JAYKAY

TRUSTWORTHY POWERFUL SOLUTIONS

HSS DRILLS & MASONRY DRILLS

No 1 File Company in South East Asia

PT. Jaykay Files Indonesia

Jaykay Files Indonesia was established in the year 1974 and has since earned a well-deserved reputation in File industry. We along with the JK Files India are the world's largest manufacturer of Steel Files and export more than 50% of our production to more than 17 countries like USA, Japan, Europe, Latin America, Asia Pacific and other Asian countries. We have a large network of Agents and Distributors spread throughout these markets.

PT Jaykay brings its rich experience and legacy of manufacturing of Files & drills and quality Hand Tools, having more than 45 years of manufacturing experience and legacy our Three Files, Sunflower brand files across the product categories such as Slim Taper, Mechanist, Jewelry and RASP Files are recognized as premium products in the Industry. Being an ISO 9001 :2000 certified Company, strict quality controls and processes are followed all the way from the Raw Material procurement till final testing of the products to ensure the best quality products are delivered to our customers.

In 2017 Company has opened up new facility in Semarang in Central Java to ensure that we keep serving our customer and produce high quality products in the most cost efficient manner so that we as a company and our customers remains competitive in the market place.

The biggest strength of PTJK is the people , most of our staff members are qualified engineers with very good mix of Industry veteran and new young comers which brings fresh prospective in the business. At PTJK we also value diversity and 30% of our total workforce across the levels is female employees.

We assure all our customers the best services, quality products and value for money.

Parag Khare
President Director

Quality Policy

For our consistent growth, we are committed to provide products & services that meet our customers requirements and enhance their satisfaction by understanding their needs of Quality, Cost, Delivery and accordingly improve our products and services.

We will continually improve the effectiveness and compliance of our Quality Management System with the involvement of employees.

Parag Khare
President Director

IS/ISO 9001: 2008
CERTIFIED

Files made to International Specifications

B.S.S. : British Standard Specification 498:Part 1,: 1960: Metric Values

A.S.S. : Federal (American Pattern) Standard Specification GCG-F-325b

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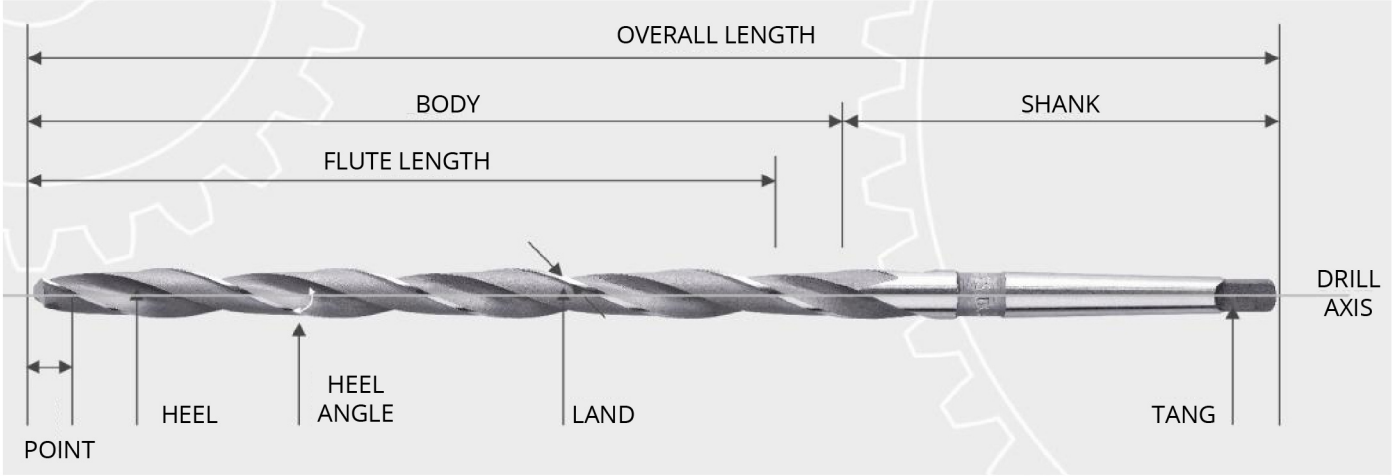
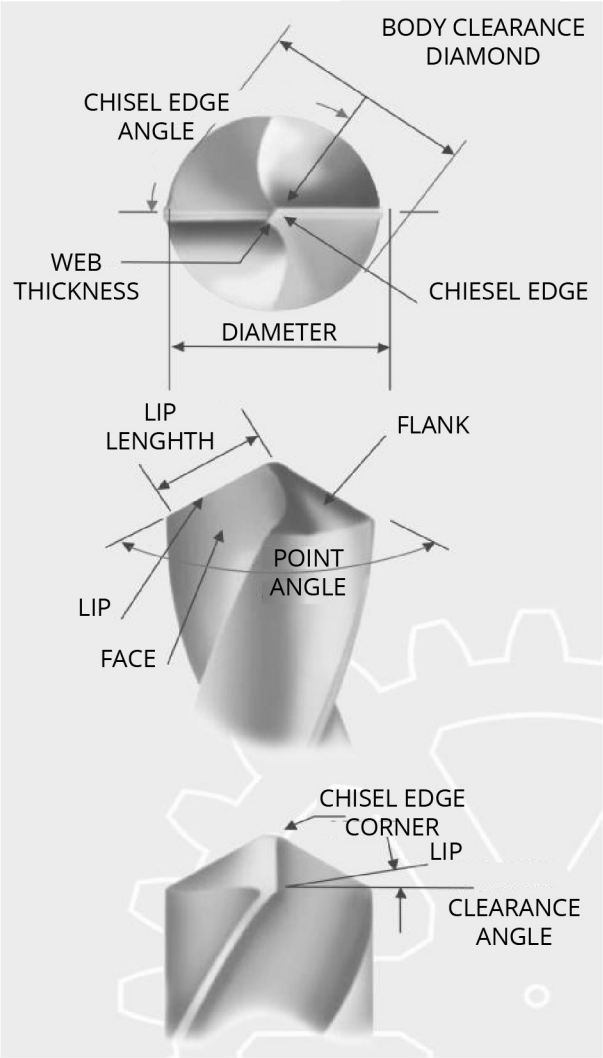
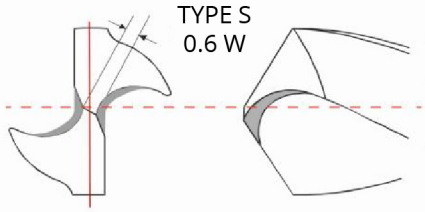
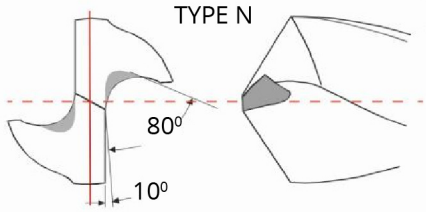
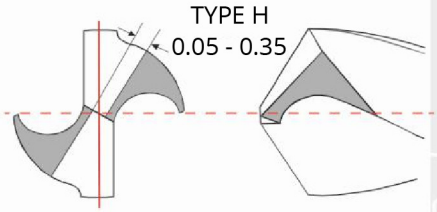
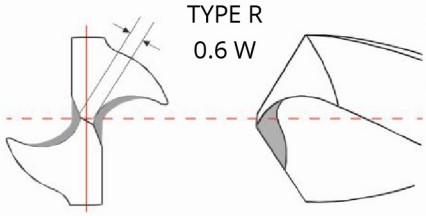
Twist Drill Nomenclature





