

Datasheet

HSS 11/32in Jobber Drill Bit, 125 mm Plain Shank

RS Stock number 434-4398

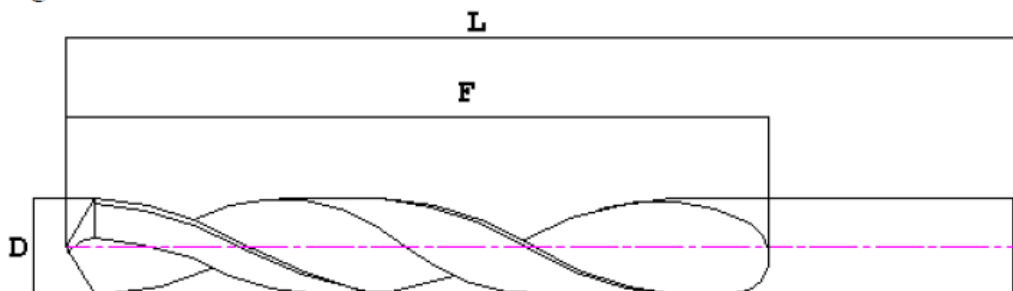


HSS CHECKING PROCEDURES

All HSS drills must be sample checked for the following:

- Diameter
- Overall length
- Flute length
- Flute form
- Cutting angle
- Chisel edge angle
- Hardness / Brittleness
- Straightness

Diameter should be checked using a vernier and **lengths** using a rule against the following data:





SIZE	TOL	L	F	TOL	
	1	-0.05	36	12	+/- 2
	1.5	-0.05	40	18	+/- 2
1/16	1.59	-0.05	43	20	+/- 2
5/64	2	-0.05	49	24	+/- 2
3/32	2.381	-0.05	57	30	+/- 2
	2.5	-0.05	57	30	+/- 2
7/64	2.778	-0.05	61	33	+/- 2
	3	-0.05	61	33	+/- 2
1/8	3.175	-0.05	65	36	+/- 2
	3.3	-0.05	65	36	+/- 2
	3.5	-0.05	70	39	+/- 2
9/64	3.572	-0.05	70	39	+/- 2
5/32	3.969	-0.05	75	43	+/- 2
	4	-0.05	75	43	+/- 2
	4.2	-0.05	75	43	+/- 2
11/64	4.366	-0.05	80	47	+/- 2
	4.5	-0.05	80	47	+/- 2
3/16	4.762	-0.05	86	52	+/- 2
	5	-0.05	86	52	+/- 2
13/64	5.159	-0.05	86	52	+/- 2
	5.5	-0.05	93	57	+/- 2
7/32	5.556	-0.05	93	57	+/- 2
15/64	5.953	-0.05	93	57	+/- 2
	6	-0.05	93	57	+/- 2
1/4	6.35	-0.08	101	63	+/- 3
	6.5	-0.08	101	63	+/- 3
17/64	6.747	-0.08	109	69	+/- 3
	7	-0.08	109	69	+/- 3

SIZE	TOL	L	F	TOL	
9/32	7.144	-0.08	109	69	+/- 3
	7.5	-0.08	109	69	+/- 3
19/64	7.541	-0.08	117	75	+/- 3
5/16	7.938	-0.08	117	75	+/- 3
	8	-0.08	117	75	+/- 3
21/64	8.334	-0.08	117	75	+/- 3
	8.5	-0.08	117	75	+/- 3
11/32	8.731	-0.08	125	81	+/- 3
	9	-0.08	125	81	+/- 3
23/64	9.128	-0.08	125	81	+/- 3
	9.5	-0.08	125	81	+/- 3
3/8	9.525	-0.08	133	87	+/- 3
25/64	9.922	-0.08	133	87	+/- 3
	10	-0.08	133	87	+/- 3
13/32	10.319	-0.08	133	87	+/- 3
	10.5	-0.08	133	87	+/- 3
27/64	10.716	-0.1	142	94	+/- 3
	11	-0.1	142	94	+/- 3
7/16	11.112	-0.1	142	94	+/- 3
	11.5	-0.1	142	94	+/- 3
29/64	11.509	-0.1	142	94	+/- 3
15/32	11.906	-0.1	151	101	+/- 3
	12	-0.1	151	101	+/- 3
31/64	12.303	-0.1	151	101	+/- 3
	12.5	-0.1	151	101	+/- 3
1/2	12.7	-0.1	151	101	+/- 3
	13	-0.1	151	101	+/- 3