

Drilling Data Sheet



01000 HSS Straight Shank DIN338 Jobber Drill

General-purpose drill, to drill steels with tensile strength up to 1.000 N/mm², cast steel, grey cast iron, malleable cast iron, nickel brass and graphite.



Discount Group	00	Surface	Steam
Material	HSS	Shank Type	Straight
Standard	DIN338	Helix Group (DIN1836)	N
Depth of Cut	4.0 x Ø	Cutting Direction	RH
Point Angle	118°	Tolerance	h8
Packing Units	<=8.50mm (21/64") in 10's, >8.50mm - 13.00mm (1/2") in 5's, >13.00mm in 1's.		

Ø mm	Ø Inch	Ø Dec Inch	O/all Length	Flute Length
0.300		0.0118	19.0	3.0
0.350		0.0137	19.0	4.0
0.396	1/64"	0.0156	20.0	5.0
0.400		0.0157	20.0	5.0
0.450		0.0177	20.0	5.0
0.500		0.0196	22.0	6.0
0.550		0.0216	24.0	7.0
0.600		0.0236	24.0	7.0
0.650		0.0255	26.0	8.0
0.700		0.0275	28.0	9.0
0.750		0.0295	28.0	9.0
0.792	1/32"	0.0312	30.0	10.0
0.800		0.0314	30.0	10.0
0.850		0.0334	30.0	10.0
0.900		0.0354	32.0	11.0
0.950		0.0374	32.0	11.0
1.000		0.0393	34.0	12.0
1.050		0.0413	34.0	12.0
1.100		0.0433	36.0	14.0
1.150		0.0452	36.0	14.0
1.189	3/64"	0.0468	38.0	16.0
1.200		0.0472	38.0	16.0
1.250		0.0492	38.0	16.0
1.300		0.0511	38.0	16.0
1.350		0.0531	40.0	18.0
1.400		0.0551	40.0	18.0
1.450		0.0570	40.0	18.0
1.500		0.0590	40.0	18.0
1.550		0.0610	43.0	20.0
1.588	1/16"	0.0625	43.0	20.0
1.600		0.0629	43.0	20.0
1.650		0.0649	43.0	20.0
1.700		0.0669	43.0	20.0
1.750		0.0688	46.0	22.0
1.800		0.0708	46.0	22.0
1.850		0.0728	46.0	22.0

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Ø mm	Ø Inch	Ø Dec Inch	O/all Length	Flute Length
1.900		0.0748	46.0	22.0
1.950		0.0767	49.0	24.0
1.984	5/64"	0.0781	49.0	24.0
2.000		0.0787	49.0	24.0
2.050		0.0807	49.0	24.0
2.100		0.0826	49.0	24.0
2.150		0.0846	53.0	27.0
2.200		0.0866	53.0	27.0
2.250		0.0885	53.0	27.0
2.300		0.0905	53.0	27.0
2.350		0.0925	53.0	27.0
2.380	3/32"	0.0937	57.0	30.0
2.400		0.0944	57.0	30.0
2.450		0.0964	57.0	30.0
2.500		0.0984	57.0	30.0
2.550		0.1003	57.0	30.0
2.600		0.1023	57.0	30.0
2.650		0.1043	57.0	30.0
2.700		0.1062	61.0	33.0
2.750		0.1082	61.0	33.0
2.776	7/64"	0.1093	61.0	33.0
2.800		0.1102	61.0	33.0
2.850		0.1122	61.0	33.0
2.900		0.1141	61.0	33.0
2.950		0.1161	61.0	33.0
3.000		0.1181	61.0	33.0
3.050		0.1200	65.0	36.0
3.100		0.1220	65.0	36.0
3.150		0.1240	65.0	36.0
3.175	1/8"	0.1250	65.0	36.0
3.200		0.1259	65.0	36.0
3.250		0.1279	65.0	36.0
3.300		0.1299	65.0	36.0
3.350		0.1318	65.0	36.0
3.400		0.1338	70.0	39.0
3.450		0.1358	70.0	39.0