Web Thinning

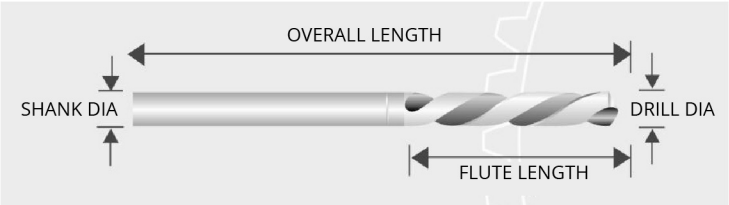
	EFFECTS	APPLICATION
	• For general purpose • Easy thinning process	• General material
	• Maintains strength of the point • Excellent cooling effect • Good chip discharge	• Same as type S • For deep-hole drilling
	• Large decrease in thrust • Minimized skidding or walking of the drill point when starting a hold • When specially designed heavy web drill	• For deep-hole drilling • Automotive crankshaft • Materials of poor machinability such as stainless stell and heat resistant alloys (not heavy cutting)
	• Decreases thrust and prevents chipping of cutting edges	• For heavy cutting • Used mainly for rails and manganese steel

Jobber Series Drills

SIZE-DIAMETER			LENGTH (MM)		SIZE-DIAMETER			LENGTH (MM)		SIZE-DIAMETER			LENGTH (MM)	
MM	INCH	DG/LG	FLUTE	OVERALL	MM	INCH	DG/LG	FLUTE	OVERALL	MM	INCH	DG/LG	FLUTE	OVERALL
0.50			6	22	2.37		42	30	57	4.10			43	75
0.55			7	24	2.38	3/32		30	57	4.20			43	75
0.60			7	24	2.40			30	57	4.22		19	43	75
0.65			8	26	2.44		41	30	57	4.30		18	47	80
0.70			9	28	2.49		40	30	57	4.37	11/64		47	80
0.75	1/32		9	28	2.50			30	57	4.39		17	47	80
0.80			10	30	2.53		39	30	57	4.40			47	80
0.85			10	30	2.58		38	30	57	4.50		16	47	80
0.90			11	32	2.60			30	57	4.57		15	47	80
0.95			11	32	2.64		37	30	57	4.60			47	80
1.00			12	34	2.70			33	61	4.62		14	47	80
1.02			12	34	2.71		36	33	61	4.70		13	47	80
1.04			12	34	2.78	7/64		33	61	4.76	3/16		52	86
1.07			14	36	2.79		35	33	61	4.80		12	52	86
1.09		57	14	36	2.80			33	61	4.85		11	52	86
1.10			14	36	2.82		34	33	61	4.90			52	86
1.18		56	14	36	2.87		33	33	61	4.92		10	52	86
1.19	3/64		16	38	2.90			33	61	4.98		9	52	86
1.20			16	38	2.95		32	33	61	5.00			52	86
1.30			16	38	3.00			33	61	5.06		8	52	86
1.32		55	16	38	3.05		31	36	65	5.10			52	86
1.40		54	18	40	3.10			36	65	5.11		7	52	86
1.50			18	40	3.17	1/8		36	65	5.16	13/64		52	86
1.51		53	20	43	3.20			36	65	5.18		6	52	86
1.59	1/16		20	43	3.26		30	36	65	5.20			52	86
1.60			20	43	3.30			36	65	5.22		5	52	86
1.61		52	20	43	3.40			39	70	5.30			52	86
1.70		51	20	43	3.45		29	39	70	5.31		4	57	93
1.78		50	22	46	3.50			39	70	5.40			57	93
1.80			22	46	3.57	9/64	28	39	70	5.41		3	57	93
1.85		49	22	46	3.60			39	70	5.50			57	93
1.90			22	46	3.66		27	39	70	5.56	7/32		57	93
1.93		48	24	49	3.70			39	70	5.60			57	93
1.98	5/64		24	49	3.73		26	39	70	5.61		2	57	93
1.99		47	24	49	3.80		25	43	75	5.70			57	93
2.00			24	49	3.86		24	43	75	5.79		1	57	93
2.06		46	24	49	3.90			43	75	5.80			57	93
2.08		45	24	49	3.91		23	43	75	5.90			57	93
2.10			24	49	3.97	5/32		43	75	5.94		A	57	93
2.18		44	27	53	3.99		22	43	75	5.95	15/64		57	93

SIZE-DIAMETER			LENGTH (MM)		SIZE-DIAMETER			LENGTH (MM)		SIZE-DIAMETER			LENGTH (MM)	
MM	INCH	DG/LG	FLUTE	OVERALL	MM	INCH	DG/LG	FLUTE	OVERALL	MM	INCH	DG/LG	FLUTE	OVERALL
6.15		C	63	101	8.73	11/32		81	125	11.60			94	142
6.2			63	101	8.80			81	125	11.70			94	142
6.25		D	63	101	8.84		S	81	125	11.80			94	142
6.3			63	101	8.90			81	125	11.90			101	151
6.35	1/4	E	63	101	9.00			81	125	11.91	15/32		101	151
6.4			63	101	9.09		T	81	125	12.00			101	151
6.5			63	101	9.10			81	125	12.10			101	151
6.53		F	63	101	9.13	23/64		81	125	12.20			101	151
6.6			63	101	9.20			81	125	12.30	31/64		101	151
6.63		G	63	101	9.30			81	125	12.40			101	151
6.7			63	101	9.34		U	81	125	12.50			101	151
6.75	17/64	H	69	109	9.40			81	125	12.60			101	151
6.8			69	109	9.50			81	125	12.70	1/2		101	151
6.9		I	69	109	9.52	3/8		87	133	12.80			101	151
7			69	109	9.58		V	87	133	12.90			101	151
7.03		J	69	109	9.60			87	133	13.00			101	151
7.1			69	109	9.70			87	133	13.10	33/64		101	151
7.14	9/32	K	69	109	9.80		W	87	133	13.20			101	151
7.2			69	109	9.90			87	133	13.30			108	160
7.3			69	109	9.92	25/64		87	133	13.40			108	160
7.37		L	69	109	10.00			87	133	13.49	17/32		108	160
7.4			69	109	10.08		X	87	133	13.50			108	160
7.49		M	69	109	10.10			87	133	13.60			108	160
7.5			69	109	10.20			87	133	13.70			108	160
7.54	19/64		75	117	10.26		Y	87	133	13.80			108	160
7.6			75	117	10.30			87	133	13.89	35/64		108	160
7.67		N	75	117	10.32	13/32		87	133	13.90			108	160
7.7			75	117	10.40			87	133	14.00			108	160
7.8			75	117	10.49		Z	87	133	14.25			114	169
7.9			75	117	10.50			87	133	14.29	9./16		114	169
7.94	5/16		75	117	10.60			87	133	14.50			114	169
8			75	117	10.70			94	142	14.68	37/64		114	169
8.03		O	75	117	10.72	27/64		94	142	14.75			114	169
8.1			75	117	10.80			94	142	15.00			114	169
8.2		P	75	117	10.90			94	142	15.08	19/32		120	178
8.3			75	117	11.00			94	142	15.25			120	178
8.33	21/64		75	117	11.10			94	142	15.48	39/64		120	178
8.4			75	117	11.11	7/16		94	142	15.50			120	178
8.43		Q	75	117	11.20			94	142	15.75			120	178
					11.30			94	142	15.87	5/8		120	178

Standard straight shank ground flute drill for general purpose application on Steel and Cast steel, alloyed and non-alloyed, Grey cast iron, German silver steel, Graphite, etc.



