

Datasheet

HSS 31/64in Jobber Drill Bit, 151 mm Plain Shank

RS Stock number 434-4483

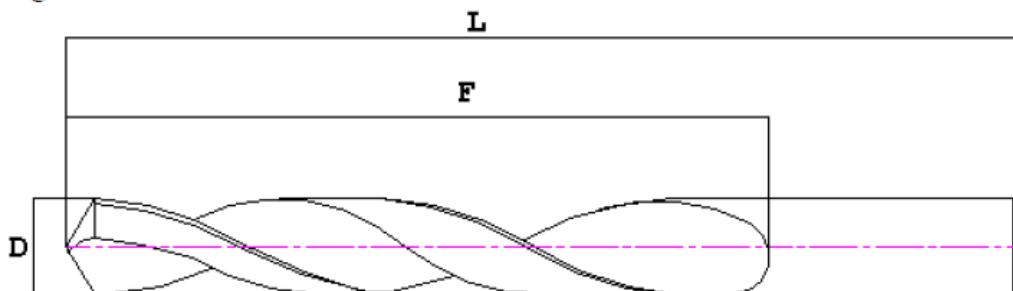


HSS CHECKING PROCEDURES

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

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