

General Purpose Styles 157, 157-TN (2157)

Features/Benefits:

- General-purpose geometry for drilling in a wide range of operating conditions and materials.
- Manufactured from premium high-speed steel.
- 118° point.
- Shorter flute and overall length provide superior rigidity to minimize deflection when using heavy feed rates.
- Extra rigidity is ideal for portable drilling.
- Bright finish standard from stock up to .5000"; black oxide standard from stock over .5000"; titanium-nitride (TiN) coated available from stock in selected sizes.

Application Information:

- carbon steel (bright, black oxide)
- alloy steel (bright, black oxide)
- cast iron (bright, black oxide)
- non-ferrous materials (bright)

Surface Treatment Information:

- Black oxide surface finish increases wear resistance and adds lubricity, improving chip flow.
- Titanium nitride (TiN) PVD coating adds lubricity and hardness which enhances chip flow, finish hole quality, and drill life.



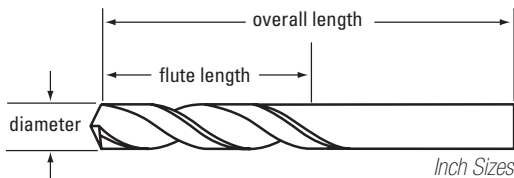
Style 157 Bright Finish



Style 157 Black Oxide



Style 157-TN TiN-Coated



INCH SIZES

Drill Diameter		Overall Length		Flute Length		Style 157	Style 157-TN		
Fraction	Wire/Let	Decimal	mm	Inch	mm	Bright	TiN		
	60	.0400	1.02	1.3750	34.93	.5000	12.70	48760	—
	59	.0410	1.04	1.3750	34.93	.5000	12.70	48759	—
	58	.0420	1.07	1.3750	34.93	.5000	12.70	48758	—
	57	.0430	1.09	1.3750	34.93	.5000	12.70	48757	—
	56	.0465	1.18	1.3750	34.93	.5000	12.70	48756	—
3/64		.0469	1.19	1.3750	34.93	.5000	12.70	48503	—
	55	.0520	1.32	1.6250	41.28	.6250	15.88	48755	—
	54	.0550	1.40	1.6250	41.28	.6250	15.88	48754	—
	53	.0595	1.51	1.6250	41.28	.6250	15.88	48753	—
1/16		.0625	1.59	1.6250	41.28	.6250	15.88	48504	55096
	52	.0635	1.61	1.6875	42.86	.6875	17.46	48752	—
	51	.0670	1.70	1.6875	42.86	.6875	17.46	48751	—
	50	.0700	1.78	1.6875	42.86	.6875	17.46	48750	—
	49	.0730	1.85	1.6875	42.86	.6875	17.46	48749	—
	48	.0760	1.93	1.6875	42.86	.6875	17.46	48748	—
5/64		.0781	1.98	1.6875	42.86	.6875	17.46	48505	55097
	47	.0785	1.99	1.7500	44.45	.7500	19.05	48747	—
	46	.0810	2.06	1.7500	44.45	.7500	19.05	48746	—
	45	.0820	2.08	1.7500	44.45	.7500	19.05	48745	—
	44	.0860	2.18	1.7500	44.45	.7500	19.05	48744	—
	43	.0890	2.26	1.7500	44.45	.7500	19.05	48743	—
	42	.0935	2.37	1.7500	44.45	.7500	19.05	48742	—
3/32		.0938	2.38	1.7500	44.45	.7500	19.05	48506	55098