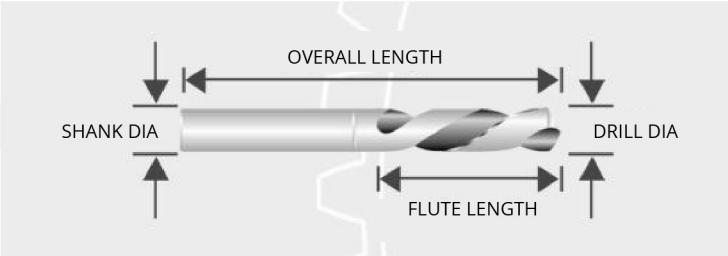
Stub Series Drills

SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)	
MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL
1.00		6	26	5.95	15/64	28	66	10.80		47	95
1.19	3/64	8	30	6.00		28	66	11.00		47	95
1.20		8	30	6.20		31	70	11.11	7/16	47	95
1.50		9	32	6.35	1/4	31	70	11.20		47	95
1.59	1/16	10	34	6.50		31	70	11.50		47	95
1.80		11	36	6.75	17/64	34	74	11.51	29/64	47	95
1.98	5/64	12	38	6.80		34	74	11.80		47	95
2.00		12	38	7.00		34	74	11.91	15/32	51	102
2.20		13	40	7.14	9/32	34	74	12.00		51	102
2.38	3/32	14	43	7.20		34	74	12.20		51	102
2.50		14	43	7.50		34	74	12.30	31/64	51	102
2.78	7/64	16	46	7.54	19.64	37	79	12.50		51	102
2.80		16	46	7.80		37	79	12.70	1/2	51	102
3.00		16	46	7.94	5.16	37	79	12.80		51	102
3.17	1/8	18	49	8.00		37	79	13.00		51	102
3.20		18	49	8.20		37	79	13.20		51	102
3.50		20	52	8.33	21/64	37	79	13.49	17/32	54	107
3.57	9/64	20	52	8.50		37	79	13.50		54	107
3.80		22	55	8.73	11/32	40	84	13.80		54	107
3.97	5/32	22	55	8.80		40	84	14.00		54	107
4.00		22	55	9.00		40	84	14.25		56	111
4.20		22	55	9.13	23/64	40	84	14.29	9/16	56	111
4.37	11/64	24	58	9.20		40	84	14.50		56	111
4.50		24	58	9.50		40	84	14.75		56	111
4.76	3/16	26	62	9.52	3/8	43	89	15.00		56	111
4.80		26	62	9.80		43	89	15.08	19/32	58	115
5.00		26	62	9.92	25/64	43	89	15.25		58	115
5.16	13/64	26	62	10.00		43	89	15.50		58	115
5.20		26	62	10.20		43	89	15.75		58	115
5.50		28	66	10.32	13/32	43	89	15.87	5/8	58	115

IS: 5100/DIN: 1897/BS: 328/I.S.O.

SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)	
MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL
16.50		60	119	22.50		72	146	30.50		87	174
16.67	21/32	60	119	22.75		72	146	30.96	1.7/32	87	174
16.75		60	119	23.00		72	146	31.00		87	174
17.00		60	119	23.02	29/32	72	146	31.50		87	174
17.25		62	123	23.25		72	146	31.75	1.1/4	90	180
17.46	11/16	62	123	23.50		72	146	32.00		90	180
17.50		62	123	23.75		75	151	32.50		90	180
17.75		62	123	23.81	15/16	75	151	32.54	1.9/32	90	180
18.00		62	123	24.00		75	151	33.00		90	180
18.25		64	127	24.25		75	151	33.34	1.5/16	90	180
18.26	23/32	64	127	24.50		75	151	33.50		90	180
18.50		64	127	24.61	31/32	75	151	34.00		93	186
18.75		64	127	24.75		75	151	34.13	1.11/32	93	186
19.00		64	127	25.00		75	151	34.50		93	186
19.05	3/4	66	131	25.25		78	156	34.92	1.3/8	93	186
19.25		66	131	25.40	1	78	156	35.00		93	186
19.50		66	131	25.50		78	156	35.50		93	186
19.75		66	131	26.00		78	156	35.72	1.13/32	96	193
19.84	25/32	66	131	26.19	1.1/32	78	156	36.00		96	193
20.00		66	131	26.50		78	156	36.50		96	193
20.25		68	136	26.99	1.1/16	81	162	36.51	1.7/16	96	193
20.50		68	136	27.00		81	162	37.00		96	193
20.64	13/16	68	136	27.50		81	162	37.31	1.15/32	96	193
20.75		70	141	27.78	1.3/32	81	162	37.50		96	193
21.00		70	141	28.00		81	162	38.00		100	200
21.25		70	141	28.50		84	168	38.10	1.1/2	100	200
21.43	27/32	70	141	28.57	1.1/8	84	168	38.50		100	200
21.50		70	141	29.00		84	168	39.00		100	200
21.75		70	141	29.37	1.5/32	84	168	39.50		100	200
22.00		70	141	29.50		84	168	40.00		100	200

Standard straight shank ground flute drill, recommended for use with hand drilling machine in drilling thin sections, sheet metal, car and bus bodies etc. Also, for use in automatic and capstan lathes.



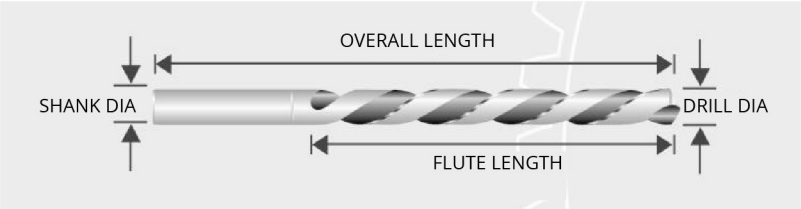
Long Series Drills

SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)	
MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL
1.00		33	56	4.30		82	126	7.54	19/64	109	165
1.10		37	60	4.37	11/64	82	126	7.60		109	165
1.19	3/64	41	65	4.40		82	126	7.70		109	165
1.20		41	65	4.50		82	126	7.80		109	165
1.30		41	65	4.60		82	126	7.90		109	165
1.40		45	70	4.70		82	126	7.94		109	165
1.50		45	70	4.76	3/16	87	132	8.00		109	165
1.59	1/16	50	76	4.80		87	132	8.10		109	165
1.60		50	76	4.90		87	132	8.20		109	165
1.70		50	76	5.00		87	132	8.30		109	165
1.80		53	80	5.10		87	132	8.33	21/64	109	165
1.90		53	80	5.16	13/64	87	132	8.40		109	165
1.98	5/64	56	85	5.20		87	132	8.50		109	165
2.00		56	85	5.30		87	132	8.60		115	175
2.10		56	85	5.40		91	139	8.70		115	175
2.20		59	90	5.50		91	139	8.73	11/32	115	175
2.30		59	90	5.56	7/32	91	139	8.80		115	175
2.38	3/32	62	95	5.60		91	139	9.00		115	175
2.40		62	95	5.70		91	139	9.13	23/64	115	175
2.50		62	95	5.80		91	139	9.20		115	175
2.60		62	95	5.90		91	139	9.50		115	175
2.70		66	100	5.95	15/64	91	139	9.52	3/8	121	184
2.78	7/64	66	100	6.00		91	139	9.80		121	184
2.80		66	100	6.10		97	148	9.92	25/64	121	184
2.90		66	100	6.20		97	148	10.00		121	184
3.00		66	100	6.30		97	148	10.20		121	184
3.10		69	106	6.35	1/4	97	148	10.32	13/32	121	184
3.17	1/8	69	106	6.40		97	148	10.50		121	184
3.20		69	106	6.50		97	148	10.72	27/64	128	195
3.30		69	106	6.60		97	148	10.80		128	195
3.40		73	112	6.70		97	148	11.00		128	195
3.50		73	112	6.75	17/64	102	156	11.11	7/16	128	195
3.57	9/64	73	112	6.80		102	156	11.20		128	195
3.60		73	112	6.90		102	156	11.50		128	195
3.70		73	112	7.00		102	156	11.51	29/64	128	195
3.80		78	119	7.10		102	156	11.80		128	195
3.90		78	119	7.14	9/32	102	156	11.91	15/32	134	205
3.97	5/32	78	119	7.20		102	156	12.00		134	205
4.00		78	119	7.30		102	156	12.20		134	205

IS: 5102/DIN: 340/
BS: 328/I.S.O.

SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)	
MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL
12.70	1/2	134	205	19.05	3/4	166	254	25.50		190	290
12.80		134	205	19.25		166	254	25.75		190	290
13.00		134	205	19.45	49/64	166	254	25.80	1.1/64	190	290
13.10	33/64	134	205	19.50		166	254	26.00		190	290
13.20		134	205	19.75	25/32	166	254	26.19	1.1/32	190	290
13.49	17/32	140	214	19.84		166	254	26.25		190	290
13.50		140	214	20.00		166	254	26.50		190	290
13.80		140	214	20.24	51/64	171	261	26.59	1.3/64	195	298
13.89	35/64	140	214	20.25		171	261	26.75		195	298
14.00		140	214	20.50		171	261	26.99	1.1/16	195	298
14.25		144	220	20.64	13/16	171	261	27.00		195	298
14.29	9/16	144	220	20.75		171	261	27.252		195	298
14.50		144	220	21.00		171	261	7.38	1.5/64	195	298
14.68	37/64	144	220	21.03	53/64	171	261	27.50		195	298
13.75		144	220	21.25		176	268	27.75		195	298
15.00		144	220	21.43	27/32	176	268	27.78	1.3/32	195	298
15.08	19/32	149	227	21.50		176	268	28.00		195	298
15.25		149	227	21.75		176	268	28.18	1.7/64	201	307
15.50		149	227	21.83	55/64	176	268	28.25		201	307
15.75		149	227	22.00		176	268	28.50		201	307
15.87	5/8	149	227	22.22	7/8	176	268	28.57	1.1/8	201	307
16.00		149	227	22.25		176	268	28.75		201	307
16.25		154	235	22.50		180	275	28.97	1.9/64	201	307
16.27	41/65	154	235	22.62	57/64	180	275	29.00		201	307
16.50		154	235	22.75		180	275	29.25		201	307
16.67	21/32	154	235	23.00		180	275	29.37	1.5/32	201	307
16.75		154	235	23.02	29/32	180	275	29.50		201	307
17.00		154	235	23.25		180	275	29.75		201	307
17.07	43/64	158	241	23.42	59/64	180	275	29.77	1.11/64	201	307
17.25		158	241	23.50		180	275	30.00		201	307
17.46	11/16	158	241	23.75		185	282	30.16	1.3/16	207	316
17.50		158	241	23.81	15/16	185	282	30.25		207	316
17.75		158	241	24.00		185	282	30.50		207	316
17.86	45/64	158	241	24.21	61/64	185	282	30.56	1.13/64	207	316
18.00		158	241	24.25		185	282	30.75		207	316
18.25		162	247	24.50		185	282	30.96	1.7/32	207	316
18.26	23/32	162	247	24.61	31/32	185	282	31.00		207	316
18.50		162	247	24.75		185	282	31.25		207	316

Standard straight drill with increased flute length for drilling deep and inaccessible holes or for use in conjunction with drill bushings.



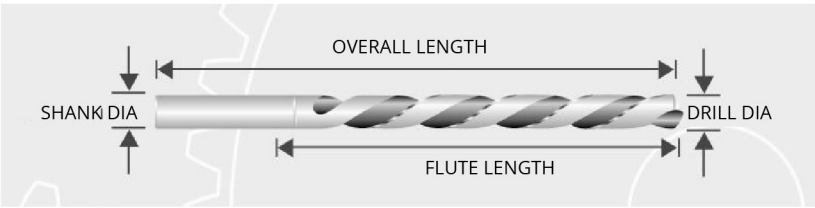
Extra Long Series Drills

SIZE		OVERALL LENGTH IN MM									
MM	INCH										
0.50		50									
0.60		50									
0.70	1/32	50									
0.80		50									
0.90		50									
1.00			100		150						
1.10			100		150						
1.20	3/64		100		150						
1.30			100		150						
1.40			100		150						
1.50			100		150						
1.60	1/16		100	125	150						
1.70			100	125	150						
1.80			100	125	150						
1.90			100	125	150						
2.00	5/64		100	125	150						
2.10			100	125	150						
2.20			100	125	150						
2.30			100	125	150						
2.40	3/32			125	150						
2.50				125	150						
2.60				125	150						
2.70				125	150						
2.80	7/64			125	150						
2.90				150	175	200	225	250			
3.00					150	175	200	225	250	275	300
3.17	1/8				150	175	200	225	250	275	300

IS: 7823/DIN: 1869
/BS: 328/I.S.O.

SIZE		OVERALL LENGTH IN MM										
MM	INCH											
4.00		150	175	200	225	250	275	300	325	350	375	400
4.50	11/64	150	175	200	225	250	275	300	325	350	375	400
4.76	3/16	150	175	200	225	250	275	300	325	350	375	400
5.00		150	175	200	225	250	275	300	325	350	375	400
5.50	13/64	150	175	200	225	250	275	300	325	350	375	400
5.56	7/32	150	175	200	225	250	275	300	325	350	375	400
6.00	15/64			200	225	250	275	300	325	350	375	400
6.35	1/4			200	225	250	275	300	325	350	375	400
6.50				200	225	250	275	300	325	350	375	400
7.00	17/64			200	225	250	275	300	325	350	375	400
7.14	9/32			200	225	250	275	300	325	350	375	400
7.50	19/64			200	225	250	275	300	325	350	375	400
7.94	5/16			200	225	250	275	300	325	350	375	400
8.00				200	225	250	275	300	325	350	375	400
8.50	21/64			200	225	250	275	300	325	350	375	400
8.73	11/32			200	225	250	275	300	325	350	375	400
9.00				200	225	250	275	300	325	350	375	400
9.50	23/64			200	225	250	275	300	325	350	375	400
9.52	3/8			200	225	250	275	300	325	350	375	400
10.00	25/64			200	225	250	275	300	325	350	375	400
10.32	13/32			200	225	250	275	300	325	350	375	400
10.50				200	225	250	275	300	325	350	375	400
11.00	27/64					250	275	300	325	350	375	400
11.11	7/16					250	275	300	325	350	375	400
11.50	29/64					250	275	300	325	350	375	400
11.91	15/32					250	275	300	325	350	375	400
12.00						250	275	300	325	350	375	400

Straight shank drill with extra long flute for drilling extremely deep holes.