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Ø mm	Ø Inch	Ø Dec Inch	O/all Length	Flute Length
3.500		0.1377	70.0	39.0
3.550		0.1397	70.0	39.0
3.571	9/64"	0.1406	70.0	39.0
3.600		0.1417	70.0	39.0
3.650		0.1437	70.0	39.0
3.700		0.1456	70.0	39.0
3.750		0.1476	70.0	39.0
3.800		0.1496	75.0	43.0
3.850		0.1515	75.0	43.0
3.900		0.1535	75.0	43.0
3.950		0.1555	75.0	43.0
3.967	5/32"	0.1562	75.0	43.0
4.000		0.1574	75.0	43.0
4.050		0.1594	75.0	43.0
4.100		0.1614	75.0	43.0
4.150		0.1633	75.0	43.0
4.200		0.1653	75.0	43.0
4.250		0.1673	75.0	43.0
4.300		0.1692	80.0	47.0
4.350		0.1712	80.0	47.0
4.364	11/64"	0.1718	80.0	47.0
4.400		0.1732	80.0	47.0
4.450		0.1751	80.0	47.0
4.500		0.1771	80.0	47.0
4.550		0.1791	80.0	47.0
4.600		0.1811	80.0	47.0
4.650		0.1830	80.0	47.0
4.700		0.1850	80.0	47.0
4.750		0.1870	80.0	47.0
4.763	3/16"	0.1875	86.0	52.0
4.800		0.1889	86.0	52.0
4.850		0.1909	86.0	52.0
4.900		0.1929	86.0	52.0
4.950		0.1948	86.0	52.0
5.000		0.1968	86.0	52.0
5.100		0.2007	86.0	52.0

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Ø mm	Ø Inch	Ø Dec Inch	O/all Length	Flute Length
5.159	13/64"	0.2031	86.0	52.0
5.200		0.2047	86.0	52.0
5.250		0.2066	86.0	52.0
5.300		0.2086	86.0	52.0
5.400		0.2125	93.0	57.0
5.500		0.2165	93.0	57.0
5.555	7/32"	0.2187	93.0	57.0
5.600		0.2204	93.0	57.0
5.700		0.2244	93.0	57.0
5.750		0.2263	93.0	57.0
5.800		0.2283	93.0	57.0
5.900		0.2322	93.0	57.0
5.951	15/64"	0.2343	93.0	57.0
6.000		0.2362	93.0	57.0
6.100		0.2401	101.0	63.0
6.200		0.2440	101.0	63.0
6.250		0.2460	101.0	63.0
6.300		0.2480	101.0	63.0
6.350	1/4"	0.2500	101.0	63.0
6.400		0.2519	101.0	63.0
6.500		0.2559	101.0	63.0
6.600		0.2598	101.0	63.0
6.700		0.2637	101.0	63.0
6.746	17/64"	0.2656	109.0	69.0
6.750		0.2657	109.0	69.0
6.800		0.2677	109.0	69.0
6.900		0.2716	109.0	69.0
7.000		0.2755	109.0	69.0
7.100		0.2795	109.0	69.0
7.142	9/32"	0.2812	109.0	69.0
7.200		0.2834	109.0	69.0
7.250		0.2854	109.0	69.0
7.300		0.2874	109.0	69.0
7.400		0.2913	109.0	69.0
7.500		0.2952	109.0	69.0
7.539	19/64"	0.2968	117.0	75.0

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Ø mm	Ø Inch	Ø Dec Inch	O/all Length	Flute Length
7.600		0.2992	117.0	75.0
7.700		0.3031	117.0	75.0
7.750		0.3051	117.0	75.0
7.800		0.3070	117.0	75.0
7.900		0.3110	117.0	75.0
7.938	5/16"	0.3125	117.0	75.0
8.000		0.3149	117.0	75.0
8.100		0.3188	117.0	75.0
8.200		0.3228	117.0	75.0
8.250		0.3248	117.0	75.0
8.300		0.3267	117.0	75.0
8.334	21/64"	0.3281	117.0	75.0
8.400		0.3307	117.0	75.0
8.500		0.3346	117.0	75.0
8.600		0.3385	125.0	81.0
8.700		0.3425	125.0	81.0
8.730	11/32"	0.3437	125.0	81.0
8.750		0.3444	125.0	81.0
8.800		0.3464	125.0	81.0
8.900		0.3503	125.0	81.0
9.000		0.3543	125.0	81.0
9.100		0.3582	125.0	81.0
9.126	23/64"	0.3593	125.0	81.0
9.200		0.3622	125.0	81.0
9.250		0.3641	125.0	81.0
9.300		0.3661	125.0	81.0
9.400		0.3700	125.0	81.0
9.500		0.3740	125.0	81.0
9.525	3/8"	0.3750	133.0	87.0
9.600		0.3779	133.0	87.0
9.700		0.3818	133.0	87.0
9.750		0.3838	133.0	87.0
9.800		0.3858	133.0	87.0
9.900		0.3897	133.0	87.0
9.921	25/64"	0.3906	133.0	87.0
10.000		0.3937	133.0	87.0