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Drill Diameter		Overall Length				Flute Length		Style 157	Style 157-TN
Fraction	Wire/Let	Decimal	mm	Inch	mm	Inch	mm	Bright	TiN
	41	.0960	2.44	1.8125	46.04	.8125	20.64	48741	—
	40	.0980	2.49	1.8125	46.04	.8125	20.64	48740	—
	39	.0995	2.53	1.8125	46.04	.8125	20.64	48739	—
	38	.1015	2.58	1.8125	46.04	.8125	20.64	48738	—
	37	.1040	2.64	1.8125	46.04	.8125	20.64	48737	—
	36	.1065	2.71	1.8125	46.04	.8125	20.64	48736	—
7/64		.1094	2.78	1.8125	46.04	.8125	20.64	48507	55099
	35	.1100	2.79	1.8750	47.63	.8750	22.23	48735	—
	34	.1110	2.82	1.8750	47.63	.8750	22.23	48734	—
	33	.1130	2.87	1.8750	47.63	.8750	22.23	48733	—
	32	.1160	2.95	1.8750	47.63	.8750	22.23	48732	—
	31	.1200	3.05	1.8750	47.63	.8750	22.23	48731	—
1/8		.1250	3.18	1.8750	47.63	.8750	22.23	48508	55100
	30	.1285	3.26	1.9375	49.21	.9375	23.81	48730	—
	29	.1360	3.45	1.9375	49.21	.9375	23.81	48729	—
	28	.1405	3.57	1.9375	49.21	.9375	23.81	48728	—
9/64		.1406	3.57	1.9375	49.21	.9375	23.81	48509	55101
	27	.1440	3.66	2.0625	52.39	1.0000	25.40	48727	—
	26	.1470	3.73	2.0625	52.39	1.0000	25.40	48726	—
	25	.1495	3.80	2.0625	52.39	1.0000	25.40	48725	—
	24	.1520	3.86	2.0625	52.39	1.0000	25.40	48724	—
	23	.1540	3.91	2.0625	52.39	1.0000	25.40	48723	—
5/32		.1562	3.97	2.0625	52.39	1.0000	25.40	48510	55102
	22	.1570	3.99	2.1250	53.98	1.0625	26.99	48722	—
	21	.1590	4.04	2.1250	53.98	1.0625	26.99	48721	—
	20	.1610	4.09	2.1250	53.98	1.0625	26.99	48720	—
	19	.1660	4.22	2.1250	53.98	1.0625	26.99	48719	—
	18	.1695	4.31	2.1250	53.98	1.0625	26.99	48718	—
11/64		.1719	4.37	2.1250	53.98	1.0625	26.99	48511	55103
	17	.1730	4.39	2.1875	55.56	1.2500	31.75	48717	—
	16	.1770	4.50	2.1875	55.56	1.2500	31.75	48716	—
	15	.1800	4.57	2.1875	55.56	1.2500	31.75	48715	—
	14	.1820	4.62	2.1875	55.56	1.2500	31.75	48714	—
	13	.1850	4.70	2.1875	55.56	1.2500	31.75	48713	—
3/16		.1875	4.76	2.1875	55.56	1.2500	31.75	48512	55104
	12	.1890	4.80	2.2500	57.15	1.1875	30.16	48712	—
	11	.1910	4.85	2.2500	57.15	1.1875	30.16	48711	—
	10	.1935	4.91	2.2500	57.15	1.1875	30.16	48710	—
	9	.1960	4.98	2.2500	57.15	1.1875	30.16	48709	—
	8	.1990	5.05	2.2500	57.15	1.1875	30.16	48708	—
	7	.2010	5.11	2.2500	57.15	1.1875	30.16	48707	—
13/64		.2031	5.16	2.2500	57.15	1.1875	30.16	48513	55105
	6	.2040	5.18	2.3750	60.33	1.2500	31.75	48706	—
	5	.2055	5.22	2.3750	60.33	1.2500	31.75	48705	—
	4	.2090	5.31	2.3750	60.33	1.2500	31.75	48704	—
	3	.2130	5.41	2.3750	60.33	1.2500	31.75	48703	—
7/32		.2188	5.56	2.3750	60.33	1.2500	31.75	48514	55106