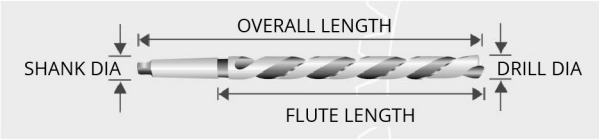
Standard Drills

SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)	
MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL
				11.11	7/16	94	175	19.25		140	238
3.00		33	114	11.20		94	175	19.45	49/64	140	238
3.17	1/8	36	117	11.50		94	175	19.50		140	238
3.20		36	117	11.51	29/64	94	175	19.75		140	238
3.50		39	120	11.80		94	175	19.84	25/32	140	238
3.57	9/64	39	120	11.91	15/32	101	182	20.00		140	238
3.80		43	124	12.00		101	182	20.24	51/64	145	243
3.97	5/32	43	124	12.20		101	182	20.25		145	243
4.00		43	124	12.30	31/64	101	182	20.50		145	243
4.20		43	124	12.50		101	182	20.64	13/16	145	243
4.37	11/64	47	128	12.70	1/2	101	182	20.75		145	243
4.50		47	128	12.80		101	182	21.00		145	243
4.76	3/16	52	133	13.00		101	182	21.03	53/64	145	243
4.80		52	133	13.10	33/64	101	182	21.25		150	248
5.00		52	133	13.20		101	182	21.43	27/32	150	248
5.16	13/64	52	133	13.49	17/32	108	189	21.50		150	248
5.20		52	133	13.50		108	189	21.75		150	248
5.50		57	138	13.80		108	189	21.83	55/64	150	248
5.56	7/32	57	138	13.89	35/64	108	189	22.00		150	248
5.80		57	138	14.00		108	189	22.22	7/8	150	248
5.95	15/64	57	138					22.25		150	248
6.00		57	138	14.25		114	212	22.50		155	253
6.20		63	144	14.29	9/16	114	212	22.62	57/64	155	253
6.35	1/4	63	144	14.50		114	212	22.75		155	253
6.50		63	144	14.68	37/64	114	212	23.00		155	253
6.75	17/64	69	150	14.75		114	212	23.01	29/32	155	253
6.80		69	150	15.00		114	212				
7.00		69	150	15.08	19/32	120	218	23.25		155	276
7.14	9/32	69	150	15.25		120	218	23.42	59/64	155	276
7.20		69	150	15.48	39/64	120	218	23.50		155	276
7.50		69	150	15.50		120	218	23.75		160	281
7.54	19/64	75	156	15.75		120	218	23.81	15/16	160	281
7.80		75	156	15.87	5/8	120	218	24.00		160	281
7.94	5/16	75	156	16.00		120	218	24.21	61/64	160	281
8.00		75	156	16.25		125	223	24.25		160	281
8.20		75	156	16.27	41/64	125	223	24.50		160	281
8.33	21/64	75	156	16.50		125	223	24.61	31/32	160	281
8.50		75	156	16.67	21/32	125	223	24.75		160	281
8.73	11/32	81	162	16.75		125	223	25.00	63/64	160	281
8.80		81	162	17.00		125	223	25.25		165	286
9.00		81	162	17.07	43/64	130	228	25.40	1	165	286
9.13	23/64	81	162	17.25		130	228	25.50		165	286
9.20		81	162	17.46	11/16	130	228	25.75		165	286
9.50		81	162	17.50		130	228	25.80	1.1/64	165	286
9.52	3/8	87	168	17.75		130	228	26.00		165	286
9.80		87	168	17.86	45/64	130	228	26.19	1.1/32	165	286
9.92	25/64	87	168	18.00		130	228	26.25		165	286
10.00		87	168	18.25		135	233	26.50		165	286
10.20		87	168	18.26	23/32	135	233	26.59	1.3/64	170	291
10.32	13/32	87	168	18.50		135	233	26.75		170	291
10.50		87	168	18.65	47/64	135	233	26.99	1.1/16	170	291

IS: 5103/DIN: 345
/BS: 328/I.S.O.

SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)	
MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL
27.50		170	291	37.70		195	344	49.61	1.61/64	220	369
27.75		170	291	37.70	1.31/64	200	349	50.00		220	369
27.78	1.3/32	170	291	38.00			349	50.01	1.31/32	225	374
28.00		170	291	38.10	1.1/2	200	349	50.40	1.63/64	225	374
28.18	1.7/64	175	296	38.50	1.33/64	200	349	50.50		225	374
28.25		175	296	38.89	1.17/32	200	349	50.80	2	225	374
28.50		175	296	39.00		200	349				
28.57	1.1/8	175	296	39.29	1.35/64	200	349	51.00		225	412
28.75		175	296	39.50		200	349	51.50		225	412
28.97	1.9/64	175	296	39.69	1.9/16	200	349	51.59	2.1/32	225	412
29.00		175	296	40.00		200	349	52.00		225	412
29.25		175	296	40.08	1.37/64	205	354	52.39	2.1/16	225	412
29.37	1.5/32	175	296	40.48	1.19/32	205	354	52.50		225	412
29.50		175	296	40.50		205	354	53.00		225	412
29.75		175	296	40.88	1.39/64	205	354	53.18	2.3/32	230	417
29.77	1.11/64	175	296	41.00		205	354	53.50		230	417
30.00		180	301	41.27	1.5/8	205	354	53.97	2.1/8	230	417
30.16	1.3/16	180	301	41.50		205	354	54.00		230	417
30.25		180	301	41.67	1.41/64	205	354	54.50		230	417
30.50		180	301	42.00		205	354	54.77	2.5/32	230	417
30.56	1.13/64	180	301	42.07	1.21/32	205	354	55.00		230	417
30.75		180	301	42.47	1.43/64	205	354	55.50		230	417
30.96	1.7/32	180	301	42.50		205	354	55.56	2.3/16	230	417
31.00		180	301	42.86	1.11/16	210	359	56.00		230	417
31.25		180	301	43.00		210	359	56/36	2.7/32	230	417
31.35	1.15/64	180	301	43.26	1.45/64	210	359	56.50		230	417
31.50		180	301	43.50		210	359	57.00		235	422
31.75	1.1/4	185	306	43.66	1.23/32	210	359	57.15	2.1/4	235	422
				44.00		210	359	57.50		235	422
32.00		185	334	44.05	1.47/64	210	359	57.94	2.9/32	235	422
32.15	1.17/64	185	334	44.45	1.3/4	210	359	58.00		235	422
32.50		185	334	44.50		210	359	58.50		235	422
32.54	1.9/32	185	334	44.85	1.49/64	210	359	58.74	2.5/16	235	422
32.94	1.19/64	185	334	45.00		210	359	59.00		235	422
33.00		185	334	45.24	1.25/32	215	364	59.50		235	422
33.34	1.5/16	185	334	45.50		215	364	59.53	2.11/32	235	422
33.50		185	334	45.64	1.51/64	215	364	60.00		235	422
33.73	1.21/64	190	339	46.00		215	364	60.32	2.3/8	240	427
34.00		190	339	46.04	1.13/16	215	364	60.50		240	427
34.13	1.11/32	190	339	46.43	1.53/64	215	364	61.00		240	427
34.50		190	339	46.50		215	364	61.12	2.13/32	240	427
34.53	1.23/64	190	339	46.83	1.27/32	215	364	61.50		240	427
34.92	1.3/8	190	339	47.00		215	364	61.91	2.7/16	240	427
35.00		190	339	47.23	1.55/64	215	364	62.00		240	427
35.32	1.25/64	190	339	47.50		215	364	62.50		240	427
35.50		190	339	47.62	1.7/8	220	369	61.71	2.15/32	240	427
35.72	1.13/32	195	344	48.00		220	369	63.00		240	427
36.00		195	344	48.02	1.57/64	220	369	63.50	2.1/2	245	432
36.12	1.27/64	195	344	48.42	1.29/32	220	369	64.00		245	432
36.50		195	344	48.50		220	369	64.29	2.17/32	245	432
36.51	1.7/16	195	344	48.82	1.59/64	220	369	65.00		245	432

Standard taper shank drill for general purpose application on Steel and Cast steel, Grey cast iron, German silver steel, Graphite, etc.