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Ø mm	Ø Inch	Ø Dec Inch	O/all Length	Flute Length
10.100		0.3976	133.0	87.0
10.200		0.4015	133.0	87.0
10.250		0.4035	133.0	87.0
10.300		0.4055	133.0	87.0
10.317	13/32"	0.4062	133.0	87.0
10.400		0.4094	133.0	87.0
10.500		0.4133	133.0	87.0
10.600		0.4173	133.0	87.0
10.700		0.4212	142.0	94.0
10.714	27/64"	0.4218	142.0	94.0
10.750		0.4232	142.0	94.0
10.800		0.4251	142.0	94.0
10.900		0.4291	142.0	94.0
11.000		0.4330	142.0	94.0
11.100		0.4370	142.0	94.0
11.113	7/16"	0.4375	142.0	94.0
11.200		0.4409	142.0	94.0
11.250		0.4429	142.0	94.0
11.300		0.4448	142.0	94.0
11.400		0.4488	142.0	94.0
11.500		0.4527	142.0	94.0
11.509	29/64"	0.4531	142.0	94.0
11.600		0.4566	142.0	94.0
11.700		0.4606	142.0	94.0
11.750		0.4625	142.0	94.0
11.800		0.4645	142.0	94.0
11.900		0.4685	151.0	101.0
11.905	15/32"	0.4687	151.0	101.0
12.000		0.4724	151.0	101.0
12.100		0.4763	151.0	101.0
12.200		0.4803	151.0	101.0
12.250		0.4822	151.0	101.0
12.300		0.4842	151.0	101.0
12.301	31/64"	0.4843	151.0	101.0
12.400		0.4881	151.0	101.0
12.500		0.4921	151.0	101.0

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Ø mm	Ø Inch	Ø Dec Inch	O/all Length	Flute Length
12.600		0.4960	151.0	101.0
12.700		0.5000	151.0	101.0
12.700	1/2"	0.5000	151.0	101.0
12.750		0.5019	151.0	101.0
12.800		0.5039	151.0	101.0
12.900		0.5078	151.0	101.0
13.000		0.5118	151.0	101.0
13.100		0.5157	151.0	101.0
13.200		0.5196	151.0	101.0
13.250		0.5216	160.0	108.0
13.300		0.5236	160.0	108.0
13.400		0.5275	160.0	108.0
13.492	17/32"	0.5312	160.0	108.0
13.500		0.5314	160.0	108.0
13.600		0.5354	160.0	108.0
13.700		0.5393	160.0	108.0
13.750		0.5413	160.0	108.0
13.800		0.5433	160.0	108.0
13.900		0.5472	160.0	108.0
14.000		0.5511	160.0	108.0
14.250		0.5610	169.0	114.0
14.288	9/16"	0.5625	169.0	114.0
14.500		0.5708	169.0	114.0
14.750		0.5807	169.0	114.0
15.000		0.5905	169.0	114.0
15.080	19/32"	0.5937	178.0	120.0
15.250		0.6003	178.0	120.0
15.500		0.6102	178.0	120.0
15.750		0.6200	178.0	120.0
15.875	5/8"	0.6250	178.0	120.0
16.000		0.6299	178.0	120.0
16.500		0.6496	184.0	125.0
16.667	21/32"	0.6562	184.0	125.0
17.000		0.6692	184.0	125.0
17.463	11/16"	0.6875	191.0	130.0
17.500		0.6889	191.0	130.0

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Ø mm	Ø Inch	Ø Dec Inch	O/all Length	Flute Length
18.000		0.7086	191.0	130.0
18.255	23/32"	0.7187	198.0	135.0
18.500		0.7283	198.0	135.0
19.000		0.7480	198.0	135.0
19.050	3/4"	0.7500	205.0	140.0
19.500		0.7677	205.0	140.0
20.000		0.7874	205.0	140.0