drill designed to prevent work hardening conditions caused by lack of lubrication at the drill point on tough or hard materials. Provides fast accurate spotting and single operation centering and chamfering. Match spot drill and follow-up drill point angles to reduce chance of chipping the follow-up drill during initial penetration. Zero body clearance prohibits drilling beyond point angle.

MATERIAL	BRIGHT	DARK	TIN
HSS	●		●
SPECIFICATIONS			
Helix: 22°-24° Standard			
Point: 90°, 120°, 135°, 145°			
Web: Standard			

TOOL DIAMETER INCH	DECIMAL	SHANK DIA. (IN)	FLUTE LENGTH (IN)	OAL (IN)	90° POINT PART NUMBER	120° POINT PART NUMBER	135° POINT PART NUMBER	145° POINT PART NUMBER
1/4	0.2500	0.2500	3/4	2-1/2	605A-0250	605B-0250	605C-0250	*605D-0250
3/8	0.3750	0.3750	1-1/8	3-1/8	605A-0375	605B-0375	605C-0375	*605D-0375
1/2	0.5000	0.5000	1-3/8	3-3/4	605A-0500	605B-0500	605C-0500	*605D-0500
5/8	0.6250	0.6250	1-5/8	4-3/8	605A-0625	605B-0625	605C-0625	*605D-0625
3/4	0.7500	0.7500	1-7/8	5	605A-0750	605B-0750	605C-0750	*605D-0750
1	1.0000	1.0000	2-1/4	6	605A-1000	605B-1000	605C-1000	*605D-1000

*Expanded Offering

STUB LENGTH • HIGH SPEED • STRAIGHT SHANK

SERIES 803 • COOLANT-FED



SERIES: 803

SIZES

9/32" - 1"
INCH

General purpose drill works well in materials ranging from soft to medium hard materials. Suitable for both horizontal and vertical drilling. Notched point provides good chip formation when the proper speeds and feeds are applied. Flute web is constant with rolled heel providing maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix: 22°-24° Standard			
Point: 118° Notch			
Web: Standard			

DIAMETER INCH	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER	DIAMETER INCH	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
9/32	0.2812	2-1/2	4-1/2	803-011	21/32	0.6562	5	7	803-035
19/64	0.2969	2-1/2	4-1/2	803-012	43/64	0.6719	5	7	803-036
5/16	0.3125	2-1/2	4-1/2	803-013	11/16	0.6875	5	7	803-037
21/64	0.3281	2-1/2	4-1/2	803-014	45/64	0.7031	5	7	803-038
11/32	0.3438	2-1/2	4-1/2	803-015	23/32	0.7188	5	7	803-039
23/64	0.3594	2-1/2	4-1/2	803-016	47/64	0.7344	5	7	803-040
3/8	0.3750	2-1/2	4-1/2	803-017	3/4	0.7500	5	7	803-041
25/64	0.3906	3	5	803-018	49/64	0.7656	5	7	803-042
13/32	0.4062	3	5	803-019	25/32	0.7812	5	7	803-043
27/64	0.4219	3	5	803-020	51/64	0.7969	5	7	803-044
7/16	0.4375	3	5	803-021	13/16	0.8125	5	7	803-045
29/64	0.4531	3-1/2	5-1/2	803-022	53/64	0.8281	5	7	803-046
15/32	0.4688	3-1/2	5-1/2	803-023	27/32	0.8438	5	7	803-047
31/64	0.4844	3-1/2	5-1/2	803-024	55/64	0.8594	5	7	803-048
1/2	0.5000	3-1/2	5-1/2	803-025	7/8	0.8750	5	7	803-049
33/64	0.5156	4	6	803-026	57/64	0.8906	5	7	803-050
17/32	0.5312	4	6	803-027	29/32	0.9062	5	7	803-051
35/64	0.5469	4	6	803-028	59/64	0.9219	5	7	803-052
9/16	0.5625	4	6	803-029	15/16	0.9375	5	7	803-053
37/64	0.5781	4-1/2	6-1/2	803-030	61/64	0.9531	5	7	803-054
19/32	0.5938	4-1/2	6-1/2	803-031	31/32	0.9688	5	7	803-055
39/64	0.6094	4-1/2	6-1/2	803-032	63/64	0.9844	5	7	803-056
5/8	0.6250	4-1/2	6-1/2	803-033	1	1.0000	5	7	803-057
41/64	0.6406	5	7	803-034					

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable



STUB LENGTH • PARABOLIC • HIGH SPEED • STRAIGHT SHANK

SERIES 303 • COOLANT-FED



EXPANDED



SERIES: 303

SIZES

1/18"-19/64"
INCH

Parabolic style drill performs exceptionally well in aluminum and in most other materials. The 32° helix has excellent shearing action. Higher helix also assists chip flow in the vertical position. Parabolic design gives maximum chip room and lift in deep hole drilling. Split point design is self centering and provides accurate hole locations. **For tough materials and machining applications Ultra-Bronze coating is now available.**

MATERIAL	BRIGHT	ULTRA-BRONZE	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix:	32° Parabolic		
Point:	118° Split		
Web:	Standard		

TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER	TOOL DIAMETER		SHANK DIA. (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
INCH	DECIMAL					INCH	DECIMAL				
1/8	0.1250	0.1250	1-1/2	3-1/2	303-001	7/32	0.2188	0.2187	1-3/4	3-3/4	303-007
9/64	0.1406	0.1406	1-1/2	3-1/2	303-002	15/64	0.2344	0.2344	1-3/4	3-3/4	303-008
5/32	0.1562	0.1562	1-1/2	3-1/2	303-003	1/4	0.2500	0.2500	1-3/4	3-3/4	303-009
11/64	0.1719	0.1719	1-3/4	3-3/4	303-004	17/64	0.2656	0.2656	2	4	303-010
3/16	0.1875	0.1875	1-3/4	3-3/4	303-005	9/32	0.2812	0.2812	2	4	303-011
13/64	0.2031	0.2031	1-3/4	3-3/4	303-006	19/64	0.2969	0.2969	2	4	303-012

• For coolant entry specifications, see page 18.

STUB LENGTH • METRIC • PARABOLIC • COBALT • TIN COATED • CNC SHANK

SERIES M604 • COOLANT-FED



SERIES: M604

SIZES

5.0 - 14.0
MM

Cobalt parabolic style drill with versatile CNC shank works well in most materials and is an outstanding performer in harder materials. Excellent substitute when machines do not have the proper speed and feed for carbide. Parabolic design provides maximum chip room. The stubby length of these drills makes them sturdy. Furnished titanium nitride coated.

MATERIAL	BRIGHT	DARK	TIN
HSCO			●
SPECIFICATIONS			
Helix:	32° Parabolic		
Point:	135° Notch		
Web:	Standard		

TOOL DIAMETER		SHANK DIA. (MM)	FLUTE LENGTH (MM)	OAL (MM)	PART NUMBER
MM	DECIMAL				
5.0	0.1968	6	44	82	M604-0050
5.5	0.2165	6	44	82	M604-0055
6.0	0.2362	6	44	82	M604-0060
6.5	0.2559	8	53	91	M604-0065
6.8	0.2677	8	53	91	M604-0068
7.0	0.2756	8	53	91	M604-0070
7.5	0.2953	8	53	91	M604-0075
7.8	0.3071	8	53	91	M604-0078
8.0	0.3150	8	53	91	M604-0080
8.5	0.3346	10	61	103	M604-0085
9.0	0.3543	10	61	103	M604-0090
9.5	0.3740	10	61	103	M604-0095
10.0	0.3937	10	61	103	M604-0100
10.2	0.4016	12	71	118	M604-0102
10.5	0.4134	12	71	118	M604-0105
11.0	0.4331	12	71	118	M604-0110
11.5	0.4528	12	71	118	M604-0115
12.0	0.4724	12	71	118	M604-0120
12.5	0.4921	14	77	124	M604-0125
13.0	0.5118	14	77	124	M604-0130
13.5	0.5315	14	77	124	M604-0135
14.0	0.5512	14	77	124	M604-0140

• Specify finish when ordering where applicable



TAPER LENGTH • HIGH SPEED • STRAIGHT SHANK

SERIES 804 • COOLANT-FED



SERIES: 804

SIZES

1/8" - 1-1/2"
INCH

General purpose drill works well in materials ranging from soft to medium hard. Suitable for both horizontal and vertical drilling. Notched point provides good chip formation when the proper speeds and feeds are applied. The 22° - 24° helix has constant web thickness with rolled heel providing maximum chip clearance.

MATERIAL	BRIGHT	DARK	TN
HSCO	●	●	●
SPECIFICATIONS			
Helix: 22°-24° Standard			
Point: 118° Notch			
Web: Standard			

DIAMETER INCH	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER	DIAMETER INCH	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
1/8	0.1250	2-3/8	4-3/4	804-001	43/64	0.6719	6	9-1/4	804-036
9/64	0.1406	2-5/8	5	804-002	11/16	0.6875	6	9-1/4	804-037
5/32	0.1562	2-5/8	5	804-003	45/64	0.7031	6-3/16	9-1/2	804-038
11/64	0.1719	2-7/8	5-1/4	804-004	23/32	0.7188	6-3/16	9-1/2	804-039
3/16	0.1875	2-7/8	5-1/4	804-005	47/64	0.7344	6-3/8	9-3/4	804-040
13/64	0.2031	3-1/8	5-1/2	804-006	3/4	0.7500	6-3/8	9-3/4	804-041
7/32	0.2188	3-1/8	5-1/2	804-007	49/64	0.7656	6-1/2	9-7/8	804-042
15/64	0.2344	3-3/8	5-3/4	804-008	25/32	0.7812	6-1/2	9-7/8	804-043
1/4	0.2500	3-3/8	5-3/4	804-009	51/64	0.7969	6-5/8	10	804-044
17/64	0.2656	3-5/8	6	804-010	13/16	0.8125	6-5/8	10	804-045
9/32	0.2812	3-5/8	6	804-011	53/64	0.8281	6-3/4	10-1/4	804-046
19/64	0.2969	3-7/8	6-1/4	804-012	27/32	0.8438	6-3/4	10-1/4	804-047
5/16	0.3125	3-7/8	6-1/4	804-013	55/64	0.8594	7	10-1/2	804-048
21/64	0.3281	4-1/8	6-1/2	804-014	7/8	0.8750	7	10-1/2	804-049
11/32	0.3438	4-1/8	6-1/2	804-015	57/64	0.8906	7	10-5/8	804-050
23/64	0.3594	4-1/4	6-3/4	804-016	29/32	0.9062	7	10-5/8	804-051
3/8	0.3750	4-1/4	6-3/4	804-017	59/64	0.9219	7	10-3/4	804-052
25/64	0.3906	4-3/8	7	804-018	15/16	0.9375	7	10-3/4	804-053
13/32	0.4062	4-3/8	7	804-019	61/64	0.9531	7-1/8	10-7/8	804-054
27/64	0.4219	4-5/8	7-1/4	804-020	31/32	0.9688	7-1/8	10-7/8	804-055
7/16	0.4375	4-5/8	7-1/4	804-021	63/64	0.9844	7-3/16	11	804-056
29/64	0.4531	4-7/8	7-1/2	804-022	1	1.0000	7-3/16	11	804-057
15/32	0.4688	4-7/8	7-1/2	804-023	1-1/32	1.0313	7-5/16	11-1/8	804-058
31/64	0.4844	5	7-3/4	804-024	1-1/16	1.0625	7-3/8	11-1/4	804-059
1/2	0.5000	5	7-3/4	804-025	1-3/32	1.0938	7-5/8	11-1/2	804-060
33/64	0.5156	5-1/4	8	804-026	1-1/8	1.1250	7-7/8	11-3/4	804-061
17/32	0.5313	5-1/4	8	804-027	1-5/32	1.1563	8	11-7/8	804-062
35/64	0.5469	5-3/8	8-1/4	804-028	1-3/16	1.1875	8-1/8	12	804-063
9/16	0.5625	5-3/8	8-1/4	804-029	1-7/32	1.2188	8-1/8	12-1/8	804-064
37/64	0.5781	5-5/8	8-1/2	804-030	1-1/4	1.2500	8-1/2	12-1/2	804-065
19/32	0.5938	5-5/8	8-1/2	804-031	1-5/16	1.3125	9-1/4	14-1/4	804-066
39/64	0.6094	5-3/4	8-3/4	804-032	1-3/8	1.3750	9-1/2	14-1/2	804-067
5/8	0.6250	5-3/4	8-3/4	804-033	1-7/16	1.4375	9-5/8	14-3/4	804-068
41/64	0.6406	5-7/8	9	804-034	1-1/2	1.5000	9-7/8	15	804-069
21/32	0.6563	5-7/8	9	804-035					

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable



TAPER LENGTH • SLOW SPIRAL • HIGH SPEED • STRAIGHT SHANK

SERIES 805 • COOLANT-FED



MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix:	14° Slow		
Point:	118° Notch		
Web:	Standard		

SERIES: 805

SIZES

5/16" - 1-1/2"
INCH

General purpose slow spiral drill works best in horizontal applications on materials ranging from soft to hard. 14° slow spiral produces uninterrupted chip flow and increases edge strength. Notch point provides good chip formation when the proper speeds and feeds are applied.