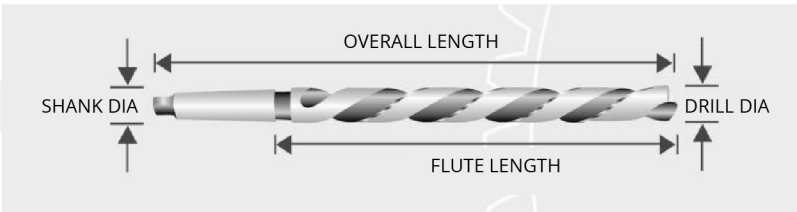
Long Series Drills

SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)	
MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL
				10.72	27/64	125	206	16.27	41/64	159	257
5.00		74	155	10.80		125	206	16.50		159	257
5.16	13/64	74	155	11.00		125	206	16.67	21/32	159	257
5.20		74	155	11.11	7/16	125	206	16.75		159	257
5.50		80	161	11.20		125	206	17.00		159	257
5.56	7/32	80	161	11.50		125	206	17.07	43/64	165	263
5.80		80	161	11.51	29/64	125	206	17.25		165	263
5.95	15/64	80	161	11.80		125	206	17.46	11/16	165	263
6.00		80	161	11.91	15/32	134	215	17.50		165	263
6.20		86	167	12.00		134	215	17.75		165	263
6.35	1/4	86	167	12.20		134	215	17.86	45/64	165	263
6.50		86	167	12.30	31/64	134	215	18.00		165	263
6.75	17/64	93	174	12.50		134	215	18.25		171	269
6.80		93	174	12.70	1/2	134	215	18.26	23/32	171	269
7.00		93	174	12.80		134	215	18.50		171	269
7.14	9/32	93	174	13.00		134	215	18.65	47/64	171	269
7.20		93	174	13.10	33/64	134	215	18.75		171	269
7.50		93	174	13.20		134	215	19.00		171	269
7.54	19/64	100	181	13.49	17/32	142	223	19.05	3/4	177	275
7.80		100	181	13.50		142	223	19.25		177	275
7.94	5/16	100	181	13.80		142	223	19.45	49/64	177	275
8.00		100	181	13.89	35/64	142	223	19.50		177	275
8.20		100	181	14.00		142	223	19.75		177	275
8.33	21/64	100	181					19.84	25/32	177	275
8.50		100	181	14.25		147	245	20.00		177	275
8.73	11/32	107	188	14.29	9/16	147	245	20.24	51/64	184	282
8.80		107	188	14.50		147	245	20.25		184	282
9.00		107	188	14.68	37/64	147	245	20.50		184	282
9.13	23/64	107	188	14.75		147	245	20.64	13/16	184	282
9.20		107	188	15.00		147	245	20.75		184	282
9.50		107	188	15.08	19/32	153	251	21.00		184	282
9.52	3/8	116	197	15.25		153	251	21.03	53/64	184	282
9.80		116	197	15.48	39/64	153	251	21.25		191	289
9.92	25/64	116	197	15.50		153	251	21.43	27/32	191	289
10.00		116	197	15.75		153	251	21.50		191	289
10.20		116	197	15.87	5/8	153	251	21.75		191	289

IS: 8305-1976/DIN: 341

SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)		SIZE-DIAMETER		LENGTH (MM)	
MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL	MM	INCH	FLUTE	OVERALL
22.22	7/8	191	289	28.57	1.1/8	230	351	38.10	1.1/2	277	426
22.25		191	289	28.75		230	351	38.50		277	426
22.50	13/64	198	296	29.00		230	351	38.89	1.17/32	277	426
22.62	57/64	198	296	29.25		230	351	39.00		277	426
22.75		198	296	29.37	1.5/32	230	351	39.50		277	426
23.00		198	296	29.50		230	351	39.69	1.9/16	277	426
23.02	29/32	198	296	29.75		230	351	40.00		277	426
				30.00		230	351	40.48	1.19/32	287	436
23.25		198	319	30.16	1.3/16	239	360	40.50		287	436
23.42	59/64	198	319	30.25		239	360	41.00		287	436
23.50		198	319	30.50		239	360	41.27	1.5/8	287	436
23.75		206	327	30.75		239	360	41.50		287	436
23.81	15/16	206	327	30.98	1.7/32	239	360	42.00		287	436
24.00		206	327	31.00		239	360	42.07	1.21/32	287	436
24.21	61/64	206	327	31.25		239	360	42.50		287	436
24.25		206	327	31.50		239	360	42.86	1.11/16	298	447
24.50		206	327	31.75	1.1/4	248	369	43.00		298	447
24.61	31/32	206	327					43.50		298	447
24.75		206	327	32.00		248	397	43.66	1.23/32	298	447
25.00	63/64	206	327	32.50		248	397	44.00		298	447
25.25		214	335	32.54	1.9/32	248	397	44.45	1.3/4	298	447
25.40		214	335	33.00		248	397	44.50		298	459
25.50		214	335	33.34	1.5/16	248	397	45.00		298	459
25.75		214	335	33.50		248	397	45.24	1.25/32	310	459
26.00		214	335	34.00		257	406	45.50		310	459
26.19	1.1/32	214	335	34.13	1.11/32	257	406	46.00		310	459
26.25		214	335	34.50		257	406	46.04	1.13/16	310	459
26.50		214	335	34.92	1.3/8	257	406	46.50		310	459
26.75		222	343	35.00		257	406	46.83	1.27/32	310	459
26.99	1.1/16	222	343	35.50		257	406	47.00		310	459
27.00		222	343	35.72	1.13/32	267	416	47.50		310	459
27.25		222	343	36.00		267	416	47.62	1.7/8	321	470
27.50		222	343	36.50		267	416	48.00		321	470
27.75		222	343	36.51	1.7/16	267	416	48.42	1.29/32	321	470
27.78	1.3/32	222	343	37.00		267	416	48.50		321	470
28.00		222	343	37.31	1.15/32	267	416	49.00		321	470

Standard taper shank drill with long flute for drilling extremely deep holes.