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INCH SIZES

Drill Diameter		Overall Length		Flute Length		Style 157	Style 157-TN		
Fraction	Wire/Let	Decimal	mm	Inch	mm	Bright	TiN		
	2	.2210	5.61	2.4375	61.91	1.3125	33.34	48702	—
	1	.2280	5.79	2.4375	61.91	1.3125	33.34	48701	—
	A	.2340	5.94	2.4375	61.91	1.3125	33.34	48801	—
15/64		.2344	5.95	2.4375	61.91	1.3125	33.34	48515	55107
	B	.2380	6.05	2.5000	63.50	1.3750	34.93	48802	—
	C	.2420	6.15	2.5000	63.50	1.3750	34.93	48803	—
	D	.2460	6.25	2.5000	63.50	1.3750	34.93	48804	—
1/4	E	.2500	6.35	2.5000	63.50	1.3750	34.93	48516	55108
	F	.2570	6.53	2.6250	66.68	1.4375	36.51	48806	—
	G	.2610	6.63	2.6250	66.68	1.4375	36.51	48807	—
17/64		.2656	6.75	2.6250	66.68	1.4375	36.51	48517	55109
	H	.2660	6.76	2.6875	68.26	1.5000	38.10	48808	—
	I	.2720	6.91	2.6875	68.26	1.5000	38.10	48809	—
	J	.2770	7.04	2.6875	68.26	1.5000	38.10	48810	—
	K	.2812	7.14	2.6875	68.26	1.5000	38.10	48811	—
9/32		.2812	7.14	2.6875	68.26	1.5000	38.10	48518	55110
	L	.2900	7.37	2.7500	69.85	1.5625	39.69	48812	—
	M	.2950	7.49	2.7500	69.85	1.5625	39.69	48813	—
19/64		.2969	7.54	2.7500	69.85	1.5625	39.69	48519	55111
	N	.3020	7.67	2.8125	71.44	1.6250	41.28	48814	—
5/16		.3125	7.94	2.8125	71.44	1.6250	41.28	48520	55112
	O	.3160	8.03	2.9375	74.61	1.6875	42.86	48815	—
	P	.3230	8.20	2.9375	74.61	1.6875	42.86	48816	—
21/64		.3281	8.33	2.9375	74.61	1.6875	42.86	48521	55113
	Q	.3320	8.43	3.0000	76.20	1.6875	42.86	48817	—
	R	.3390	8.61	3.0000	76.20	1.6875	42.86	48818	—
11/32		.3438	8.73	3.0000	76.20	1.6875	42.86	48522	55114
	S	.3480	8.84	3.0625	77.79	1.7500	44.45	48819	—
	T	.3580	9.09	3.0625	77.79	1.7500	44.45	48820	—
23/64		.3594	9.13	3.0625	77.79	1.7500	44.45	48523	55115
	U	.3680	9.35	3.1250	79.38	1.8125	46.04	48821	—
3/8		.3750	9.53	3.1250	79.38	1.8125	46.04	48524	55116
	V	.3770	9.58	3.2500	82.55	1.8750	47.63	48822	—
	W	.3860	9.80	3.2500	82.55	1.8750	47.63	48823	—
25/64		.3906	9.92	3.2500	82.55	1.8750	47.63	48525	55117
	X	.3970	10.08	3.3125	84.14	1.9375	49.21	48824	—
	Y	.4040	10.26	3.3125	84.14	1.9375	49.21	48825	—
13/32		.4062	10.32	3.3125	84.14	1.9375	49.21	48526	55118
	Z	.4130	10.49	3.3750	85.73	2.0000	50.80	48826	—
27/64		.4219	10.72	3.3750	85.73	2.0000	50.80	48527	55119
7/16		.4375	11.11	3.4375	87.31	2.0625	52.39	48528	55120
29/64		.4531	11.51	3.5625	90.49	2.1250	53.98	48529	55121
15/32		.4688	11.91	3.6250	92.08	2.1250	53.98	48530	55122
31/64		.4844	12.30	3.6875	93.66	2.1875	55.56	48531	55123
1/2		.5000	12.70	3.7500	95.25	2.2500	57.15	48532	55124
33/64		.5156	13.10	3.8750	98.43	2.3750	60.33	48533	—
17/32		.5312	13.49	3.8750	98.43	2.3750	60.33	48534	—