DIAMETER INCH	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER	DIAMETER INCH	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
5/16	0.3125	3-7/8	6-1/4	805-013	49/64	0.7656	6-1/2	9-7/8	805-042
21/64	0.3281	4-1/8	6-1/2	805-014	25/32	0.7812	6-1/2	9-7/8	805-043
11/32	0.3438	4-1/8	6-1/2	805-015	51/64	0.7969	6-5/8	10	805-044
23/64	0.3594	4-1/4	6-3/4	805-016	13/16	0.8125	6-5/8	10	805-045
3/8	0.3750	4-1/4	6-3/4	805-017	53/64	0.8281	6-3/4	10-1/4	805-046
25/64	0.3906	4-3/8	7	805-018	27/32	0.8438	6-3/4	10-1/4	805-047
13/32	0.4062	4-3/8	7	805-019	55/64	0.8594	7	10-1/2	805-048
27/64	0.4219	4-5/8	7-1/4	805-020	7/8	0.8750	7	10-1/2	805-049
7/16	0.4375	4-5/8	7-1/4	805-021	57/64	0.8906	7	10-5/8	805-050
29/64	0.4531	4-7/8	7-1/2	805-022	29/32	0.9062	7	10-5/8	805-051
15/32	0.4688	4-7/8	7-1/2	805-023	59/64	0.9219	7	10-3/4	805-052
31/64	0.4844	5	7-3/4	805-024	15/16	0.9375	7	10-3/4	805-053
1/2	0.5000	5	7-3/4	805-025	61/64	0.9531	7-1/8	10-7/8	805-054
33/64	0.5156	5-1/4	8	805-026	31/32	0.9688	7-1/8	10-7/8	805-055
17/32	0.5312	5-1/4	8	805-027	63/64	0.9844	7-3/16	11	805-056
35/64	0.5469	5-3/8	8-1/4	805-028	1	1.0000	7-3/16	11	805-057
9/16	0.5625	5-3/8	8-1/4	805-029	1-1/32	1.0313	7-5/16	11-1/8	805-058
37/64	0.5781	5-5/8	8-1/2	805-030	1-1/16	1.0625	7-3/8	11-1/4	805-059
19/32	0.5938	5-5/8	8-1/2	805-031	1-3/32	1.0938	7-5/8	11-1/2	805-060
39/64	0.6094	5-3/4	8-3/4	805-032	1-1/8	1.1250	7-7/8	11-3/4	805-061
5/8	0.6250	5-3/4	8-3/4	805-033	1-5/32	1.1562	8	11-7/8	805-062
41/64	0.6406	5-7/8	9	805-034	1-3/16	1.1875	8-1/8	12	805-063
21/32	0.6562	5-7/8	9	805-035	1-7/32	1.2188	8-1/8	12-1/8	805-064
43/64	0.6719	6	9-1/4	805-036	1-1/4	1.2500	8-1/2	12-1/2	805-065
11/16	0.6875	6	9-1/4	805-037	1-5/16	1.3125	9-1/4	14-1/4	805-066
45/64	0.7031	6-3/16	9-1/2	805-038	1-3/8	1.3750	9-1/2	14-1/2	805-067
23/32	0.7188	6-3/16	9-1/2	805-039	1-7/16	1.4375	9-5/8	14-3/4	805-068
47/64	0.7344	6-3/8	9-3/4	805-040	1-1/2	1.5000	9-7/8	15	805-069
3/4	0.7500	6-3/8	9-3/4	805-041					

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable

TECHNICAL TIPS



We offer drill resharpening and reconditioning for all of our Drills. We also offer a variety of specialized drill points for specific applications. Please contact us for further information.



Visit our website at www.coolantfedtooling.com for technical information and our latest product offerings.



TAPER LENGTH • COBALT • STRAIGHT SHANK

SERIES 601 • COOLANT-FED



MATERIAL	BRIGHT	DARK	TIN
HSCO	●		
SPECIFICATIONS			
Helix: 22° -24° Standard			
Point: 135° Split			
Web: Heavy			

SERIES: 601

SIZES

3/8"-1"
INCH

Heavy duty cobalt drill designed for use in abrasive or hard materials where speed is not the primary consideration. Heavy web thickness makes this drill extremely sturdy in these tough materials. Does not work well in aluminum or soft steels. Split point design is self centering and provides accurate hole locations.

DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH.(IN.)	OAL (IN.)	OLD PART NUMBER	NEW PART NUMBER	DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	OLD PART NUMBER	NEW PART NUMBER
3/8	0.3750	4-1/4	6-3/4	C804-017	601-03750	45/64	0.7031	6-3/16	9-1/2	C804-038	601-07031
25/64	0.3906	4-3/8	7	C804-018	601-03906	23/32	0.7188	6-3/16	9-1/2	C804-039	601-07188
13/32	0.4062	4-3/8	7	C804-019	601-04062	47/64	0.7344	6-3/8	9-3/4	C804-040	601-07344
27/64	0.4219	4-5/8	7-1/4	C804-020	601-04219	3/4	0.7500	6-3/8	9-3/4	C804-041	601-07500
7/16	0.4375	4-5/8	7-1/4	C804-021	601-04375	49/64	0.7656	6-1/2	9-7/8	C804-042	601-07656
29/64	0.4531	4-7/8	7-1/2	C804-022	601-04531	25/32	0.7812	6-1/2	9-7/8	C804-043	601-07821
15/32	0.4688	4-7/8	7-1/2	C804-023	601-04688	51/64	0.7968	6-5/8	10	C804-044	601-07968
31/64	0.4844	5	7-3/4	C804-024	601-04844	13/16	0.8125	6-5/8	10	C804-045	601-08125
1/2	0.5000	5	7-3/4	C804-025	601-05000	53/64	0.8281	6-3/4	10-1/4	C804-046	601-08281
33/64	0.5156	5-1/4	8	C804-026	601-05156	27/32	0.8438	6-3/4	10-1/4	C804-047	601-08438
17/32	0.5312	5-1/4	8	C804-027	601-05312	55/64	0.8593	7	10-1/2	C804-048	601-08593
35/64	0.5469	5-3/8	8-1/4	C804-028	601-05469	7/8	0.8750	7	10-1/2	C804-049	601-08750
9/16	0.5625	5-3/8	8-1/4	C804-029	601-05625	57/64	0.8906	7	10-5/8	C804-050	601-08906
37/64	0.5781	5-5/8	8-1/2	C804-030	601-05781	29/32	0.9062	7	10-5/8	C804-051	601-09062
19/32	0.5938	5-5/8	8-1/2	C804-031	601-05938	59/64	0.9218	7	10-3/4	C804-052	601-09218
39/64	0.6094	5-3/4	8-3/4	C804-032	601-06094	15/16	0.9375	7	10-3/4	C804-053	601-09375
5/8	0.6250	5-3/4	8-3/4	C804-033	601-06250	61/64	0.9531	7-1/8	10-7/8	C804-054	601-09531
41/64	0.6406	5-7/8	9	C804-034	601-06406	31/32	0.9687	7-1/8	10-7/8	C804-055	601-09687
21/32	0.6562	5-7/8	9	C804-035	601-06562	63/64	0.9843	7-3/16	11	C804-056	601-09843
43/64	0.6719	6	9-1/4	C804-036	601-06719	1	1.0000	7-3/16	11	C804-057	601-10000
11/16	0.6875	6	9-1/4	C804-037	601-06875						

- For coolant entry specifications, see page below.
- Specify finish when ordering where applicable

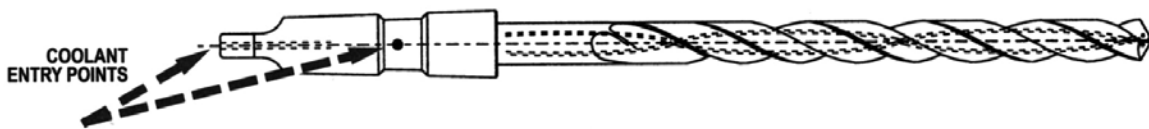
COOLANT ENTRY SPECIFICATIONS

STRAIGHT SHANK



Sizes **under 1/2"** have Cupped End Coolant Entry
 Sizes **1/2" through 3/4"** have 1/8 NPT Tapped Coolant Entry
 Sizes **49/64" through 1-1/4"** have 1/4 NPT Tapped Coolant Entry
 Sizes **1-9/32" through 1-3/8"** have 3/8 NPT Tapped Coolant Entry

TAPER SHANK



The George Whalley Company standard length taper shank coolant-fed twist drills are normally furnished with side and tang end coolant entry. However, if end entry is an absolute requirement, please specify when ordering.



LONG LENGTH • SMALL DIAMETER • HIGH SPEED • STRAIGHT SHANK

SERIES 806 • COOLANT-FED



SERIES: 806

SIZES

1/8" - 1/2"
INCH

General purpose drill works well in materials ranging from soft to medium hard materials. Suitable for both horizontal and vertical drilling. Notched point provides good chip formation when the proper speeds and feeds are applied. The 22° - 24° helix has constant web thickness with rolled heel providing maximum chip clearance.

MATERIAL	BRIGHT	DARK	TN
HSS	●	●	●
SPECIFICATIONS			
Helix: 22°-24° Standard			
Point: 118° Notch			
Web: Standard			

DIAMETER INCH	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
1/8	0.1250	3-5/8	6	806-001
9/64	0.1406	4	6-3/8	806-002
5/32	0.1562	4	6-3/8	806-003
11/64	0.1719	4-3/8	6-3/4	806-004
3/16	0.1875	4-3/8	6-3/4	806-005
13/64	0.2031	4-3/4	7-1/8	806-006
7/32	0.2188	4-3/4	7-1/8	806-007
15/64	0.2344	5-1/8	7-1/2	806-008
1/4	0.2500	5-1/8	7-1/2	806-009
17/64	0.2656	5-1/2	7-7/8	806-010
9/32	0.2812	5-1/2	7-7/8	806-011
19/64	0.2969	5-7/8	8-1/4	806-012
5/16	0.3125	5-7/8	8-1/4	806-013

DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
21/64	0.3281	6-1/4	8-5/8	806-014
11/32	0.3438	6-1/4	8-5/8	806-015
23/64	0.3594	6-3/8	8-7/8	806-016
3/8	0.3750	6-3/8	8-7/8	806-017
25/64	0.3906	6-5/8	9-1/4	806-018
13/32	0.4062	6-5/8	9-1/4	806-019
27/64	0.4219	7	9-5/8	806-020
7/16	0.4375	7	9-5/8	806-021
29/64	0.4531	7-3/8	10	806-022
15/32	0.4688	7-3/8	10	806-023
31/64	0.4844	7-1/2	10-1/4	806-024
1/2	0.5000	7-1/2	10-1/4	806-025

• For coolant entry specifications, see page 18.

