



Note
Designed to drill tough, high-tensile materials and work-hardening materials like high-strength alloy steels, stainless steel, titanium, manganese steel, armor plate, and inconel.
For Reduced Shank see Style #1812.

Style 1891 (Metric) now combined with style 1802.



HOLEMAKING

drill diameter		decimal equivalent	overall length	flute length	order number	
frac/wire/let	mm				1603 Straw Oxide	1802 Straw Oxide
	*1.00	.0394	34	12	—	C18900
*60		.0400	1-5/8	11/16	C68460	C23374
*59		.0410	1-5/8	11/16	C68459	C23375
*58		.0420	1-5/8	11/16	C68458	C23376
*57		.0430	1-3/4	3/4	C68457	C23377
*56		.0465	1-3/4	3/4	C68456	C23378
	*1.20	.0472	38	16	—	C18902
*55		.0520	1-7/8	7/8	C68455	C23379
*54		.0550	1-7/8	7/8	C68454	C23380
	*1.50	.0591	40	18	—	C18905
*53		.0595	1-7/8	7/8	C68453	C23381
1/16		.0625	1-7/8	7/8	C68344	C23345
	1.60	.0630	43	20	—	C18906
52		.0635	1-7/8	7/8	C68452	C23382
51		.0670	2	1	C68451	C23383
50		.0700	2	1	C68450	C23384
49		.0730	2	1	C68449	C23385
48		.0760	2	1	C68448	C23386
5/64		.0781	2	1	C68345	C23346
47		.0785	2	1	C68447	C23387
	2.00	.0787	49	24	—	C18910
46		.0810	2-1/8	1-1/8	C68446	C23388
45		.0820	2-1/8	1-1/8	C68445	C23389
44		.0860	2-1/8	1-1/8	C68444	C23390
43		.0890	2-1/4	1-1/4	C68443	C23391
42		.0935	2-1/4	1-1/4	C68442	C23392
3/32		.0938	2-1/4	1-1/4	C68346	C23347
	2.40	.0945	57	30	—	C18914
41		.0960	2-3/8	1-3/8	C68441	C23393
40		.0980	2-3/8	1-3/8	C68440	C23394
	2.50	.0984	57	30	—	C18915
39		.0995	2-3/8	1-3/8	C68439	C23395
38		.1015	2-1/2	1-7/16	C68438	C23396
37		.1040	2-1/2	1-7/16	C68437	C23397
36		.1065	2-1/2	1-7/16	C68436	C23398
7/64		.1094	2-5/8	1-1/2	C68347	C23348
35		.1100	2-5/8	1-1/2	C68435	C23399
	2.80	.1102	61	33	—	C18918
34		.1110	2-5/8	1-1/2	C68434	C23400
33		.1130	2-5/8	1-1/2	C68433	C23401
32		.1160	2-3/4	1-5/8	C68432	C23402
	3.00	.1181	61	33	—	C18920
31		.1200	2-3/4	1-5/8	C68431	C23403
	3.10	.1220	65	36	—	C18921
1/8		.1250	2-3/4	1-5/8	C68351	C23349
	3.20	.1260	65	36	—	C18922

*Not split point.

continued on next page

HOLEMAKING

drill diameter		decimal equivalent	overall length	flute length	order number	
frac/wire/let	mm				1603 Straw Oxide	1802 Straw Oxide
30		.1285	2-3/4	1-5/8	C68430	C23404
	3.30	.1299	65	36	—	C18923
29		.1360	2-7/8	1-3/4	C68429	C23405
	3.50	.1378	70	39	—	C18925
28		.1405	2-7/8	1-3/4	C68428	C23406
9/64		.1406	2-7/8	1-3/4	C68352	C23350
	3.60	.1417	70	39	—	C18926
27		.1440	3	1-7/8	C68427	C23407
	3.70	.1457	70	39	—	C18927
26		.1470	3	1-7/8	C68426	C23408
25		.1495	3	1-7/8	C68425	C23409
24		.1520	3-1/8	2	C68424	C23410
	3.90	.1535	75	43	—	C18929
23		.1540	3-1/8	2	C68423	C23411
5/32		.1562	3-1/8	2	C68353	C23351
22		.1570	3-1/8	2	C68422	C23412
	4.00	.1575	75	43	—	C18930
21		.1590	3-1/4	2-1/8	C68421	C23413
20		.1610	3-1/4	2-1/8	C68420	C23414
	4.10	.1614	75	43	—	C18931
	4.20	.1654	75	43	—	C18932
19		.1660	3-1/4	2-1/8	C68419	C23415
18		.1695	3-1/4	2-1/8	C68418	C23416
11/64		.1719	3-1/4	2-1/8	C68354	C23352
17		.1730	3-3/8	2-3/16	C68417	C23417
16		.1770	3-3/8	2-3/16	C68416	C23418
	4.50	.1772	80	47	—	C18935
15		.1800	3-3/8	2-3/16	C68415	C23419
	4.60	.1811	80	47	—	C18936
14		.1820	3-3/8	2-3/16	C68414	C23420
13		.1850	3-1/2	2-5/16	C68413	C23421
3/16		.1875	3-1/2	2-5/16	C68355	C23353
12		.1890	3-1/2	2-5/16	C68412	C23422
	4.80	.1890	86	52	—	C18938
11		.1910	3-1/2	2-5/16	C68411	C23423
	4.90	.1929	86	52	—	C18939
10		.1935	3-5/8	2-7/16	C68410	C23424
9		.1960	3-5/8	2-7/16	C68409	C23425
	5.00	.1969	86	52	—	C18940
8		.1990	3-5/8	2-7/16	C68408	C23426
	5.10	.2008	86	52	—	C18941
7		.2010	3-5/8	2-7/16	C68407	C23427
13/64		.2031	3-5/8	2-7/16	C68356	C23354
6		.2040	3-3/4	2-1/2	C68406	C23428
	5.20	.2047	86	52	—	C18942
5		.2055	3-3/4	2-1/2	C68405	C23429
4		.2090	3-3/4	2-1/2	C68404	C23430
3		.2130	3-3/4	2-1/2	C68403	C23431
	5.50	.2165	93	57	—	C18945
7/32		.2188	3-3/4	2-1/2	C68357	C23355
2		.2210	3-7/8	2-5/8	C68402	C23432
1		.2280	3-7/8	2-5/8	C68401	C23433
A		.2340	3-7/8	2-5/8	C68376	C23320
15/64		.2344	3-7/8	2-5/8	C68358	C23356
	6.00	.2362	93	57	—	C18950
B		.2380	4	2-3/4	C68377	C23321