Long Series Drills

SIZE		OVERALL LENGTH IN MM													
MM	INCH														
3.00	1/8	200	225	250	275	300									
3.50		200	225	250	275	300									
4.00	5/32	200	225	250	275	300	315								
4.50		200	225	250	275	300	315	325							
5.00	3/16	200	225	250	275	300	315	325							
5.50		200	225	250	275	300	315	325							
6.00		200	225	250	275	300	315	325							
6.35	1/4	200	225	250	275	300	315	325							
6.50		200	225	250	275	300	315	325							
7.00		200	225	250	275	300	315	325							
7.50		200	225	250	275	300	315	325							
7.94	5/16	200	225	250	275	300	315	325							
8.00		200	225	250	275	300	315	325							
8.50		200	225	250	275	300	315	325							
9.00		200	225	250	275	300	315	325							
9.50		200	225	250	275	300	315	325							
9.52	3/8	200	225	250	275	300	315	325							
10.00		200	225	250	275	300	315	325	350	375	400				
10.50		200	225	250	275	300	315	325	350	375	400				
11.00		200	225	250	275	300	315	325	350	375	400				
11.11	7/16	200	225	250	275	300	315	325	350	375	400				
11.50		200	225	250	275	300	315	325	350	375	400				
12.00			225	250	275	300	315	325	350	375	400				
12.50			225	250	275	300	315	325	350	375	400				
12.70	1/2		225	250	275	300	315	325	350	375	400				
13.00				250	275	300	315	325	350	375	400				
13.50				250	275	300	315	325	350	375	400				
14.00				250	275	300	315	325	350	375	400				
14.29	9/16			250	275	V300	315	325	350	375	400	425	450	475	500
14.50				250	275	300	315	325	350	375	400	425	450	475	500
15.00				250	275	300	315	325	350	375	400	425	450	475	500
15.50				250	275	300	315	325	350	375	400	425	450	475	500
15.87	5/8			250	275	300	315	325	350	375	400	425	450	475	500
16.00				250	275	300	315	325	350	375	400	425	450	475	500
16.50				250	275	300	315	325	350	375	400	425	450	475	500
17.00				250	275	300	315	325	350	375	400	425	450	475	500
17.45	11/16					300	315	325	350	375	400	425	450	475	500
17.50						300	315	325	350	375	400	425	450	475	500
18.00						300	315	325	350	375	400	425	450	475	500
18.50						300	315	325	350	375	400	425	450	475	500
19.00						300	315	325	350	375	400	425	450	475	500
19.05	3/4					300	315	325	350	375	400	425	450	475	500
19.50						300	315	325	350	375	400	425	450	475	500
20.00						300	315	325	350	375	400	425	450	475	500
20.50						300	315	325	350	375	400	425	450	475	500
20.64	13/46					300	315	325	350	375	400	425	450	475	500

IS: 8305-1976/DIN: 341

Extra Long Series Drills

SIZE		OVERALL LENGTH IN MM										
MM	INCH											
22.50		300	315	325	350	375	400	425	450	475	500	
23.00		300	315	325	350	375	400	425	450	475	500	
23.50		300		325	350	375	400	425	450	475	500	
23.81	15/16	300		325	350	375	400	425	450	475	500	
24.00		300		325	350	375	400	425	450	475	500	
24.50		300		325	350	375	400	425	450	475	500	
25.00				325	350	375	400	425	450	475	500	
25.40	1				350	375	400	425	450	475	500	
25.50					350	375	400	425	450	475	500	
26.00					350	375	400	425	450	475	500	
26.50					350	375	400	425	450	475	500	
26.99	1.1/16				350	375	400	425	450	475	500	
27.00					350	375	400	425	450	475	500	
27.50					350	375	400	425	450	475	500	
28.00					350	375	400	425	450	475	500	
28.50					350	375	400	425	450	475	500	
28.57	1.1/8				350	375	400	425	450	475	500	
29.00					350	375	400	425	450	475	500	
29.50					350	375	400	425	450	475	500	
30.00					350	375	400	425	450	475	500	
30.16	1.3/16				350	375	400	425	450	475	500	
31.00					350	375	400	425	450	475	500	
31.75	1.1/4				350	375	400	425	450	475	500	
32.00					350	375	400	425	450	475	500	
33.00							400	425	450	475	500	525
33.34	1.5/18						400	425	450	475	500	525
34.00							400	425	450	475	500	525
34.92	1.3/8						400	425	450	475	500	525
35.00							400	425	450	475	500	525
36.00							400	425	450	475	500	525
36.51	1.1/16						400	425	450	475	500	525
37.00							400	425	450	475	500	525
38.00							400	425	450	475	500	525
38.10	1.1/2						400	425	450	475	500	525
39.00							400	425	450	475	500	525
40.00							400	425	450	475	500	525
41.00											500	
41.27	1.5/8										500	
42.00											500	
43.00											500	
44.00											500	
44.45	1.3/4										500	
45.00											500	
45.50	1.13/16										500	
46.00											500	
47.00											500	

DIN: 7822/BS: 328

HSS Centre Drills

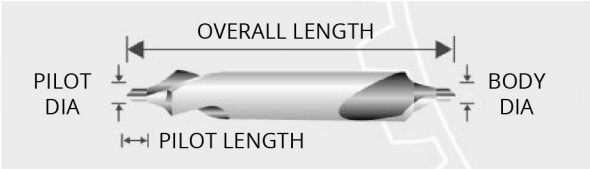
HSS Centre drills are manufactured in two types. Type A - for centre holes without protecting chamfers. Type B - for centre holes with protecting chamfers.

TYPE 'A' AS PER IS-6708/1977					
PILOT DIA	MODY DIA	OVERALL LENGTH MM		PILOT LENGTH MM	
MM K12	MM H9	MAX.	MIN.	MAX.	MIN.
1.00	3.15	33.5	29.5	1.9	1.3
1.25	3.15	33.5	29.5	2.2	1.6
1.60	4.00	27.4	33.5	2.8	2.0
2.00	5.00	43	38	3.3	2.5
2.50	6.30	47	43	4.1	3.1
3.15	8.00	52	48	4.9	3.9
4.00	10.00	59	53	6.2	5.0

TYPE 'B' AS PER IS-6709/1977					
1.60	6.30	47	43	2.8	2.0
2.00	8.00	52	48	3.3	2.5
2.50	10.00	59	53	4.1	3.1
3.15	11.20	63	57	4.9	3.9
4.00	14.00	70	64	6.2	5.0

AS PER B.S. 328 (PART 2)						
SIZE PILOT	DIA	BODY DIA	PILOT LENGTH mmOAL		TOLERANCE ON	
	INCH	INCH	MAX.	MIN.	INCH.	OVERALL LENGTH
BS 1	3/64	1/8	5/64	1/16	1.1/2	± 1/32
BS 2	1/16	3/16	3/32	5/64	1.3/4	± 1/33
BS 3	3/32	1/4	5/32	1/8	2	± 1/16
BS 4	1/8	5/16	3/16	5/32	2.1/4	± 1/16
BS 5	3/16	7/16	9/32	1/4	2.1/2	± 3/32

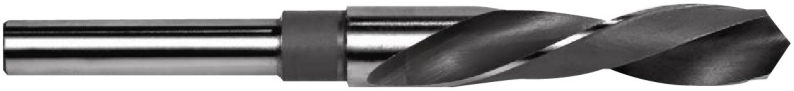
DIN: 333/BS: 328



Silver & Deming Drills

These drills have reduced shank and are used for drilling holes larger than the capacity of a %4” or 3/8" or 42” drill chuck. Deming These drills are used light to medium duty drilling applications.

SIZE-DIAMETER	LENGTH IN INCH	
INCH	FLUTE	OVERALL
1/2	3	6



Double Ended Drills

These drills have flutes and split points on both ends and have a solid centre shank for chucking. They will drill double number of holes than a single end drill for only a fraction more in cost. They reduce change over time, inventory and overall cost.

SIZE-DIAMETER	LENGTH IN INCH	
INCH	FLUTE	OVERALL
3.3	15	50
4.1	17	56
5	17	63

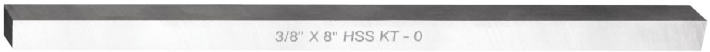
Square Tool Bit Blanks

They are manufactured from high quality High Speed Steel Bars. They undergo Cryogenic heat treatment process to allow full conversion into marten site and attain stress free structure. This ensures consistently high wear resistance for superior performance. They are available in KT-O, and KT-5 grades in square sections.