TAPER LENGTH • METRIC • HIGH SPEED • STRAIGHT SHANK

SERIES M804 • COOLANT-FED



SERIES: M804

SIZES

3.0 - 13.0
MM

General purpose metric drill for use in soft to medium hard materials. Suitable for both horizontal and vertical applications. Higher helix assists chip flow in the vertical position. Notch point provides good chip formation when the proper speeds and feeds are applied

MATERIAL	BRIGHT	DARK	TN
HSS	●		●
SPECIFICATIONS			
Helix: 34° Fast			
Point: 118° Notch			
Web: Standard			

DIAMETER (MM)	DECIMAL (IN.)	FLUTE LENGTH (MM)	OAL (MM)	PART NUMBER
3.0	0.1181	66	100	M804-0030
3.3	0.1299	69	106	M804-0033
3.5	0.1378	73	112	M804-0035
4.0	0.1575	78	119	M804-0040
4.2	0.1654	78	119	M804-0042
4.5	0.1772	82	126	M804-0045
5.0	0.1968	87	132	M804-0050
5.5	0.2165	91	139	M804-0055
6.0	0.2362	91	139	M804-0060
6.5	0.2559	97	148	M804-0065
6.8	0.2677	102	156	M804-0068
7.0	0.2756	102	156	M804-0070

DIAMETER (MM)	DECIMAL (IN.)	FLUTE LENGTH (MM)	OAL (MM)	PART NUMBER
7.5	0.2953	102	156	M804-0075
8.0	0.3150	109	165	M804-0080
8.5	0.3346	109	165	M804-0085
9.0	0.3543	115	175	M804-0090
9.5	0.3740	115	175	M804-0095
10.0	0.3937	121	184	M804-0100
10.2	0.4016	121	184	M804-0102
10.5	0.4134	121	184	M804-0105
11.0	0.4331	128	195	M804-0110
11.5	0.4528	128	195	M804-0115
12.0	0.4724	134	205	M804-0120
13.0	0.5118	134	205	M804-0130

- Meets DIN 34 Specifications
- Specify finish when ordering where applicable



LONG LENGTH • SMALL DIAMETER • COBALT • STRAIGHT SHANK

SERIES 602 • COOLANT-FED



SERIES: 602

SIZES

1/8"-1/2"
INCH

Heavy duty cobalt drill designed for use in abrasive or hard materials where speed is not the primary consideration. Heavy web thickness makes this drill extremely sturdy in these tough materials. Does not work well in aluminum or soft steels. Split point design is self centering and provides accurate hole locations.

MATERIAL	BRIGHT	DARK	TIN
HSCO	●		●

SPECIFICATIONS

Helix: 22° -24° Standard
Point: 135° Split
Web: Heavy

DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	OLD PART NUMBER	PART NUMBER	DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	OLD PART NUMBER	PART NUMBER
1/8	0.1250	3-5/8	6	C806-001	602-01250	21/64	0.3281	6-1/4	8-5/8	C806-014	602-03281
9/64	0.1406	4	6-3/8	C806-002	602-01406	11/32	0.3438	6-1/4	8-5/8	C806-015	602-03438
5/32	0.1562	4	6-3/8	C806-003	602-01562	23/64	0.3594	6-3/8	8-7/8	C806-016	602-03594
11/64	0.1719	4-3/8	6-3/4	C806-004	602-01719	3/8	0.3750	6-3/8	8-7/8	C806-017	602-03750
3/16	0.1875	4-3/8	6-3/4	C806-005	602-01875	25/64	0.3906	6-5/8	9-1/4	C806-018	602-03906
13/64	0.2031	4-3/4	7-1/8	C806-006	602-02031	13/32	0.4062	6-5/8	9-1/4	C806-019	602-04062
7/32	0.2188	4-3/4	7-1/8	C806-007	602-02188	27/64	0.4219	7	9-5/8	C806-020	602-04219
15/64	0.2344	5-1/8	7-1/2	C806-008	602-02344	7/16	0.4375	7	9-5/8	C806-021	602-04375
1/4	0.2500	5-1/8	7-1/2	C806-009	602-02500	29/64	0.4531	7-3/8	10	C806-022	602-04531
17/64	0.2656	5-1/2	7-7/8	C806-010	602-02656	15/32	0.4688	7-3/8	10	C806-023	602-04688
9/32	0.2812	5-1/2	7-7/8	C806-011	602-02812	31/64	0.4844	7-1/2	10-1/4	C806-024	602-04844
19/64	0.2969	5-7/8	8-1/4	C806-012	602-02969	1/2	0.5000	7-1/2	10-1/4	C806-025	602-05000
5/16	0.3125	5-7/8	8-1/4	C806-013	602-03125						

• For coolant entry specifications, see page 18.

EXTRA LENGTH • 7" FLUTE • PARABOLIC • HIGH SPEED • STRAIGHT SHANK

SERIES 307 • COOLANT-FED



SERIES: 307

SIZES

1/8" - 3/4"
INCH

Parabolic style drill performs exceptionally well in aluminum and in most other materials. The 32° helix has excellent shearing action. Higher helix also assists chip flow in the vertical position. Parabolic design gives maximum chip room and lift in deep hole drilling. Split point design is self centering and provides accurate hole locations. For tough machining applications Ultra-Bronze coating is available.

MATERIAL	BRIGHT	ULTRA-BRONZE	TIN
HSS	●	●	●

SPECIFICATIONS

Helix: 32° Parabolic
Point: 118° Split
Web: Standard

TOOL DIAMETER INCH	DECIMAL	SHANK DIA.	FLUTE LENGTH	OAL	PART NUMBER	TOOL DIAMETER INCH	DECIMAL	SHANK DIA.	FLUTE LENGTH	OAL	PART NUMBER
*1/8	0.1250	0.1250	7	10	307-001	7/16	0.4375	0.4375	7	10	307-021
*9/64	0.1406	0.1406	7	10	307-002	29/64	0.4531	0.4531	7	10	307-022
*5/32	0.1563	0.1563	7	10	307-003	15/32	0.4688	0.4688	7	10	307-023
*11/64	0.1719	0.1719	7	10	307-004	31/64	0.4844	0.4688	7	10	307-024
*3/16	0.1875	0.1875	7	10	307-005	1/2	0.5000	0.5000	7	10	307-025
*13/64	0.2031	0.2031	7	10	307-006	33/64	0.5156	0.5156	7	10	307-026
*7/32	0.2188	0.2188	7	10	307-007	17/32	0.5312	0.5312	7	10	307-027
*15/64	0.2344	0.2344	7	10	307-008	35/64	0.5469	0.5469	7	10	307-028
1/4	0.2500	0.2500	7	10	307-009	9/16	0.5625	0.5625	7	10	307-029
17/64	0.2656	0.2656	7	10	307-010	37/64	0.5781	0.5781	7	10	307-030
9/32	0.2812	0.2812	7	10	307-011	19/32	0.5937	0.5937	7	10	307-031
19/64	0.2969	0.2969	7	10	307-012	39/64	0.6094	0.6094	7	10	307-032
5/16	0.3125	0.3125	7	10	307-013	5/8	0.6250	0.6250	7	10	307-033
21/64	0.3281	0.3281	7	10	307-014	41/64	0.6406	0.6406	7	10	307-034
11/32	0.3437	0.3437	7	10	307-015	21/32	0.6562	0.6562	7	10	307-035
23/64	0.3594	0.3594	7	10	307-016	43/64	0.6719	0.6719	7	10	307-036
3/8	0.3750	0.3750	7	10	307-017	11/16	0.6875	0.6875	7	10	307-037
25/64	0.3906	0.3906	7	10	307-018	45/64	0.7031	0.7031	7	10	307-038
13/32	0.4062	0.4062	7-3/4	10-3/4	307-019S	23/32	0.7188	0.7188	7	10	307-039
27/64	0.4219	0.4219	7	10	307-020	47/64	0.7344	0.7344	7	10	307-040
						3/4	0.7500	0.7500	7	10	307-041

*Expanded Offering

• Specify finish when ordering where applicable



For hole concentricity we recommend using **Series 605 Spotting Drill**, see page 14.



EXTRA LENGTH • 9" FLUTE • HIGH SPEED • STRAIGHT SHANK

SERIES 808 • COOLANT-FED



MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix: 22° -24° Standard			
Point: 118° Notch			
Web: Standard			

SERIES: 808

SIZES

3/16" - 1-1/16"
INCH

General purpose drill works well in materials ranging from soft to medium hard. Suitable for both horizontal and vertical drilling. Notched point provides good chip formation when the proper speeds and feeds are applied. The 22° to 24° helix has constant web thickness with rolled heel providing maximum chip clearance.

DIAMETER INCH	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER	DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
3/16	0.1875	9	12	808-006	5/8	0.6250	9	12	808-034
13/64	0.2031	9	12	808-007	41/64	0.6406	9	12	808-035
7/32	0.2188	9	12	808-008	21/32	0.6562	9	12	808-036
15/64	0.2344	9	12	808-009	43/64	0.6719	9	12	808-037
1/4	0.2500	9	12	808-010	11/16	0.6875	9	12	808-038
17/64	0.2656	9	12	808-011	45/64	0.7031	9	12	808-039
9/32	0.2812	9	12	808-012	23/32	0.7188	9	12	808-040
19/64	0.2969	9	12	808-013	47/64	0.7344	9	12	808-041
5/16	0.3125	9	12	808-014	3/4	0.7500	9	12	808-042
21/64	0.3281	9	12	808-015	49/64	0.7656	9	12	808-043
11/32	0.3438	9	12	808-016	25/32	0.7812	9	12	808-044
23/64	0.3594	9	12	808-017	51/64	0.7969	9	12	808-045
3/8	0.3750	9	12	808-018	13/16	0.8125	9	12	808-046
25/64	0.3906	9	12	808-019	53/64	0.8281	9	12	808-047
13/32	0.4062	9	12	808-020	27/32	0.8438	9	12	808-048
27/64	0.4219	9	12	808-021	55/64	0.8594	9	12	808-049
7/16	0.4375	9	12	808-022	7/8	0.8750	9	12	808-050
29/64	0.4531	9	12	808-023	57/64	0.8906	9	12	808-051
15/32	0.4688	9	12	808-024	29/32	0.9062	9	12	808-052
31/64	0.4844	9	12	808-025	59/64	0.9219	9	12	808-053
1/2	0.5000	9	12	808-026	15/16	0.9375	9	12	808-054
33/64	0.5156	9	12	808-027	61/64	0.9531	9	12	808-055
17/32	0.5312	9	12	808-028	31/32	0.9688	9	12	808-056
35/64	0.5469	9	12	808-029	63/64	0.9844	9	12	808-057
9/16	0.5625	9	12	808-030	1	1.0000	9	12	808-059
37/64	0.5781	9	12	808-031	1-1/32	1.0313	9	12	808-060
19/32	0.5938	9	12	808-032	1-1/16	1.0625	9	12	808-061
39/64	0.6094	9	12	808-033					

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable



For hole concentricity we recommend using **Series 605 Spotting Drill**, see page 14.

TECHNICAL TIPS



We offer drill resharpening and reconditioning for all of our Drills. We also offer a variety of specialized drill points for specific applications. Please contact us for further information.





Visit our website at www.coolantfedtooling.com for technical information and our latest product offerings.



EXTRA LENGTH • 9" FLUTE • COBALT • STRAIGHT SHANK

SERIES 603 • COOLANT-FED

MATERIAL	BRIGHT	DARK	TIN
HSCO	●		●
SPECIFICATIONS			
Helix: 22° -24° Standard			
Point: 135° Split			
Web: Heavy			

SERIES: 603

SIZES

5/16" - 1-1/16" INCH

Heavy duty cobalt drill designed for use in abrasive or hard materials where speed is not the primary consideration. Heavy web thickness makes this drill extremely sturdy in these tough materials. Does not work well in aluminum or soft steels. Split point design is self centering and provides accurate hole locations.

DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	OLD PART NO.	PART NUMBER	DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	OLD PART NO.	PART NUMBER
5/16	0.3125	9	12	C808-014	603-03125	11/16	0.6875	9	12	C808-038	603-06875
21/64	0.3281	9	12	C808-015	603-03281	45/64	0.7031	9	12	C808-039	603-07031
11/32	0.3437	9	12	C808-016	603-03437	23/32	0.7188	9	12	C808-040	603-07188
23/64	0.3593	9	12	C808-017	603-03593	47/64	0.7344	9	12	C808-041	603-07344
3/8	0.3750	9	12	C808-018	603-03750	3/4	0.7500	9	12	C808-042	603-07500
25/64	0.3906	9	12	C808-019	603-03906	49/64	0.7656	9	12	C808-043	603-07656
13/32	0.4062	9	12	C808-020	603-04062	25/32	0.7812	9	12	C808-044	603-07812
27/64	0.4219	9	12	C808-021	603-04219	51/64	0.7968	9	12	C808-045	603-07968
7/16	0.4375	9	12	C808-022	603-04375	13/16	0.8125	9	12	C808-046	603-08125
29/64	0.4531	9	12	C808-023	603-04531	53/64	0.8281	9	12	C808-047	603-08281
15/32	0.4688	9	12	C808-024	603-04688	27/32	0.8437	9	12	C808-048	603-08437
31/64	0.4844	9	12	C808-025	603-04844	55/64	0.8593	9	12	C808-049	603-08593
1/2	0.5000	9	12	C808-026	603-05000	7/8	0.8750	9	12	C808-050	603-08750
33/64	0.5156	9	12	C808-027	603-05156	57/64	0.8906	9	12	C808-051	603-08906
17/32	0.5312	9	12	C808-028	603-05312	29/32	0.9062	9	12	C808-052	603-09062
35/64	0.5469	9	12	C808-029	603-05469	59/64	0.9218	9	12	C808-053	603-09218
9/16	0.5625	9	12	C808-030	603-05625	15/16	0.9375	9	12	C808-054	603-09375
37/64	0.5781	9	12	C808-031	603-05781	61/64	0.9531	9	12	C808-055	603-09531
19/32	0.5938	9	12	C808-032	603-05938	31/32	0.9687	9	12	C808-056	603-09687
39/64	0.6094	9	12	C808-033	603-06094	63/64	0.9843	9	12	C808-057	603-09843
5/8	0.6250	9	12	C808-034	603-06250	1	1.0000	9	12	C808-059	603-10000
41/64	0.6406	9	12	C808-035	603-06406	1-1/32	1.0312	9	12	C808-060	603-10312
21/32	0.6562	9	12	C808-036	603-06562	1-1/16	1.0625	9	12	C808-061	603-10625
43/64	0.6719	9	12	C808-037	603-06719						

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable



For hole concentricity we recommend using **Series 605 Spotting Drill**, see page 14.



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EXTRA LENGTH • 10" FLUTE • HIGH SPEED • STRAIGHT SHANK

SERIES 710 • COOLANT-FED



SERIES: 710
SIZES
5/16" - 1-3/8"
INCH

General purpose drill works well in materials ranging from soft to medium hard. Suitable for both horizontal and vertical drilling. Notched point provides good chip formation when the proper speeds and feeds are applied. The 22° to 24° helix has constant web thickness with rolled heel providing maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix: 22° -24° Standard			
Point: 118° Notch			
Web: Standard			

DIAMETER INCH	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER	DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
5/16	0.3125	10	13-1/2	710-014A	49/64	0.7656	10	13-1/2	710-043A
21/64	0.3281	10	13-1/2	710-015A	25/32	0.7812	10	13-1/2	710-044A
11/32	0.3438	10	13-1/2	710-016A	51/64	0.7969	10	13-1/2	710-045A
23/64	0.3594	10	13-1/2	710-017A	13/16	0.8125	10	13-1/2	710-046A
3/8	0.3750	10	13-1/2	710-018A	53/64	0.8281	10	13-1/2	710-047A
25/64	0.3906	10	13-1/2	710-019A	27/32	0.8438	10	13-1/2	710-048A
13/32	0.4062	10	13-1/2	710-020A	55/64	0.8594	10	13-1/2	710-049A
27/64	0.4219	10	13-1/2	710-021A	7/8	0.8750	10	13-1/2	710-050A
7/16	0.4375	10	13-1/2	710-022A	57/64	0.8906	10	13-1/2	710-051A
29/64	0.4531	10	13-1/2	710-023A	29/32	0.9062	10	13-1/2	710-052A
15/32	0.4688	10	13-1/2	710-024A	59/64	0.9219	10	13-1/2	710-053A
31/64	0.4844	10	13-1/2	710-025A	15/16	0.9375	10	13-1/2	710-054A
1/2	0.5000	10	13-1/2	710-026A	61/64	0.9531	10	13-1/2	710-055A
33/64	0.5156	10	13-1/2	710-027A	31/32	0.9688	10	13-1/2	710-056A
17/32	0.5312	10	13-1/2	710-028A	63/64	0.9844	10	13-1/2	710-057A
35/64	0.5469	10	13-1/2	710-029A	1	1.0000	10	13-1/2	710-059A
9/16	0.5625	10	13-1/2	710-030A	1-1/32	1.0313	10	13-1/2	710-060A
37/64	0.5781	10	13-1/2	710-031A	1-1/16	1.0625	10	13-1/2	710-061A
19/32	0.5938	10	13-1/2	710-032A	1-3/32	1.0938	10	15	710-062A
39/64	0.6094	10	13-1/2	710-033A	1-1/8	1.1250	10	15	710-063A
5/8	0.6250	10	13-1/2	710-034A	1-5/32	1.1562	10	15	710-064A
41/64	0.6406	10	13-1/2	710-035A	1-3/16	1.1875	10	15	710-065A
21/32	0.6562	10	13-1/2	710-036A	1-7/32	1.2188	10	15	710-066A
43/64	0.6719	10	13-1/2	710-037A	1-1/4	1.2500	10	15	710-067A
11/16	0.6875	10	13-1/2	710-038A	1-9/32	1.2812	10	15	710-068A
45/64	0.7031	10	13-1/2	710-039A	1-5/16	1.3125	10	15	710-069A
23/32	0.7188	10	13-1/2	710-040A	1-11/32	1.3438	10	15	710-070A
47/64	0.7344	10	13-1/2	710-041A	1-3/8	1.3750	10	15	710-071A
3/4	0.7500	10	13-1/2	710-042A					

• For coolant entry specifications, see page 18.

Note: Drill bushing or starter hole recommended when drilling under 3/8 diameter

- Specify finish when ordering where applicable
- Where coatings are not shown by each product, we offer the following coatings: TiN, TiAlN, TiCN, HARDLUBE, ULTRAGOLD and ULTRA-BRONZE.



For hole concentricity we recommend using **Series 605 Spotting Drill**, see page 14.



EXTRA LENGTH • 12" FLUTE • HIGH SPEED • STRAIGHT SHANK

SERIES 712 • COOLANT-FED



SERIES: 712
SIZES
5/16" - 1-3/8"
INCH

General purpose drill works well in materials ranging from soft to medium hard. Suitable for both horizontal and vertical drilling. Notched point provides good chip formation when the proper speeds and feeds are applied. The 22° to 24° helix has constant web thickness with rolled heel providing maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix: 22° -24° Standard			
Point: 118° Notch			
Web: Standard			

DIAMETER INCH	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER	DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
5/16	0.3125	12	16	712-014	45/64	0.7031	12	16	712-039
21/64	0.3281	12	16	712-015	23/32	0.7188	12	16	712-040
11/32	0.3438	12	16	712-016	47/64	0.7344	12	16	712-041
23/64	0.3594	12	16	712-017	3/4	0.7500	12	16	712-042
3/8	0.3750	12	16	712-018	25/32	0.7812	12	16	712-044
25/64	0.3906	12	16	712-019	13/16	0.8125	12	16	712-046
13/32	0.4062	12	16	712-020	27/32	0.8438	12	16	712-048
27/64	0.4219	12	16	712-021	55/64	0.8594	12	16	712-049
7/16	0.4375	12	16	712-022	7/8	0.8750	12	16	712-050
29/64	0.4531	12	16	712-023	29/32	0.9062	12	16	712-052
15/32	0.4688	12	16	712-024	15/16	0.9375	12	16	712-054
31/64	0.4844	12	16	712-025	31/32	0.9688	12	16	712-056
1/2	0.5000	12	16	712-026	1	1.0000	12	16	712-059
33/64	0.5156	12	16	712-027	1-1/32	1.0313	12	16	712-060
17/32	0.5312	12	16	712-028	1-1/16	1.0625	12	16	712-061
35/64	0.5469	12	16	712-029	1-3/32	1.0938	12	18	712-062
9/16	0.5625	12	16	712-030	1-1/8	1.1250	12	18	712-063
37/64	0.5781	12	16	712-031	1-5/32	1.1562	12	18	712-064
19/32	0.5938	12	16	712-032	1-3/16	1.1875	12	18	712-065
39/64	0.6094	12	16	712-033	1-7/32	1.2188	12	18	712-066
5/8	0.6250	12	16	712-034	1-1/4	1.2500	12	18	712-067
41/64	0.6406	12	16	712-035	1-9/32	1.2812	12	18	712-068
21/32	0.6562	12	16	712-036	1-5/16	1.3125	12	18	712-069
43/64	0.6719	12	16	712-037	1-11/32	1.3438	12	18	712-070
11/16	0.6875	12	16	712-038	1-3/8	1.3750	12	18	712-071

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable

Note : Drill bushing or starter hole recommended when drilling under 3/8" diameter



For hole concentricity we recommend using **Series 605 Spotting Drill**, see page 14.

TECHNICAL TIPS



We offer drill sharpening and reconditioning for all of our Drills. We also offer a variety of specialized drill points for specific applications. Please contact us for further information.



Visit our website at www.coolantfedtooling.com for technical information and our latest product offerings.



EXTRA LENGTH • 18" FLUTE • HIGH SPEED • STRAIGHT SHANK

SERIES 718 • COOLANT-FED



SERIES: 718

SIZES

5/16"-1"
INCH

General purpose drill works well in materials ranging from soft to medium hard. Suitable for both horizontal and vertical drilling. Notched point provides good chip formation when the proper speeds and feeds are applied. The 22° to 24° helix has constant web thickness with rolled heel providing maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix: 22° - 24° Standard			
Point: 118° Notch			
Web: Standard			

DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER	DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
* 5/16	0.3125	18	21	718-014	39/64	0.6094	18	21	718-033
* 21/64	0.3281	18	21	718-015	5/8	0.6250	18	21	718-034
* 11/32	0.3438	18	21	718-016	41/64	0.6406	18	21	718-035
* 23/64	0.3594	18	21	718-017	21/32	0.6562	18	21	718-036
3/8	0.3750	18	21	718-018	43/64	0.6719	18	21	718-037
* 25/64	0.3906	18	21	718-019	11/16	0.6875	18	21	718-038
* 13/32	0.4062	18	21	718-020	45/64	0.7031	18	21	718-039
* 27/64	0.4219	18	21	718-021	23/32	0.7188	18	21	718-040
7/16	0.4375	18	21	718-022	47/64	0.7344	18	21	718-041
29/64	0.4531	18	21	718-023	3/4	0.7500	18	21	718-042
15/32	0.4688	18	21	718-024	25/32	0.7812	18	21	718-044
31/64	0.4844	18	21	718-025	13/16	0.8125	18	21	718-046
1/2	0.5000	18	21	718-026	27/32	0.8438	18	21	718-048
33/64	0.5156	18	21	718-027	7/8	0.8750	18	21	718-050
17/32	0.5312	18	21	718-028	29/32	0.9062	18	21	718-052
35/64	0.5469	18	21	718-029	15/16	0.9375	18	21	718-054
9/16	0.5625	18	21	718-030	31/32	0.9688	18	21	718-056
37/64	0.5781	18	21	718-031	1	1.0000	18	21	718-059
19/32	0.5938	18	21	718-032					

* **Outgoing Items**

• For coolant entry specifications, see page 18.

