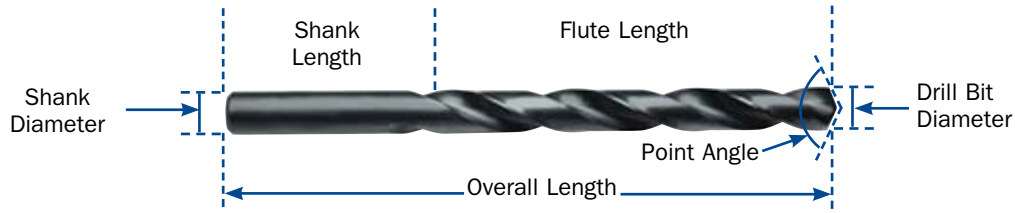


Engineered For Controlled Precision And Speed



Overall Length: The length from the point to the end of the drill

Point Angle: The angle of the cutting edges

Drill Diameter: The cutting diameter of the drill

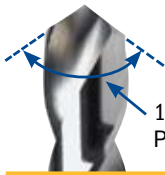
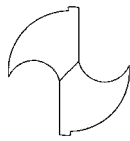
Shank Length: The end of the drill bit that is secured by the drill

Flute Length: The length from the point to the end of the flutes

Tip Geometry

118° Conventional Point

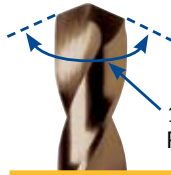
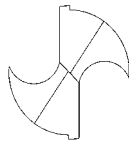
- General Use
- Not self-centering
- For Stationary Drills
- Performs better in softer materials than hard metal



118°
Point Angle

135° Split Point

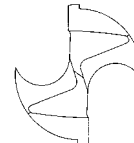
- Self-centering (won't "walk")
- For Portable Drills
- Requires less force than 118°



135°
Point Angle

TURBOMAX® Tip

- Self-centering (won't "walk")
- Precision ground to stay sharp longer and drill faster
- For Portable Drills
- Requires less force than 118°



METAL DRILLING

Drill Bit Section

Material	Point Angle	Black & Gold TURBOMAX®		Heavy-Duty	Titanium Nitride (TiN) Coated	Cobalt	General Purpose
		(135°)	(TURBOMAX®)	(135°)	(135°)	(135°)	(118°)
Wood/Drywall		●	●	●	●	●	●
Sheet Metal		●	●	●	●	●	●
Mild Steel		●	●	●	●	●	●
High Alloy Steels		●	●	●	●	●	●
Stainless Steels		●	●	●	●	●	●
Cast Iron		●	●	●	●	●	●
Aluminum, Brass & Copper		●	●	●	●	●	●
Plastic		●	●	●	●	●	●

Key: ● Recommended ● Acceptable ● Not Recommended

Cutting Speeds - by Working Material

Speeds for High Speed Steel Drills

	SFM*
Aluminum and its Alloys	200 - 300
Brass and Bronze (Ordinary)	150 - 300
Bronze (High Tensile)	70 - 150
Die Castings (Zinc Base)	300 - 400
Iron-Cast (Soft)	100 - 150
Cast (Medium hard)	70 - 100
Hard Chilled	30 - 40
Malleable	80 - 90
Magnesium and its Alloys	250 - 400
Monel Metal or High-Nickel Steel	30 - 50
Plastics or Similar Materials (Bakelite)	100 - 300
Steel - Mild (.2 carbon to .3 carbon)	80 - 110
Steel (.4 carbon to .5 carbon)	70 - 80
Tool (1.2 carbon)	50 - 60
Forgings	40 - 50
Alloy - 300 to 400 Brinell	20 - 30
High Tensile (Heat Treated)	
35 to 40 Rockwell C	30 - 40
40 to 45 Rockwell C	25 - 35
45 to 50 Rockwell C	15 - 25
50 to 55 Rockwell C	7 - 15
Stainless Steel	
Free Machining Grades	30 - 80
Work Hardening Grades	15 - 50
Wood	300 - 400

*Surface Feet per Minute (SFM)

$$RPM = \frac{SFM \times 3.82}{\text{Drill Diameter}}$$

Speeds and Feeds for Deep Hole Drilling

Holes that qualify as "deep-hole drilling" are three or more drill bit diameters deep. When drilling this deep, the speed and feed rate must be adjusted to reduce friction. Friction creates heat, and heat build-up in the drill bit can cause failure and breakage. Lubricants help dissipate heat from the tip of the drill bit, prolonging drill life, and should always be used when deep-hole drilling.

Another technique that should be used when deep-hole drilling is called "pecking". Pecking is the process whereby the user drills a short distance then backs the drill out of the hole before progressing. Pecking lessens the possibility of chips getting lodged in the flute and allows for the reintroduction of lubricant into the hole.