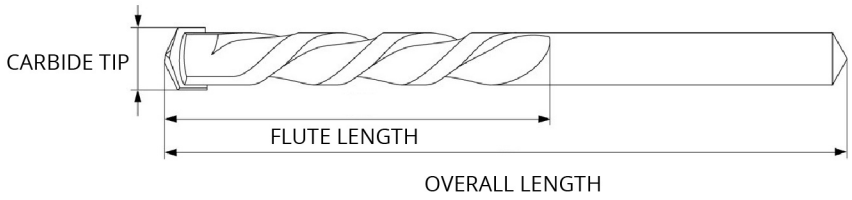
KT-0= (M2)
0% COBALT

KT-5= (M35)
5% COBALT

SQ. SIZE INCH	SQ. SIZE MM	SQ. SIZE INCH	SQ. SIZE MM
3/16 X 3	5 X 75	1/2 X 4	12 X 100
3/16 X 4	5 X 100	1/2 X 6	12 X 150
3/16 X 6	5 X 150	1/2 X 8	12 X 200
1/4 X 3	6 X 75	5/8 X 4	16 X 100
1/4 X 4	6 X 100	5/8 X 6	16 X 150
1/4 X 6	6 X 150	5/8 X 8	16 X 200
5/16 X 3	8 X 75	3/4 X 4	-
5/16 X 4	8 X 100	3/4 X 6	-
5/16 X 6	8 X 150	3/4 X 8	-
3/8 X 3	10 X 75	-	20 X 100
3/8 X 4	10 X 100	-	20 X 150
3/8 X 6	10 X 150	-	20 X 200
3/8 X 8	10 X 200	1 X 6	25 X 150
1/2 X 3	12 X 75	1 X 8	25 X 200



Normal



JK Masonry Drills is meant for use on bricks, concrete walls & other general applications.

SIZE * *	SIZE * *	FLUTE	OVERALL
INCH	MM	LENGTH	LENGTH
1/8	3.00	33	67
5/32	4.00	40	78
3/16	5.00	45	88
7/32	5.50	50	88
15/64	6.00	54	102
1/4	6.50	54	102
9/32	7.00	55	108
5/16	8.00	64	118
11/32	9.00	78	135
3/8	10.00	78	135
7/16	11.00	82	148
15/32	12.00	85	152

SDS PLUS
HAMMER
DRILL BITS

SDS PLUS HAMMER DRILL BITS

JK CODE	DIAMETER X WORKING LENGTH X TOTAL LENGTH (MM)	STD. PKG. (PC.)
9060000	5 X 50 X 110	10
9060001	5 X 100 X 160	10
9060002	6 X 50 X 110	10
9060003	6 X 100 X 160	10
9060047	6.5 X 50 X 110	10
9060048	6.5 X 100 X 160	10
9060004	8 X 50 X 110	10
9060005	8 X 100 X 160	10
9060006	10 X 100 X 160	1
9060007	10 X 150 X 210	1
9060008	10 X 200 X 260	1
9060009	12 X 100 X 160	1
9060010	12 X 150 X 210	1
9060011	12 X 200 X 260	1
9060012	12 X 240 X 310	1
9060013	13 X 100 X 160	1
9060014	13 X 150 X 210	1
9060015	13 X 200 X 260	1
9060016	13 X 240 X 310	1
9060017	14 X 100 X 160	1
9060018	14 X 150 X 210	1
9060019	14 X 200 X 260	1
9060020	14 X 240 X 310	1
9060021	16 X 100 X 160	1
9060022	16 X 150 X 210	1

JK CODE	DIAMETER X WORKING LENGTH X TOTAL LENGTH (MM)	STD. PKG. (PC.)
9060023	16 X 200 X 260	1
9060024	16 X 240 X 310	1
9060025	18 X 100 X 160	1
9060026	18 X 150 X 210	1
9060027	18 X 200 X 260	1
9060028	18 X 240 X 310	1
9060029	20 X 200 X 260	1
9060030	20 X 240 X 310	1
9060032	20 X 300 X 360	1
9060033	20 X 240 X 400	1
9060031	20 X 400 X 460	1
9060034	22 X 240 X 310	1
9060036	22 X 300 X 360	1
9060037	22 X 340 X 400	1
9060035	22 X 400 X 460	1
9060038	24 X 240 X 310	1
9060040	24 X 300 X 360	1
9060041	24 X 340 X 400	1
9060039	24 X 400 X 460	1
9060042	25 X 200 X 260	1
9060043	25 X 240 X 310	1
9060045	25 X 300 X 360	1
9060046	25 X 340 X 400	1
9060044	25 X 400 X 460	1

Useful Tips for Drilling

- Use the shortest drill possible for the specific application Longer drills are:

1. More costly
2. Break easier
3. Drill bellmouthed holes

- Avoid the tendency to over speed and under feed. Excessive speed causes:

1. Premature outer comer drill wear
2. Material work hardening
3. Long, stringy chips
4. Reduced drill life and
5. Increased cost per hole

- Optimising feed rate:

1. Help break up chips
2. Reduces premature outer corner drill wear
3. Reduces material work hardening
4. Extends drill life and
5. Reduces cost per hole

- Use split point drills for drilling alloy materials; benefits include:

1. Start at the point of contact (self-centering)
2. Drill with less torque and thrust and
3. Break up chips

- A hole of three drill diameters or deeper should be considered a deep hole. Therefore, you should peck drill just enough to prevent chips from packing in the flutes. Because chip clogging is the major cause of drill breakage.

- When drilling harder materials (i.e. above HRC 35):

1. Reduce speeds and feeds to prevent points from burning and drilling breakage.
2. Use cobalt drills as their higher hardness and heavy-duty

SPEED AND FEED REDUCTION (BASED UPON HOLE DEPTH)

HOLES DEPTH TO DIAMETER RATIO (TIMES DRILL DIAMETER)	SPEED REDUCTION	FEED REDUCTION
3	10%	10%
4	20%	10%
5	30%	20%
6	35-40%	20%

- Use steam tempered. The black oxide surface laser holds the coolants and lubricates to the surface of the drill retarding material build-up. This treatment also improves toughness.

- You should decrease speeds and use coolant whenever possible, this will keep the drill cooler. Chip welding and breakage are also reduced. Coolant helps the drill to last and will give the drill a better chance of operating without failing.

- Chips should be short and broken up.

- Keep drills sharp! Sharp drills perform better and last longer. Sharp drills also increase productivity and have a reduced tendency to break.

- Chuck drill on shank area only, not in

Trouble Shooting and Remedies

PROBLEMS	REASONS	REMEDIES
1. Oversize hole	1. Unequal lip angles 2. Unequal lip lengths	Regrind the drill point to correct lip angle with proper relief, maintaining lip lengths equal
2. Buckling of the drill	Drill deflects axially	Use correct guide bush
3. Drill chattering	1. Hard, tough work piece 2. Torsional deflection of the drill	Increase torsional stiffness by replacing thicker web drill. Reduce drill length and shorten flute length.
4. Drill breaking	1. Fixture not rigid 2. Web thickness more 3. Speed & feed not proper	1. Use rigid fixture 2. Web thinning to be implemented 3. Use proper speeds & feeds according to work material
5. Drill breaking in deep hole drilling	1. Chips blocking in flutes 2. Back taper no uniform 3. Drill finished on CD	1. Use wood pecking system 2. Before using check uniform back taper and concentricity
6. Drill rubbing at relief	1. No proper relief on point 2. No uniform back taper	1. Regrind point with proper point geometry 2. Check uniform back taper, at no point negative back taper should occur on drill dia
7. Excessive heat generation while drilling	1. Coolant insufficient 2. Proper coolant not used	1. Use proper coolant flow 2. Use proper coolant

OTHER RANGE

STEEL FILES

HAND TOOLS

POWER TOOLS

POWER TOOLS ACCESSORIES

CONTRIBUTING TO INDUSTRIAL GROWTH FOR THE LAST 4 DECADES

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