Note : Drill bushing or starter hole recommended when drilling under 3/8" diameter

EXTRA LENGTH • 21" FLUTE • HIGH SPEED • STRAIGHT SHANK

SERIES 721 • COOLANT-FED



SERIES: 721

SIZES

5/16"- 47/64"
INCH

General purpose drill works well in materials ranging from soft to medium hard. Suitable for both horizontal and vertical drilling. Notched point provides good chip formation when the proper speeds and feeds are applied. The 22° to 24° helix has constant web thickness with rolled heel providing maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix: 22° - 24° Standard			
Point: 118° Notch			
Web: Standard			

DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER	DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
* 5/16	0.3125	21	24	721-014	* 9/16	0.5625	21	24	721-030
* 21/64	0.3281	21	24	721-015	* 37/64	0.5781	21	24	721-031
* 11/32	0.3438	21	24	721-016	* 19/32	0.5938	21	24	721-032
* 23/64	0.3594	21	24	721-017	* 39/64	0.6094	21	24	721-033
* 3/8	0.3750	21	24	721-018	* 5/8	0.6250	21	24	721-034
* 25/64	0.3906	21	24	721-019	* 41/64	0.6406	21	24	721-035
* 13/32	0.4062	21	24	721-020	* 21/32	0.6562	21	24	721-036
* 27/64	0.4219	21	24	721-021	* 43/64	0.6719	21	24	721-037
* 7/16	0.4375	21	24	721-022	* 11/16	0.6875	21	24	721-038
* 29/64	0.4531	21	24	721-023	* 45/64	0.7031	21	24	721-039
* 15/32	0.4688	21	24	721-024	* 23/32	0.7188	21	24	721-040
* 31/64	0.4844	21	24	721-025	* 47/64	0.7344	21	24	721-041

* **Outgoing Items**

• For coolant entry specifications, see page 18.

• Specify finish when ordering where applicable

Note : Drill bushing or starter hole recommended when drilling under 3/8" diameter

* **Outgoing Items**



For hole concentricity we recommend using **Series 605 Spotting Drill**, see page 14.



STUB LENGTH • CARBIDE TIPPED • PARABOLIC • STRAIGHT SHANK

SERIES 903 • COOLANT-FED



SERIES: 903
SIZES
5/16"-1" INCH

Parabolic style carbide tipped drill that works well in non-ferrous materials and some steel and stainless steel applications. Helical point gives it a self centering start. Carbide is C2 micrograin for top performance. Constant web with rolled heel provides maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
C2 MICROGRAIN	●		●
SPECIFICATIONS			
Helix: 22° -24° Parabolic			
Point: 135° Helical			
Web: Standard			

DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
5/16	0.3125	2-1/2	4-1/2	903-013
21/64	0.3281	2-1/2	4-1/2	903-014
11/32	0.3438	2-1/2	4-1/2	903-015
23/64	0.3594	2-1/2	4-1/2	903-016
3/8	0.3750	2-1/2	4-1/2	903-017
25/64	0.3906	3	5	903-018
13/32	0.4062	3	5	903-019
27/64	0.4219	3	5	903-020
7/16	0.4375	3	5	903-021
29/64	0.4531	3-1/2	5-1/2	903-022
15/32	0.4688	3-1/2	5-1/2	903-023
31/64	0.4844	3-1/2	5-1/2	903-024
1/2	0.5000	3-1/2	5-1/2	903-025
33/64	0.5156	4	6	903-026

DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
17/32	0.5312	4	6	903-027
35/64	0.5469	4	6	903-028
9/16	0.5625	4	6	903-029
37/64	0.5781	4-1/2	6-1/2	903-030
19/32	0.5938	4-1/2	6-1/2	903-031
39/64	0.6094	4-1/2	6-1/2	903-032
5/8	0.6250	4-1/2	6-1/2	903-033
* 41/64	0.6406	5	7	903-034
* 21/32	0.6562	5	7	903-035
* 47/64	0.7344	5	7	903-040
* 3/4	0.7500	5	7	903-041
* 13/16	0.8125	5	7	903-045
* 15/16	0.9375	5	7	903-053
* 1	1.0000	5	7	903-057

*** Outgoing Items**

• For coolant entry specifications, see page 18.

STUB • TAPER LENGTH • EXTRA LENGTH • METRIC • CARBIDE TIP • STRAIGHT SHANK

SERIES: M903
SERIES: M905
SERIES: M908
SIZES
9.5 - 24.5 MM



Carbide tipped drill designed for non-ferrous materials such as aluminum and cast iron. Can be used in other materials such as steel but in steel applications performance may not be consistent. Double angle point increases the margin life. Carbide is C2 micrograin for top performance. Constant web with rolled heel provides maximum chip clearance. For coolant entry specifications, see page 18.

MATERIAL	BRIGHT	DARK	TIN
C2 MICROGRAIN	●		●
SPECIFICATIONS			
Helix: 22° -24° Standard			
Point: 118°/90° Double Angle			
Web: Standard			

SERIES M905 • TAPER LENGTH • METRIC

DIAMETER (MM)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
10.2	0.4016	4-3/8	7	M905-115
10.5	0.4134	4-5/8	7-1/4	M905-125
12.2	0.4803	5	7-3/4	M905-135
13.8	0.5433	5-3/8	8-1/4	M905-155
*14.2	0.5591	5-3/8	8-1/4	M905-165
*17.0	0.6693	6	9-1/4	M905-175
*19.0	0.7480	6-3/8	9-3/4	M905-185
*24.0	0.9449	7-1/8	10-7/8	M905-195

*** Outgoing Items**

SERIES M903 • STUB LENGTH • METRIC

DIAMETER (MM)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
13.8	0.5433	4-3/8	7-1/4	M903-110
16.7	0.6575	3-3/4	6-1/2	M903-115

SERIES M908 • EXTRA LENGTH • METRIC

DIAMETER (MM)	DECIMAL (IN.)	FLUTE LENGTH (MM)	OAL (MM)	PART NUMBER
9.5	0.3740	8	10-1/2	M908-105
9.5	0.3740	9-1/2	11-1/2	M908-110
9.5	0.3740	12-1/2	14-1/2	M908-115
11.5	0.4528	8	11	M908-120
12.2	0.4803	7	10-1/2	M908-125
13.8	0.5433	8-1/2	11-1/2	M908-130
16.0	0.6299	9-1/4	12	M908-135
16.8	0.6614	9	12	M908-140
17.0	0.6693	9-1/2	12-3/4	M908-145
19.0	0.7480	9	12	M908-150
24.5	0.9646	9	12	M908-155

• Specify finish when ordering where applicable



TAPER LENGTH • CARBIDE TIP • STRAIGHT SHANK

SERIES 905 • COOLANT-FED



SERIES: 905

SIZES

5/16" - 1"
INCH

Carbide tipped drill designed for non-ferrous materials such as aluminum and cast iron. Can be used in other materials such as steel but in steel applications performance may not be consistent. Double angle point increases the margin life. Carbide is C2 micrograin for top performance. Constant web with rolled heel provides maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
C2 MICROGRAIN	●		●
SPECIFICATIONS			
Helix: 22° -24° Standard			
Point: 118°/90° Double Angle			
Web: Standard			

DIAMETER INCH	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
5/16	0.3125	3-7/8	6-1/4	905-013
21/64	0.3281	4-1/8	6-1/2	905-014
11/32	0.3438	4-1/8	6-1/2	905-015
23/64	0.3594	4-1/4	6-3/4	905-016
3/8	0.3750	4-1/4	6-3/4	905-017
25/64	0.3906	4-3/8	7	905-018
13/32	0.4062	4-3/8	7	905-019
27/64	0.4219	4-5/8	7-1/4	905-020
7/16	0.4375	4-5/8	7-1/4	905-021
29/64	0.4531	4-7/8	7-1/2	905-022
15/32	0.4688	4-7/8	7-1/2	905-023
31/64	0.4844	5	7-3/4	905-024
1/2	0.5000	5	7-3/4	905-025
33/64	0.5156	5-1/4	8	905-026
17/32	0.5312	5-1/4	8	905-027
35/64	0.5469	5-3/8	8-1/4	905-028
9/16	0.5625	5-3/8	8-1/4	905-029
37/64	0.5781	5-5/8	8-1/2	905-030
19/32	0.5938	5-5/8	8-1/2	905-031
39/64	0.6094	5-3/4	8-3/4	905-032
5/8	0.6250	5-3/4	8-3/4	905-033
41/64	0.6406	5-7/8	9	905-034
21/32	0.6562	5-7/8	9	905-035

DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
43/64	0.6719	6	9-1/4	905-036
11/16	0.6875	6	9-1/4	905-037
45/64	0.7031	6-3/16	9-1/2	905-038
23/32	0.7188	6-3/16	9-1/2	905-039
47/64	0.7344	6-3/8	9-3/4	905-040
3/4	0.7500	6-3/8	9-3/4	905-041
*49/64	0.7656	6-1/2	9-7/8	905-042
*25/32	0.7812	6-1/2	9-7/8	905-043
*51/64	0.7969	6-5/8	10	905-044
*13/16	0.8125	6-5/8	10	905-045
*53/64	0.8281	6-3/4	10-1/4	905-046
*27/32	0.8438	6-3/4	10-1/4	905-047
*55/64	0.8594	7	10-1/2	905-048
*7/8	0.8750	7	10-1/2	905-049
*57/64	0.8906	7	10-5/8	905-050
*29/32	0.9062	7	10-5/8	905-051
*1	1.0000	7-3/16	11	905-057

* Outgoing Items

- For coolant entry specifications, see page 18.

EXTRA LENGTH • CARBIDE TIP • 9" FLUTE • STRAIGHT SHANK

SERIES 908 • COOLANT-FED



SERIES: 908

SIZES

5/8" - 1"
INCH

Carbide tipped drill designed for non-ferrous materials such as aluminum and cast iron. Can be used in other materials such as steel but in steel applications performance may not be consistent. Double angle point increases the margin life. Carbide is C2 micrograin for top performance. Constant web with rolled heel provides maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
C2 MICROGRAIN	●		●
SPECIFICATIONS			
Helix: 22° -24° Standard			
Point: 118°/90° Double Angle			
Web: Standard			

DIAMETER INCH	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
* 5/8	0.6250	9	12	908-034
* 41/64	0.6406	9	12	908-035
* 21/32	0.6562	9	12	908-036
* 47/64	0.7344	9	12	908-041
* 3/4	0.7500	9	12	908-042

* Outgoing Items

DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LENGTH (IN.)	OAL (IN.)	PART NUMBER
* 25/32	0.7812	9	12	908-044
* 13/16	0.8125	9	12	908-046
* 7/8	0.8750	9	12	908-050
* 61/64	0.9531	9	12	908-055
* 1	1.0000	9	12	908-058

* Outgoing Items

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable



STANDARD LENGTH • HIGH SPEED • TAPER SHANK

SERIES 802 • COOLANT-FED



SERIES: 802

SIZES

3/16" - 2" INCH

General purpose drill works well in most all materials. Suitable for both horizontal and vertical drilling. Taper shank allows the tool to quickly adapt to drill presses or special drilling machines. Notched point provides good chip formation when the proper speeds and feeds are applied. Constant web thickness with rolled heel provides maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●