continued on next page

drill diameter		decimal equivalent	overall length	flute length	order number	
frac/wire/let	mm				1603 Straw Oxide	1802 Straw Oxide
C		.2420	4	2-3/4	C68378	C23322
D		.2460	4	2-3/4	C68379	C23323
1/4, E		.2500	4	2-3/4	C68359	C23357
	6.50	.2559	101	63	—	C18955
F		.2570	4-1/8	2-7/8	C68380	C23324
G		.2610	4-1/8	2-7/8	C68381	C23325
17/64		.2656	4-1/8	2-7/8	C68360	C23358
H		.2660	4-1/8	2-7/8	C68382	C23326
	6.80	.2677	109	69	—	C18958
I		.2720	4-1/8	2-7/8	C68383	C23327
	7.00	.2756	109	69	—	C18960
J		.2770	4-1/8	2-7/8	C68384	C23328
K		.2810	4-1/4	2-15/16	C68385	C23329
9/32		.2812	4-1/4	2-15/16	C68361	C23359
L		.2900	4-1/4	2-15/16	C68386	C23330
M		.2950	4-3/8	3-1/16	C68387	—
	7.50	.2953	109	69	—	C18965
19/64		.2969	4-3/8	3-1/16	C68362	C23360
N		.3020	4-3/8	3-1/16	C68388	—
5/16		.3125	4-1/2	3-3/16	C68363	C23361
	8.00	.3150	117	75	—	C18970
O		.3160	4-1/2	3-3/16	C68389	—
P		.3230	4-5/8	3-5/16	C68390	—
21/64		.3281	4-5/8	3-5/16	C68364	C23362
Q		.3320	4-3/4	3-7/16	C68391	C23335
	8.50	.3346	117	75	—	C18975
R		.3390	4-3/4	3-7/16	C68392	C23336
11/32		.3438	4-3/4	3-7/16	C68365	C23363
S		.3480	4-7/8	3-1/2	C68393	—
	9.00	.3543	125	81	—	C18980
T		.3580	4-7/8	3-1/2	C68394	—
23/64		.3594	4-7/8	3-1/2	C68366	C23364
U		.3680	5	3-5/8	C68395	C23339
	9.50	.3740	125	81	—	C18985
3/8		.3750	5	3-5/8	C68367	C23365
V		.3770	5	3-5/8	C68396	C23340
W		.3860	5-1/8	3-3/4	C68397	C23341
25/64		.3906	5-1/8	3-3/4	C68368	C23366
	10.00	.3937	133	87	—	C18990
X		.3970	5-1/8	3-3/4	C68398	—
	10.20	.4016	133	87	—	C18991
Y		.4040	5-1/4	3-3/4	C68399	—
13/32		.4062	5-1/4	3-7/8	C68369	C23367
Z		.4130	5-1/4	3-7/8	C68400	—
	10.50	.4134	133	87	—	C18992
27/64		.4219	5-3/8	3-15/16	C68370	C23368
	11.00	.4331	142	94	—	C18993
7/16		.4375	5-1/2	4-1/16	C68371	C23369
	11.50	.4528	142	94	—	C18995
29/64		.4531	5-5/8	4-3/16	C68372	C23370
15/32		.4688	5-3/4	4-5/16	C68373	C23371
	12.00	.4724	151	101	—	C18996
31/64		.4844	5-7/8	4-3/8	C68374	C23372
	12.50	.4921	151	101	—	C18998
1/2		.5000	6	4-1/2	C68375	C23373
	13.00	.5118	151	101	—	C18999