Speed and Feed Reduction (Based upon the hole depth)

Hole Depth to Dia. (times drill dia.)	Speed Reduction	Feed Reduction
3	10%	10%
4	20%	10%
5	30%	20%
6	35 - 40%	20%

Feed Per Drill Revolution

Drill Dia. Range	Light	Medium	Heavy
1/16" to 1/8"	.0005 - .0010	.0010 - .0020	.0020 - .0040
1/8" to 1/4"	.0010 - .0030	.0030 - .0050	.0040 - .0050
1/4" to 3/8"	.0030 - .0050	.0050 - .0070	.0060 - .0100
3/8" to 1/2"	.0040 - .0060	.0050 - .0080	.0080 - .0120
1/2" to 3/4"	.0050 - .0070	.0070 - .0100	.0090 - .0140
3/4" to 1"	.0070 - .0100	.0090 - .0140	.0140 - .0200

See pages 127-128 for Tap & Drill Selection Chart

Titanium Nitride (TiN) Coated HSS Fractional Straight Shank Jobber Length Drill Bits 135° Split Point (Series 639/637)



63724

- Titanium Nitride coated bits last up to six times longer than standard high speed steel drill bits
- Cutting edge stays sharper longer
- Titanium Nitride coating reduces friction
- Repetitive metal drilling with Portable Drills, Stationary Drill Press

Sets:

Metal Index: 63737, 3018003

*Note: 2 bits per Card

Size	Decimal Equiv.	Flute Length	Overall Length	Carded Stock #	Bulk Stock #
1/16"	.0625	7/8"	1-7/8"	63904*	63704
5/64"	.0781	1"	2"	63905*	63705
3/32"	.0938	1-1/8"	2-1/4"	63906*	63706
7/64"	.1094	1-1/2"	2-5/8"	63907*	63707
1/8"	.1250	1-5/8"	2-3/4"	63908*	63708
9/64"	.1406	1-3/4"	2-7/8"	63909	63709
5/32"	.1563	2"	3-1/8"	63910	63710
11/64"	.1719	2-1/8"	3-1/4"	63911	63711
3/16"	.1875	2-5/16"	3-1/2"	63912	63712
13/64"	.1563	2-7/16"	3-5/8"	63913	63713
7/32"	.2188	2-1/2"	3-3/4"	63914	63714
15/64"	.2344	2-5/8"	3-7/8"	63915	63715
1/4"	.2500	2-3/4"	4"	63916	63716
17/64"	.2656	2-7/8"	4-1/8"	-	63717
9/32"	.2812	2-15/16"	4-1/4"	63918	63718
19/64"	.2969	3-1/16"	4-3/8"	-	63719
5/16"	.3125	3-3/16"	4-1/2"	63920	63720
21/64"	.3281	3-5/16"	4-5/8"	-	63721
11/32"	.3438	3-7/16"	4-3/4"	63922	63722
23/64"	.3594	3-1/2"	4-7/8"	-	63723
3/8"	.3750	3-5/8"	5"	63924	63724
25/64"	.3906	3-3/4"	5-1/8"	-	63725
13/32"	.4063	3-7/8"	5-1/4"	63926	63726
27/64"	.4219	3-15/16"	5-3/8"	-	63727
7/16"	.4375	4-1/16"	5-1/2"	63928	63728
29/64"	.4531	4-3/16"	5-5/8"	-	63729
15/32"	.4689	4-5/16"	5-3/4"	63930	63730
31/64"	.4844	4-3/8"	5-7/8"	-	63731
1/2"	.5000	4-1/2"	6"	63932	63732

Left-Hand Cobalt HSS Fractional Mechanics Length Drill Bits 135° Split Point (Series 305)



30524

- 8% Cobalt alloyed for higher heat and abrasion resistance
- Shorter drill for additional strength
- Heavy-duty web construction for strength and durability

Sets:

5 Piece Set: 30520

Size	Decimal Equiv.	Flute Length	Overall Length	Carded Stock #	Bulk Stock #
5/64"	.0781	1"	2"	—	30505
7/64"	.1094	1"	2-3/16"	—	30507
1/8"	.1250	1-1/16"	2-1/4"	—	30508
5/32"	.1563	1-1/4"	2-9/16"	—	30510
3/16"	.1875	1-1/2"	2-7/8"	—	30512
7/32"	.2188	1-5/8"	3-1/8"	—	30514
1/4"	.2500	1-3/4"	3-5/16"	—	30516
9/32"	.2812	2"	3-9/16"	—	30518
19/64"	.2969	2-1/16"	3-5/8"	—	30519
5/16"	.3125	2-1/8"	3-3/4"	—	31520
11/32"	.3438	2-1/4"	3-15/16"	—	30522
3/8"	.3750	2-3/8"	4-1/8"	—	30524
13/32"	.4062	2-1/2"	4-3/8"	—	30526
7/16"	.4375	2-5/8"	4-9/16"	—	30528
15/32"	.4688	2-3/4"	4-3/4"	—	30530
1/2"	.5000	2-7/8"	5"	—	30532

HSS Fractional Screw Machine Length Drill Bits (Series 301)



30132

- Black Oxide finish for corrosion resistance
- Shorter length for increased strength and rigidity
- Also known as "stubbies"

Applications:

Industrial applications, MRO, automotive, machine shop

Size	Decimal Equiv.	Flute Length	Overall Length	Carded Stock #	Bulk Stock #
1/16"	.0625	5/8"	1-5/8"	—	30104
5/64"	.0781	11/16"	1-11/16"	—	30105
3/32"	.0938	3/4"	1-3/4"	—	30106
7/64"	.1094	13/16"	1-13/16"	—	30107
1/8"	.1250	7/8"	1-7/8"	—	30108
9/64"	.1406	15/16"	1-15/16"	—	30109
5/32"	.1562	1"	2-1/16"	—	30110
11/64"	.1719	1-1/16"	2-1/8"	—	30111
3/16"	.1875	1-1/8"	2-3/16"	—	30112
13/64"	.2031	1-3/16"	2-1/4"	—	30113
7/32"	.2188	1-1/4"	2-3/8"	—	30114
16/64"	.2500	1-5/16"	2-7/16"	—	30115
1/4"	.2500	1-3/8"	2-1/2"	—	30116
17/64"	.2656	1-7/16"	2-5/8"	—	30117
9/32"	.2813	1-1/2"	2-11/16"	—	30118
19/64"	.2969	1-9/16"	2-3/4"	—	30119
5/16"	.3125	1-5/8"	2-13/16"	—	30120
21/64"	.3281	1-11/16"	2-15/16"	—	30121
11/32"	.3438	1-11/16"	3"	—	30122
23/64"	.3594	1-3/4"	3-1/16"	—	30123
3/8"	.3750	1-13/16"	3-1/8"	—	30124
25/64"	.3906	1-7/8"	3-1/4"	—	30125
13/32"	.4063	1-15/16"	3-5/16"	—	30126
27/64"	.4219	2"	3-3/8"	—	30127
7/16"	.4375	2-1/16"	3-7/16"	—	30128
29/64"	.4531	2-1/8"	3-9/16"	—	30129
15/32"	.4689	2-1/8"	3-5/8"	—	30130
31/64"	.4844	2-3/16"	3-11/16"	—	30131
1/2"	.5000	2-1/4"	3-3/4"	—	30132

HANSON® 10-pc Spiral Extractor & Drill Bit Set in Metal Index



11119

HANSON 35-pc Screw Extractor & Drill Bit Set



11135

HANSON 10-pc Spiral Extractor & Drill Bit Combo Packs



11117

NEW HANSON 48-pc Master Extender Set



3101010

- The most complete extractor kit we produce
- For use with fasteners above, below, or flush with the work surface

Description		Contents		Stock # 11119
Spiral Flute Extractors				Drill Bits
EX-1	52401		5/64"	30505
EX-2	52402		7/64"	30507
EX-3	52403		5/32"	30510
EX-4	52404		1/4"	30516
EX-5	52405		19/64"	30519

Description		Contents		Stock # 11135	
Spiral Flute Extractors		Multi Splines Extractors		Left-Hand Cobalt Drill Bits	
EX-1	52401	1/8"	53201	5/64"	30505
EX-2	52402	5/32"	53202	7/64"	30507
EX-3	52403	3/16"	53203	1/8"	30508
EX-4	52404	7/32"	53204	5/32"	30510
EX-5	52405	1/4"	53205	3/16"	30512
EX-6	52406	9/32"	53206	7/32"	30514
		5/16"	53207	1/4"	30516
		11/32"	53208	9/32"	30518
		3/8"	53209	19/64"	30519
		13/32"	53210	5/16"	31520
		7/16"	53211	11/32"	30522
		15/32"	53212	3/8"	30524
		1/2"	53213	13/32"	30526
				7/16"	30528
				15/32"	30530
				1/2"	30532

Description		Contents		Stock # 11117
Spiral Flute Extractors				Drill Bits
EX-1	52401		5/64"	63105
EX-2	52402		7/64"	63107
EX-3	52403		5/32"	63110
EX-4	52404		1/4"	63116
EX-5	52405		19/64"	63119

Description		Contents			Stock # 3101010		
Spiral Flute Extractors		Multi Splines Extractors		Bolt Extractors	Left-Hand Cobalt Drill Bits		
EX-1	52401	1/8"	53201	1/4"	53901	5/64"	30505
EX-2	52402	5/32"	53202	5/16"-8mm	53902	7/64"	30507
EX-3	52403	3/16"	53203	3/8"	53903	1/8"	30508
EX-4	52404	7/32"	53204	10mm	53904	5/32"	30510
EX-5	52405	1/4"	53205	7/16"-11mm	53905	3/16"	30512
EX-6	52406	9/32"	53206	12mm	53906	7/32"	30514
		5/16"	53207	1/2"	53907	1/4"	30516
		11/32"	53208	13mm	53908	9/32"	30518
		3/8"	53209	9/16"-14mm	53909	19/64"	30519
		13/32"	53210	5/8"-16mm	53910	5/16"	31520
		7/16"	53211	17mm	53911	11/32"	30522
		15/32"	53212	11/16"	53912	3/8"	30524
		1/2"	53213	3/4"-19mm	53913	13/32"	30526
						7/16"	30528
						15/32"	30530
						1/2"	30532

EXTRACTORS