SPECIFICATIONS

Helix: 32° - 34° Spiral
Point: 118° Notch
Web: Standard

DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER
3/16	0.1875	2-1/2	5-3/4	1	802-101
13/64	0.2031	2-3/4	6	1	802-102
7/32	0.2188	2-3/4	6	1	802-103
15/64	0.2344	2-7/8	6-1/8	1	802-104
1/4	0.2500	3-3/8	6-5/8	1	802-001
17/64	0.2656	3-5/8	6-7/8	1	802-002
9/32	0.2812	3-5/8	6-7/8	1	802-003
19/64	0.2969	3-7/8	7-1/8	1	802-004
5/16	0.3125	3-7/8	7-1/8	1	802-005
5/16	0.3125	3-7/8	7-3/4	2	802-005A
21/64	0.3281	4-1/8	8	2	802-006
21/64	0.3281	4-1/8	8-3/4	3	802-006A
11/32	0.3438	4-1/8	8	2	802-007
11/32	0.3438	4-1/8	8-3/4	3	802-007A
23/64	0.3594	4-1/4	8-1/8	2	802-008
23/64	0.3594	4-1/4	8-7/8	3	802-008A
3/8	0.3750	4-1/4	8-1/8	2	802-009
3/8	0.3750	4-1/4	8-7/8	3	802-009A
25/64	0.3906	4-3/8	8-1/4	2	802-010
25/64	0.3906	4-3/8	9	3	802-010A
13/32	0.4062	4-3/8	8-1/4	2	802-011
13/32	0.4062	4-3/8	9	3	802-011A
27/64	0.4219	4-5/8	8-1/2	2	802-012
27/64	0.4219	4-5/8	9-1/4	3	802-012A
7/16	0.4375	4-5/8	8-1/2	2	802-013
7/16	0.4375	4-5/8	9-1/4	3	802-013A
29/64	0.4531	4-7/8	8-3/4	2	802-014
29/64	0.4531	4-7/8	9-1/2	3	802-014A
15/32	0.4688	4-7/8	8-3/4	2	802-015
15/32	0.4688	4-7/8	9-1/2	3	802-015A
31/64	0.4844	4-3/8	9	2	802-016
31/64	0.4844	4-3/8	9	3	802-016A
1/2	0.5000	4-3/8	9	3	802-017
1/2	0.5000	4-3/8	9	2	802-017A
33/64	0.5156	4-5/8	9-1/4	3	802-018
33/64	0.5156	4-5/8	8-5/8	2	802-018A
17/32	0.5312	4-5/8	9-1/4	3	802-019
35/64	0.5469	4-7/8	9-1/2	3	802-020
9/16	0.5625	4-7/8	9-1/2	3	802-021
37/64	0.5781	4-7/8	9-1/2	3	802-022
19/32	0.5938	4-7/8	9-1/2	3	802-023
39/64	0.6094	4-7/8	9-1/2	3	802-024
5/8	0.6250	4-7/8	9-1/2	3	802-025
41/64	0.6406	5-1/8	9-3/4	3	802-026
21/32	0.6562	5-1/8	9-3/4	3	802-027
43/64	0.6719	5-3/8	10	3	802-028
11/16	0.6875	5-3/8	10	3	802-029
45/64	0.7031	5-3/8	10-1/4	3	802-030
23/32	0.7188	5-5/8	10-1/4	3	802-031
47/64	0.7344	5-7/8	10-1/2	3	802-032
*47/64	0.7344	5-7/8	9-5/8	2	802-032A
3/4	0.7500	5-7/8	10-1/2	3	802-033
49/64	0.7656	6	10-5/8	3	802-034
25/32	0.7812	6	10-5/8	3	802-035
51/64	0.7969	6-1/8	10-3/4	3	802-036
13/16	0.8125	6-1/8	10-3/4	3	802-037
53/64	0.8281	6-1/8	10-3/4	3	802-137
27/32	0.8438	6-1/8	10-3/4	3	802-138
55/64	0.8594	6-1/8	10-3/4	3	802-139

* Outgoing Items

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable

DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER
7/8	0.8750	6-1/8	10-3/4	3	802-038
57/64	0.8906	6-1/8	10-3/4	3	802-039
29/32	0.9062	6-1/8	10-3/4	3	802-040
59/64	0.9219	6-1/8	10-3/4	3	802-041
15/16	0.9375	6-1/8	10-3/4	3	802-042
61/64	0.9531	6-3/8	11	3	802-043
31/32	0.9688	6-3/8	11	3	802-044
63/64	0.9844	6-3/8	11	3	802-045
1	1.0000	6-3/8	11	3	802-046
1-1/32	1.0313	6-1/2	11-1/8	3	802-047
1-1/16	1.0625	6-5/8	11-1/4	3	802-048
1-1/16	1.0625	6-5/8	12-1/4	4	802-048A
1-3/32	1.0938	6-7/8	12-1/2	4	802-049
1-1/8	1.1250	7-1/8	12-3/4	4	802-050
1-5/32	1.1562	7-1/4	12-7/8	4	802-051
1-3/16	1.1875	7-3/8	13	4	802-052
1-7/32	1.2188	7-1/2	13-1/8	4	802-053
1-1/4	1.2500	7-7/8	13-1/2	4	802-054
1-9/32	1.2812	8-1/2	14-1/8	4	802-055
1-5/16	1.3125	8-5/8	14-1/4	4	802-056
1-11/32	1.3438	8-3/4	14-3/8	4	802-057
1-3/8	1.3750	8-7/8	14-1/2	4	802-058
1-13/32	1.4062	9	14-5/8	4	802-059
1-7/16	1.4375	9-1/8	14-3/4	4	802-060
1-15/32	1.4688	9-1/4	14-7/8	4	802-061
1-1/2	1.5000	9-3/8	15	4	802-062
1-9/16	1.5625	9-5/8	15-1/4	4	802-063
1-5/8	1.6250	10	15-5/8	4	802-064
1-11/16	1.6875	10-1/8	15-3/4	4	802-065
1-3/4	1.7500	10-1/8	16	4	802-066
1-13/16	1.8125	10-1/8	17-1/8	5	802-067
1-7/8	1.8750	10-3/8	17-3/8	5	802-068
1-15/16	1.9375	10-3/8	17-3/8	5	802-069
2	2.0000	10-3/8	17-3/8	5	802-070

LARGE DIAMETER

DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER
* 2-1/32	2.0312	10-1/4	17-3/8	5	802-090
* 2-1/16	2.0625	10-1/4	17-3/8	5	802-091
* 2-1/8	2.1250	10-1/4	17-3/8	5	802-092
* 2-3/16	2.1875	10-1/4	17-3/8	5	802-093
* 2-1/4	1.2500	10-1/8	17-3/8	5	802-094
* 2-5/16	2.3125	10-1/8	17-3/8	5	802-095
* 2-3/8	2.3750	10-1/8	17-3/8	5	802-096
* 2-7/16	2.4375	11-1/4	18-3/4	5	802-097
* 2-1/2	2.5000	11-1/4	18-3/4	5	802-098
* 2-9/16	2.5625	11-7/8	19-1/2	5	802-099
* 2-5/8	2.6250	11-7/8	19-1/2	5	802-100
* 2-11/16	2.6875	12-3/4	20-3/8	5	802-201
* 2-3/4	2.7500	12-3/4	20-3/8	5	802-202
* 2-13/16	2.8125	13-3/8	21-1/8	5	802-203
* 2-7/8	2.8750	13-3/8	21-1/8	5	802-204
* 2-15/16	2.9375	14	21-3/4	5	802-205
* 3	3.0000	14	21-3/4	5	802-206
* 3-1/16	3.0625	14-5/8	24-1/2	5	802-207
* 3-1/8	3.1250	14-5/8	24-1/2	5	802-208

* Outgoing Items



EXTRA LENGTH • 7" FLUTE • HIGH SPEED • TAPER SHANK

SERIES 807 • COOLANT-FED



SERIES: 807

SIZES

1/4" - 3/4"
INCH

General purpose drill works well in most all materials. Suitable for both horizontal and vertical drilling. Taper shank allows the tool to quickly adapt to drill presses or special drilling machines. Notched point provides good chip formation when the proper speeds and feeds are applied. Constant web thickness with rolled heel provides maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix: 32° -34° Spiral			
Point: 118° Notch			
Web: Standard			

DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER	DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER
1/4	0.2500	7	10-7/8	2	807-001	29/64	0.4531	7	10-7/8	2	807-013
1/4	0.2500	7	11-5/8	3	807-001A	29/64	0.4531	7	11-5/8	3	807-013A
17/64	0.2656	7	10-7/8	2	807-002	15/32	0.4688	7	10-7/8	2	807-014
17/64	0.2656	7	11-5/8	3	807-002A	15/32	0.4688	7	11-5/8	3	807-014A
9/32	0.2812	7	10-7/8	2	807-003	31/64	0.4844	7	11-5/8	3	807-015
9/32	0.2812	7	11-5/8	3	807-003A	1/2	0.5000	7	11-5/8	3	807-016
19/64	0.2969	7	10-7/8	2	807-004	33/64	0.5156	7	11-5/8	3	807-017
19/64	0.2969	7	11-5/8	3	807-004A	17/32	0.5312	7	11-5/8	3	807-018
5/16	0.3125	7	10-7/8	2	807-005	35/64	0.5469	7	11-5/8	3	807-019
5/16	0.3125	7	11-5/8	3	807-005A	9/16	0.5625	7	11-5/8	3	807-020
21/64	0.3281	7	10-7/8	2	807-006	37/64	0.5781	7	11-5/8	3	807-021
21/64	0.3281	7	11-5/8	3	807-006A	19/32	0.5938	7	11-5/8	3	807-022
11/32	0.3438	7	10-7/8	2	807-506	39/64	0.6094	7	11-5/8	3	807-023
11/32	0.3438	7	11-5/8	3	807-506A	5/8	0.6250	7	11-5/8	3	807-024
23/64	0.3594	7	10-7/8	2	807-007	41/64	0.6406	7	11-5/8	3	807-025
23/64	0.3594	7	11-5/8	3	807-007A	21/32	0.6562	7	11-5/8	3	807-026
3/8	0.3750	7	10-7/8	2	807-008	43/64	0.6719	7	11-5/8	3	807-027
3/8	0.3750	7	11-5/8	3	807-008A	11/16	0.6875	7	11-5/8	3	807-028
25/64	0.3906	7	10-7/8	2	807-009	45/64	0.7031	7	11-5/8	3	807-029
25/64	0.3906	7	11-5/8	3	807-009A	23/32	0.7188	7	11-5/8	3	807-030
13/32	0.4062	7	10-7/8	2	807-010	*23/32	0.7188	7	10-7/8	2	807-030A
13/32	0.4062	7	11-5/8	3	807-010A	47/64	0.7344	7	11-5/8	3	807-031
27/64	0.4219	7	10-7/8	2	807-011	3/4	0.7500	7	11-5/8	3	807-032
27/64	0.4219	7	11-5/8	3	807-011A						
7/16	0.4375	7	10-7/8	2	807-012						
7/16	0.4375	7	11-5/8	3	807-012A						

*** Outgoing Items**

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable

Note : Drill bushing or starter hole recommended when drilling under 3/8 diameter

TECHNICAL TIPS



We offer drill resharpening and reconditioning for all of our Drills. We also offer a variety of specialized drill points for specific applications. Please contact us for further information.



Visit our website at www.coolantfedtooling.com for technical information and our latest product offerings.