*drills over 1/2" diameter are black oxide finish
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General Purpose (continued) Styles 157, 157-TN (2157)

INCH SIZES

Drill Diameter		Decimal	mm	Overall Length		Flute Length		Style 157	Style 157-TN
Fraction	Wire/Let			Inch	mm	Inch	mm	Bright	TiN
35/64		.5469	13.89	4.0000	101.60	2.5000	63.50	48535	—
9/16		.5625	14.29	4.0000	101.60	2.5000	63.50	48536	—
37/64		.5781	14.68	4.1250	104.78	2.6250	66.68	48537	—
19/32		.5938	15.08	4.1250	104.78	2.6250	66.68	48538	—
39/64		.6094	15.48	4.2500	107.95	2.7500	69.85	48539	—
5/8		.6250	15.88	4.2500	107.95	2.7500	69.85	48540	—
41/64		.6406	16.27	4.5000	114.30	2.8750	73.03	48541	—
21/32		.6562	16.67	4.5000	114.30	2.8750	73.03	48542	—
43/64		.6719	17.07	4.6250	117.48	2.8750	73.03	48543	—
11/16		.6875	17.46	4.6250	117.48	2.8750	73.03	48544	—
45/64		.7031	17.86	4.7500	120.65	3.0000	76.20	48545	—
23/32		.7188	18.26	4.7500	120.65	3.0000	76.20	48546	—
47/64		.7344	18.65	5.0000	127.00	3.1250	79.38	48547	—
3/4		.7500	19.05	5.0000	127.00	3.1250	79.38	48548	—
49/64		.7656	19.45	5.1250	130.18	3.2500	82.55	48549	—
25/32		.7812	19.84	5.1250	130.18	3.2500	82.55	48550	—
51/64		.7969	20.24	5.2500	133.35	3.3750	85.73	48551	—
13/16		.8125	20.64	5.2500	133.35	3.3750	85.73	48552	—
53/64		.8281	21.03	5.3750	136.53	3.5000	88.90	48553	—
27/32		.8438	21.43	5.3750	136.53	3.5000	88.90	48554	—
55/64		.8594	21.83	5.5000	139.70	3.5000	88.90	48555	—
7/8		.8750	22.23	5.5000	139.70	3.5000	88.90	48556	—
57/64		.8906	22.62	5.6250	142.88	3.6250	92.08	48557	—
29/32		.9062	23.02	5.6250	142.88	3.6250	92.08	48558	—
59/64		.9219	23.42	5.7500	146.05	3.7500	95.25	48559	—
15/16		.9375	23.81	5.7500	146.05	3.7500	95.25	48560	—
61/64		.9531	24.21	5.8750	149.23	3.8750	98.43	48561	—
31/32		.9688	24.61	5.8750	149.23	3.8750	98.43	48562	—
63/64		.9844	25.00	6.0000	152.40	4.0000	101.60	48563	—
1		1.0000	25.40	6.0000	152.40	4.0000	101.60	48564	—
1-1/16*		1.0625	26.99	6.2500	158.75	4.0000	101.60	48568	—
1-1/8*		1.1250	28.58	6.3750	161.93	4.0000	101.60	48572	—
1-3/16*		1.1875	30.16	6.6250	168.28	4.2500	107.95	48576	—
1-1/4*		1.2500	31.75	6.7500	171.45	4.3750	111.13	48580	—

*Shank diameter for these sizes is 1.0000" (25.4mm).

INCH SETS

Sets in Metal Index Cases

Number of Tools	Size Range	Style 157 Bright
29	1/16 - 1/2 X 1/64	69900
26	Letters A - Z	69901
60	#1 - #60 wire gauge	69902



Set 69901