EXTRA LENGTH • 9" FLUTE • HIGH SPEED • TAPER SHANK

SERIES 809 • COOLANT-FED



SERIES: 809

SIZES

25/64" - 1-1/16" INCH

General purpose drill works well in most all materials. Suitable for both horizontal and vertical drilling. Taper shank allows the tool to quickly adapt to drill presses or special drilling machines. Notched point provides good chip formation when the proper speeds and feeds are applied. Constant web thickness with rolled heel provides maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix: 32° -34° Spiral			
Point: 118° Notch			
Web: Standard			

DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER	DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LGTH (IN.)	OAL (IN.)	M.T.	PART NUMBER
25/64	0.3906	9	12-7/8	2	809-009	5/8	0.6250	9	13-5/8	3	809-024
25/64	0.3906	9	13-5/8	3	809-009A	41/64	0.6406	9	13-5/8	3	809-025
13/32	0.4062	9	12-7/8	2	809-010	21/32	0.6562	9	13-5/8	3	809-026
13/32	0.4062	9	13-5/8	3	809-010A	43/64	0.6719	9	13-5/8	3	809-027
27/64	0.4219	9	12-7/8	2	809-011	11/16	0.6875	9	13-5/8	3	809-028
27/64	0.4219	9	13-5/8	3	809-011A	45/64	0.7031	9	13-5/8	3	809-029
7/16	0.4375	9	12-7/8	2	809-012	23/32	0.7188	9	13-5/8	3	809-030
7/16	0.4375	9	13-5/8	3	809-012A	47/64	0.7344	9	13-5/8	3	809-031
29/64	0.4531	9	12-7/8	2	809-013	3/4	0.7500	9	13-5/8	3	809-032
29/64	0.4531	9	13-5/8	3	809-013A	49/64	0.7656	9	13-5/8	3	809-033
15/32	0.4688	9	12-7/8	2	809-014	25/32	0.7812	9	13-5/8	3	809-034
15/32	0.4688	9	13-5/8	3	809-014A	13/16	0.8125	9	13-5/8	3	809-035
31/64	0.4844	9	13-5/8	3	809-015	27/32	0.8438	9	13-5/8	3	809-036
1/2	0.5000	9	13-5/8	3	809-016	7/8	0.8750	9	13-5/8	3	809-037
33/64	0.5156	9	13-5/8	3	809-017	29/32	0.9062	9	13-5/8	3	809-038
17/32	0.5312	9	13-5/8	3	809-018	15/16	0.9375	9	13-5/8	3	809-039
35/64	0.5469	9	13-5/8	3	809-019	31/32	0.9688	9	13-5/8	3	809-040
9/16	0.5625	9	13-5/8	3	809-020	1	1.0000	9	13-5/8	3	809-041
37/64	0.5781	9	13-5/8	3	809-021	1-1/32	1.0313	9	13-5/8	3	809-042
19/32	0.5938	9	13-5/8	3	809-022	1-1/16	1.0625	9	13-5/8	3	809-043
39/64	0.6094	9	13-5/8	3	809-023						

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable



For hole concentricity we recommend using **Series 605 Spotting Drill**, see page 14.

COMMON MACHINING EQUATIONS

SFM =	RPM X Dia. / 3.82
RPM =	3.82 x SFM / Dia.
IPM =	IPT x No. Teeth x RPM
IPT =	IPM / (No. Teeth x RPM)
IPR =	IPM / RPM

- SFM:** SURFACE FEET PER MINUTE
- RPM:** REVOLUTIONS PER MINUTE
- IPM:** INCHES PER MINUTE
- IPT:** INCHES PER TOOTH
- IPR:** INCHES PER REVOLUTION



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EXTRA LENGTH • 10" FLUTE • HIGH SPEED • TAPER SHANK

SERIES 810 • COOLANT-FED



SERIES: 810

SIZES

25/64" - 1-1/4"
INCH

General purpose drill works well in most all materials. Suitable for both horizontal and vertical drilling. Taper shank allows the tool to quickly adapt to drill presses or special drilling machines. Notched point provides good chip formation when the proper speeds and feeds are applied. Constant web thickness with rolled heel provides maximum chip clearance.

MATERIAL	BRIGHT	DARK	TiN
HSS	●	●	●
SPECIFICATIONS			
Helix: 32° -34° Spiral			
Point: 118° Notch			
Web: Standard			

DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH (IN.)	OAL (IN.)	M.T.	PART NUMBER	DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH (IN.)	OAL (IN.)	M.T.	PART NUMBER
25/64	0.3906	10	13-7/8	2	810-009	43/64	0.6719	10	14-5/8	3	810-027
25/64	0.3906	10	14-5/8	3	810-009A	11/16	0.6875	10	14-5/8	3	810-028
13/32	0.4062	10	13-7/8	2	810-010	45/64	0.7031	10	14-5/8	3	810-029
13/32	0.4062	10	14-5/8	3	810-010A	23/32	0.7188	10	14-5/8	3	810-030
27/64	0.4219	10	13-7/8	2	810-011	47/64	0.7344	10	14-5/8	3	810-031
27/64	0.4219	10	14-5/8	3	810-011A	3/4	0.7500	10	14-5/8	3	810-032
7/16	0.4375	10	13-7/8	2	810-012	49/64	0.7656	10	14-5/8	3	810-033
7/16	0.4375	10	14-5/8	3	810-012A	25/32	0.7812	10	14-5/8	3	810-034
29/64	0.4531	10	13-7/8	2	810-013	13/16	0.7968	10	14-5/8	3	810-035
29/64	0.4531	10	14-5/8	3	810-013A	27/32	0.8438	10	14-5/8	3	810-036
15/32	0.4688	10	13-7/8	2	810-014	7/8	0.8750	10	14-5/8	3	810-037
15/32	0.4688	10	14-5/8	3	810-014A	29/32	0.9062	10	14-5/8	3	810-038
31/64	0.4844	10	14-5/8	3	810-015	15/16	0.9375	10	14-5/8	3	810-039
1/2	0.5000	10	14-5/8	3	810-016	31/32	0.9688	10	14-5/8	3	810-040
33/64	0.5156	10	14-5/8	3	810-017	1	1.0000	10	14-5/8	3	810-041
17/32	0.5312	10	14-5/8	3	810-018	1-1/32	1.0313	10	14-5/8	3	810-042
35/64	0.5469	10	14-5/8	3	810-019	1-1/16	1.0625	10	14-5/8	3	810-043
9/16	0.5625	10	14-5/8	3	810-020	1-1/16	1.0625	10	15-7/8	4	810-043A
37/64	0.5781	10	14-5/8	3	810-021	1-3/32	1.0938	10	15-7/8	4	810-044
19/32	0.5938	10	14-5/8	3	810-022	1-1/8	1.1250	10	15-7/8	4	810-045
39/64	0.6094	10	14-5/8	3	810-023	1-5/32	1.1562	10	15-7/8	4	810-046
5/8	0.6250	10	14-5/8	3	810-024	1-3/16	1.1875	10	15-7/8	4	810-047
41/64	0.6406	10	14-5/8	3	810-025	1-7/32	1.2188	10	15-7/8	4	810-048
21/32	0.6562	10	14-5/8	3	810-026	1-1/4	1.2500	10	15-7/8	4	810-049

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable



For hole concentricity we recommend using **Series 605 Spotting Drill**, see page 14.

TECHNICAL TIPS

REQUIRED FOR SPEED AND FEED INFORMATION:

- Material being drilled
- Rockwell (Rc) or Brinell (Bhn) Hardness
- Diameter and Depth of hole
- Vertical or Horizontal Orientation
- Coolant Pressure of the Machine Tools Coolant Pump
- Type of Tool Holders being used (i.e., Collet Chuck)



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EXTRA LENGTH • 12" FLUTE • HIGH SPEED • TAPER SHANK

SERIES 812 • COOLANT-FED



SERIES: 812

SIZES

25/64" - 2" INCH

General purpose drill works well in most all materials. Suitable for both horizontal and vertical drilling. Taper shank allows the tool to quickly adapt to drill presses or special drilling machines. Notched point provides good chip formation when the proper speeds and feeds are applied. Constant web thickness with rolled heel provides maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix: 32° -34° Spiral			
Point: 118° Notch			
Web: Standard			

DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER	DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER
25/64	0.3906	12	15-7/8	2	812-009	13/16	0.8125	12	16-5/8	3	812-035
25/64	0.3906	12	16-5/8	3	812-009A	27/32	0.8438	12	16-5/8	3	812-036
13/32	0.4062	12	15-7/8	2	812-010	7/8	0.8750	12	16-5/8	3	812-037
13/32	0.4062	12	16-5/8	3	812-010A	29/32	0.9062	12	16-5/8	3	812-038
27/64	0.4219	12	15-7/8	2	812-011	15/16	0.9375	12	16-5/8	3	812-039
27/64	0.4219	12	16-5/8	3	812-011A	31/32	0.9688	12	16-5/8	3	812-040
7/16	0.4375	12	15-7/8	2	812-012	1	1.0000	12	16-5/8	3	812-041
7/16	0.4375	12	16-5/8	3	812-012A	1-1/32	1.0313	12	16-5/8	3	812-042
29/64	0.4531	12	15-7/8	2	812-013	1-1/16	1.0625	12	16-5/8	3	812-043
29/64	0.4531	12	16-5/8	3	812-013A	1-3/32	1.0938	12	16-5/8	4	812-044
15/32	0.4688	12	15-7/8	2	812-014	1-1/8	1.1250	12	17-7/8	4	812-045
15/32	0.4688	12	16-5/8	3	812-014A	1-5/32	1.1562	12	17-7/8	4	812-046
31/64	0.4844	12	16-5/8	3	812-015	1-3/16	1.1875	12	17-7/8	4	812-047
1/2	0.5000	12	16-5/8	3	812-016	1-7/32	1.2188	12	17-7/8	4	812-048
33/64	0.5156	12	16-5/8	3	812-017	1-1/4	1.2500	12	17-7/8	4	812-049
17/32	0.5312	12	16-5/8	3	812-018	1-9/32	1.2812	12	17-7/8	4	812-050
35/64	0.5469	12	16-5/8	3	812-019	1-5/16	1.3125	12	17-7/8	4	812-051
9/16	0.5625	12	16-5/8	3	812-020	1-11/32	1.3438	12	17-7/8	4	812-052
37/64	0.5781	12	16-5/8	3	812-021	1-3/8	1.3750	12	17-7/8	4	812-053
19/32	0.5938	12	16-5/8	3	812-022	1-13/32	1.4062	12	17-7/8	4	812-054
39/64	0.6094	12	16-5/8	3	812-023	1-7/16	1.4375	12	17-7/8	4	812-055
5/8	0.6250	12	16-5/8	3	812-024	1-15/32	1.4687	12	17-7/8	4	812-056
41/64	0.6406	12	16-5/8	3	812-025	1-1/2	1.5000	12	17-7/8	4	812-057
21/32	0.6562	12	16-5/8	3	812-026	1-9/16	1.5625	12	19	4	812-058
43/64	0.6719	12	16-5/8	3	812-027	1-5/8	1.6250	12	19	4	812-059
11/16	0.6875	12	16-5/8	3	812-028	1-11/16	1.6875	12	19	4	812-060
45/64	0.7031	12	16-5/8	3	812-029	1-3/4	1.7500	12	19	4	812-061
23/32	0.7188	12	16-5/8	3	812-030	1-13/16	1.8125	12	19	5	812-085
47/64	0.7344	12	16-5/8	3	812-031	1-7/8	1.8750	12	19	5	812-086
3/4	0.7500	12	16-5/8	3	812-032	1-15/16	1.9375	12	19	5	812-087
49/64	0.7656	12	16-5/8	3	812-033	2	2.0000	12	19	5	812-062
25/32	0.7812	12	16-5/8	3	812-034						

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable.



For hole concentricity we recommend using **Series 605 Spotting Drill**, see page 14.



EXTRA LENGTH • 14" FLUTE • HIGH SPEED • TAPER SHANK

SERIES 814 • COOLANT-FED



MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix: 32° -34° Spiral			
Point: 118° Notch			
Web: Standard			

SERIES: 814
SIZES
27/64" - 2" INCH

General purpose drill works well in most all materials. Suitable for both horizontal and vertical drilling. Taper shank allows the tool to quickly adapt to drill presses or special drilling machines. Notched point provides good chip formation when the proper speeds and feeds are applied. Constant web thickness with rolled heel provides maximum chip clearance.

DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER	DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER
27/64	0.4219	14	17-7/8	2	814-011	7/8	0.8750	14	18-5/8	3	814-037
7/16	0.4375	14	17-7/8	2	814-012	29/32	0.9062	14	18-5/8	3	814-038
7/16	0.4375	14	18-5/8	3	814-012A	15/16	0.9375	14	18-5/8	3	814-039
29/64	0.4531	14	17-7/8	2	814-013	31/32	0.9688	14	18-5/8	3	814-040
29/64	0.4531	14	18-5/8	3	814-013A	1	1.0000	14	18-5/8	3	814-041
15/32	0.4688	14	17-7/8	2	814-014	1-1/32	1.0313	14	18-5/8	3	814-042
15/32	0.4688	14	18-5/8	3	814-014A	1-1/16	1.0625	14	18-5/8	3	814-043
31/64	0.4844	14	18-5/8	3	814-015	1-3/32	1.0938	14	19-7/8	4	814-044
1/2	0.5000	14	18-5/8	3	814-016	1-1/8	1.1250	14	19-7/8	4	814-045
33/64	0.5156	14	18-5/8	3	814-017	1-5/32	1.1562	14	19-7/8	4	814-046
17/32	0.5312	14	18-5/8	3	814-018	1-3/16	1.1875	14	19-7/8	4	814-047
35/64	0.5469	14	18-5/8	3	814-019	1-7/32	1.2188	14	19-7/8	4	814-048
9/16	0.5625	14	18-5/8	3	814-020	1-1/4	1.2500	14	19-7/8	4	814-049
37/64	0.5781	14	18-5/8	3	814-021	1-9/32	1.2812	14	19-7/8	4	814-050
19/32	0.5938	14	18-5/8	3	814-022	1-5/16	1.3125	14	19-7/8	4	814-051
39/64	0.6094	14	18-5/8	3	814-023	1-11/32	1.3438	14	19-7/8	4	814-052
5/8	0.6250	14	18-5/8	3	814-024	1-3/8	1.3750	14	19-7/8	4	814-053
41/64	0.6406	14	18-5/8	3	814-025	1-13/32	1.4062	14	19-7/8	4	814-054
21/32	0.6562	14	18-5/8	3	814-026	1-7/16	1.4375	14	19-7/8	4	814-055
43/64	0.6719	14	18-5/8	3	814-027	1-15/32	1.4687	14	19-7/8	4	814-056
11/16	0.6875	14	18-5/8	3	814-028	1-1/2	1.5000	14	19-7/8	4	814-057
45/64	0.7031	14	18-5/8	3	814-029	1-9/16	1.5625	14	21	4	814-058
23/32	0.7188	14	18-5/8	3	814-030	1-5/8	1.6250	14	21	4	814-059
47/64	0.7344	14	18-5/8	3	814-031	1-11/16	1.6875	14	21	4	814-060
3/4	0.7500	14	18-5/8	3	814-032	1-3/4	1.7500	14	21	4	814-061
49/64	0.7656	14	18-5/8	3	814-033	1-13/16	1.8125	14	21	5	814-085
25/32	0.7812	14	18-5/8	3	814-034	1-7/8	1.8750	14	21	5	814-086
13/16	0.8125	14	18-5/8	3	814-035	1-15/16	1.9375	14	20-1/2	5	814-087
27/32	0.8438	14	18-5/8	3	814-036	2	2.0000	14	21	5	814-062

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable



For hole concentricity we recommend using **Series 605 Spotting Drill**, see page 14.

TECHNICAL TIPS



We offer drill resharpening and reconditioning for all of our Drills. We also offer a variety of specialized drill points for specific applications. Please contact us for further information.



Visit our website at www.coolantfedtooling.com for technical information and our latest product offerings.



EXTRA LENGTH • 17" FLUTE • HIGH SPEED • TAPER SHANK

SERIES 817 • COOLANT-FED



SERIES: 817

SIZES

7/16" - 2"
INCH

General purpose drill works well in most all materials. Suitable for both horizontal and vertical drilling. Taper shank allows the tool to quickly adapt to drill presses or special drilling machines. Notched point provides good chip formation when the proper speeds and feeds are applied. Constant web thickness with rolled heel provides maximum chip clearance.

MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	●
SPECIFICATIONS			
Helix: 32° -34° Spiral			
Point: 118° Notch			
Web: Standard			

DIAMETER INCH	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER	DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER
7/16	0.4375	17	20-7/8	2	817-012	29/32	0.9062	17	21-5/8	3	817-038
7/16	0.4375	17	21-5/8	3	817-012A	15/16	0.9375	17	21-5/8	3	817-039
29/64	0.4531	17	20-7/8	2	817-013	31/32	0.9688	17	21-5/8	3	817-040
29/64	0.4531	17	21-5/8	3	817-013A	1	1.0000	17	21-5/8	3	817-041
15/32	0.4688	17	20-7/8	2	817-014	1-1/32	1.0313	17	21-5/8	3	817-042
15/32	0.4688	17	21-5/8	3	817-014A	1-1/16	1.0625	17	21-5/8	3	817-043
31/64	0.4844	17	21-5/8	3	817-015	1-1/16	1.0625	17	22-7/8	4	817-043A
1/2	0.5000	17	21-5/8	3	817-016	1-3/32	1.0938	17	22-7/8	4	817-044
33/64	0.5156	17	21-5/8	3	817-017	1-1/8	1.1250	17	22-7/8	4	817-045
17/32	0.5312	17	21-5/8	3	817-018	1-5/32	1.1562	17	22-7/8	4	817-046
35/64	0.5469	17	21-5/8	3	817-019	1-3/16	1.1875	17	22-7/8	4	817-047
9/16	0.5625	17	21-5/8	3	817-020	1-7/32	1.2188	17	22-7/8	4	817-048
37/64	0.5781	17	21-5/8	3	817-021	1-1/4	1.2500	17	22-7/8	4	817-049
19/32	0.5938	17	21-5/8	3	817-022	1-9/32	1.2812	17	22-7/8	4	817-050
39/64	0.6094	17	21-5/8	3	817-023	1-5/16	1.3125	17	22-7/8	4	817-051
5/8	0.6250	17	21-5/8	3	817-024	1-11/32	1.3438	17	22-7/8	4	817-052
41/64	0.6406	17	21-5/8	3	817-025	1-3/8	1.3750	17	22-7/8	4	817-053
21/32	0.6562	17	21-5/8	3	817-026	1-13/32	1.4062	17	22-7/8	4	817-054
43/64	0.6719	17	21-5/8	3	817-027	1-7/16	1.4375	17	22-7/8	4	817-055
11/16	0.6875	17	21-5/8	3	817-028	1-15/32	1.4687	17	22-7/8	4	817-056
45/64	0.7031	17	21-5/8	3	817-029	1-1/2	1.5000	17	22-7/8	4	817-057
23/32	0.7188	17	21-5/8	3	817-030	1-9/16	1.5625	17	24	4	817-058
47/64	0.7344	17	21-5/8	3	817-031	1-5/8	1.6250	17	24	4	817-059
3/4	0.7500	17	21-5/8	3	817-032	1-11/16	1.6875	17	24	4	817-060
49/64	0.7656	17	21-5/8	3	817-033	1-3/4	1.7500	17	24	4	817-061
25/32	0.7812	17	21-5/8	3	817-034	1-13/16	1.8125	17	24	5	817-085
13/16	0.8125	17	21-5/8	3	817-035	1-15/16	1.9375	17	24	5	817-087
27/32	0.8438	17	21-5/8	3	817-036	2	2.0000	17	24	5	817-062
7/8	0.8750	17	21-5/8	3	817-037						

- For coolant entry specifications, see page 18.
- Specify finish when ordering where applicable



For hole concentricity we recommend using **Series 605 Spotting Drill**, see page 14.

TECHNICAL TIPS



We offer drill sharpening and reconditioning for all of our Drills. We also offer a variety of specialized drill points for specific applications. Please contact us for further information.



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EXTRA LENGTH • 19" FLUTE • HIGH SPEED • TAPER SHANK

SERIES 819 • COOLANT-FED



MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	

SPECIFICATIONS

Helix: 32° -34° Spiral
Point: 118° Notch
Web: Standard

SERIES: 819

SIZES

7/16"-2"
INCH

General purpose drill works well in most all materials. Suitable for both horizontal and vertical drilling. Taper shank allows the tool to quickly adapt to drill presses or special drilling machines. Notched point provides good chip formation when the proper speeds and feeds are applied. Constant web thickness with rolled heel provides maximum chip clearance.

DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER	DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER
* 7/16	0.4375	19	22-7/8	2	819-012	* 47/64	0.7344	19	23-5/8	3	819-031
* 7/16	0.4375	19	23-5/8	3	819-012A	* 3/4	0.7500	19	23-5/8	3	819-032
* 29/64	0.4531	19	22-7/8	2	819-013	* 49/64	0.7656	19	23-5/8	3	819-033
* 29/64	0.4531	19	23-5/8	3	819-013A	* 25/32	0.7812	19	23-5/8	3	819-034
* 15/32	0.4688	19	22-7/8	2	819-014	* 13/16	0.8125	19	23-5/8	3	819-035
* 15/32	0.4688	19	23-5/8	3	819-014A	* 7/8	0.8750	19	23-5/8	3	819-037
* 31/64	0.4844	19	23-5/8	3	819-015	* 29/32	0.9062	19	23-5/8	3	819-038
* 1/2	0.5000	19	23-5/8	3	819-016	* 31/32	0.9688	19	23-5/8	3	819-040
* 35/64	0.5469	19	23-5/8	3	819-019	* 1-5/32	1.1562	19	24-7/8	4	819-046
* 37/64	0.5781	19	23-5/8	3	819-021	* 1-1/4	1.2500	19	24-7/8	4	819-049
* 19/32	0.5938	19	23-5/8	3	819-022	* 1-15/32	1.4688	19	24-7/8	4	819-056
* 39/64	0.6094	19	23-5/8	3	819-023	* 1-9/16	1.5625	19	26	4	819-058
* 43/64	0.6719	19	23-5/8	3	819-027	* 1-5/8	1.6250	19	26	4	819-059
* 45/64	0.7031	19	23-5/8	3	819-029	* 1-3/4	1.7500	19	26	4	819-061
* 23/32	0.7188	19	23-5/8	3	819-030	* 2	2.0000	19	26	5	819-062

* **Outgoing Items**



For hole concentricity we recommend using **Series 605 Spotting Drill**, see page 14.

SUPER LENGTH • HIGH SPEED • TAPER SHANK

SERIES 822 • COOLANT-FED • 22" FLUTE



MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	

SPECIFICATIONS

Helix: 32° -34° Spiral
Point: 118° Notch
Web: Standard

SERIES: 822

SIZES

3/4"-1-1/8"
INCH

General purpose drill works well in most all materials. Suitable for both horizontal and vertical drilling. Taper shank allows the tool to quickly adapt to drill presses or special drilling machines. Notched point provides good chip formation when the proper speeds and feeds are applied. Constant web thickness with rolled heel provides maximum chip clearance.

DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER
* 3/4	0.7500	22	26-5/8	3	822-032
* 7/8	0.8750	22	26-5/8	3	822-037
* 1-1/8	1.1250	22	27-5/8	4	822-045

* **Outgoing Items**

SUPER LENGTH • HIGH SPEED • TAPER SHANK

SERIES 724 • COOLANT-FED • 24" Flute



MATERIAL	BRIGHT	DARK	TIN
HSS	●	●	

SPECIFICATIONS

Helix: 32° -34° Spiral
Point: 118° Notch
Web: Standard

SERIES: 724

SIZES

11/16"-1-15/16"
INCH

General purpose drill works well in most all materials. Suitable for both horizontal and vertical drilling. Taper shank allows the tool to quickly adapt to drill presses or special drilling machines. Notched point provides good chip formation when the proper speeds and feeds are applied. Constant web thickness with rolled heel provides maximum chip clearance.

DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER	DIAMETER (IN.)	DECIMAL (IN.)	FLUTE LGTH. (IN.)	OAL (IN.)	M.T.	PART NUMBER
* 11/16	0.6875	24	28-3/4	3	724-028	* 1-1/2	1.5000	24	29-5/8	4	724-057
* 3/4	0.7500	24	28-5/8	3	724-032	* 1-15/16	1.9375	24	31	5	724-087
* 7/8	0.8750	24	28-5/8	3	724-037	* Outgoing Items					

* **Outgoing Items**

• For coolant entry specifications, see page 18. • Specify finish when ordering where applicable.