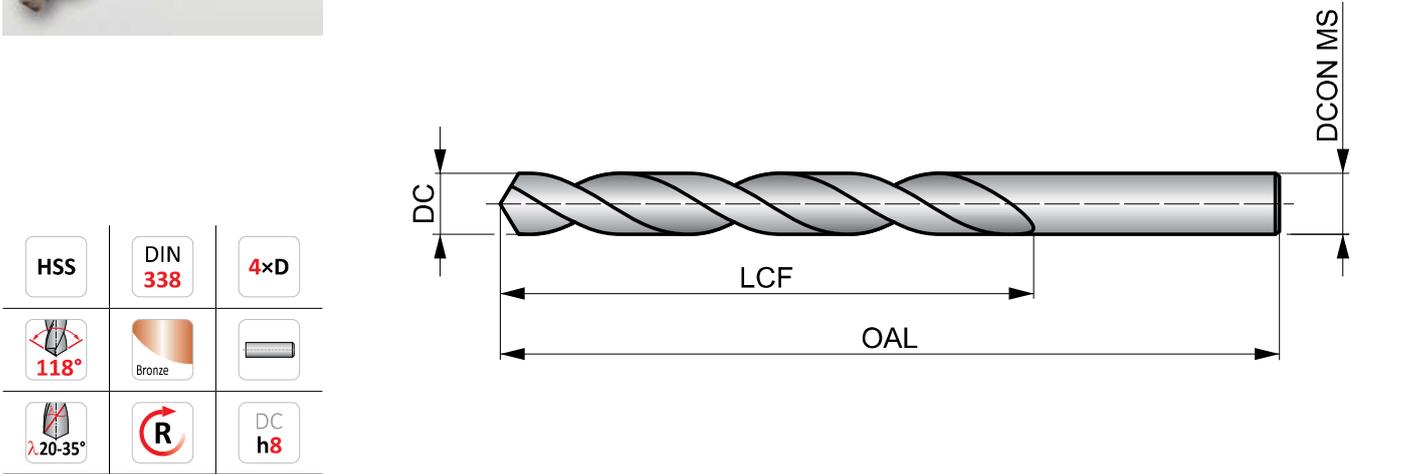


A115



HSS Jobber Drill, Bronze Finish

A versatile all-around drill with a 118° conventional point, which provides strength and is easy to regrind, making it very cost-effective for general purpose applications. Usable for hand-held and machine drilling. Bronze finish improves abrasion resistance and chip flow in soft ferrous or non-ferrous materials.



HSS	DIN 338	4xD
118°	Bronze	
λ 20-35°	R	DC h8

Workpiece material group suitability, starting values for cutting speed (m/min) and feed Alpha Code. Tables with feed per revolution can be found starting from page XY.

P1.1 31 H	P1.2 34 H	P1.3 35 H	P2.1 26 H	P2.2 23 F	P2.3 20 E	P3.1 18 F	P3.2 14 F	P3.3 12 E	P4.1 10 F	P4.2 9 E	P4.3 7 D	M1.1 20 E	M1.2 16 E
M2.1 17 E	M2.2 14 E	K1.1 28 H	K1.2 20 F	K1.3 16 F	K2.1 23 E	K2.2 19 E	K2.3 15 E	K3.1 20 E	K3.2 16 E	K3.3 12 E	K4.1 19 E	K4.2 14 E	K4.3 10 E
K4.4 9 E	K4.5 7 E	K5.1 21 E	K5.2 16 E	K5.3 12 E	N1.1 31 J	N1.2 23 J	N1.3 16 I	N2.1 39 H	N2.2 34 H	N2.3 25 H	N3.1 55 H	N3.2 33 I	N3.3 17 G
S1.1 21 E	S1.2 11 D	S1.3 6 B	S2.1 7 E	S2.2 4 A	S3.1 6 E	S3.2 3 A	S4.1 5 E	S4.2 2 A					

Product	DC (Wire gauge size)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1151.0	-	1.00	0.0394	12.0	34.0	1.00
A1151.1	-	1.10	0.0433	14.0	36.0	1.10
A1151.2	-	1.20	0.0472	16.0	38.0	1.20
A1151.3	-	1.30	0.0512	16.0	38.0	1.30
A1151.4	-	1.40	0.0551	18.0	40.0	1.40
A1151.5	-	1.50	0.0591	18.0	40.0	1.50
A1151.6	-	1.60	0.0630	20.0	43.0	1.60
A1151.63	-	1.63	0.0642	20.0	43.0	1.63
A1151.7	-	1.70	0.0669	20.0	43.0	1.70
A1151.8	-	1.80	0.0709	22.0	46.0	1.80
A1151.9	-	1.90	0.0748	22.0	46.0	1.90
A115N48	N48	1.93	0.0760	24.0	49.0	1.93
A1151.95	-	1.95	0.0768	24.0	49.0	1.95
A1152.0	-	2.00	0.0787	24.0	49.0	2.00
A115N45	N45	2.08	0.0819	24.0	49.0	2.08
A1152.1	-	2.10	0.0827	24.0	49.0	2.10
A1152.2	-	2.20	0.0866	27.0	53.0	2.20
A1152.3	-	2.30	0.0906	27.0	53.0	2.30
A1152.4	-	2.40	0.0945	30.0	57.0	2.40
A115N41	N41	2.44	0.0961	30.0	57.0	2.44
A1152.5	-	2.50	0.0984	30.0	57.0	2.50
A1152.6	-	2.60	0.1024	30.0	57.0	2.60
A1152.7	-	2.70	0.1063	33.0	61.0	2.70
A1152.8	-	2.80	0.1102	33.0	61.0	2.80
A1152.9	-	2.90	0.1142	33.0	61.0	2.90
A1153.0	-	3.00	0.1181	33.0	61.0	3.00

Product	DC (Wire gauge size)	DC (mm)	DC (inch)	LCF (mm)	OAL (mm)	DCON MS (mm)
A1153.1	-	3.10	0.1220	36.0	65.0	3.10
A1153.2	-	3.20	0.1260	36.0	65.0	3.20
A1153.3	-	3.30	0.1299	36.0	65.0	3.30
A1153.4	-	3.40	0.1339	39.0	70.0	3.40
A115N29	N29	3.45	0.1358	39.0	70.0	3.45
A1153.5	-	3.50	0.1378	39.0	70.0	3.50
A1153.6	-	3.60	0.1417	39.0	70.0	3.60
A1153.7	-	3.70	0.1457	39.0	70.0	3.70
A1153.8	-	3.80	0.1496	43.0	75.0	3.80
A1153.9	-	3.90	0.1535	43.0	75.0	3.90
A1154.0	-	4.00	0.1575	43.0	75.0	4.00
A1154.1	-	4.10	0.1614	43.0	75.0	4.10
A1154.2	-	4.20	0.1654	43.0	75.0	4.20
A1154.3	-	4.30	0.1693	47.0	80.0	4.30
A1154.4	-	4.40	0.1732	47.0	80.0	4.40
A1154.5	-	4.50	0.1772	47.0	80.0	4.50
A1154.6	-	4.60	0.1811	47.0	80.0	4.60
A1154.7	-	4.70	0.1850	47.0	80.0	4.70
A1154.8	-	4.80	0.1890	52.0	86.0	4.80
A1154.9	-	4.90	0.1929	52.0	86.0	4.90
A1155.0	-	5.00	0.1969	52.0	86.0	5.00
A1155.1	-	5.10	0.2008	52.0	86.0	5.10
A1155.2	-	5.20	0.2047	52.0	86.0	5.20
A1155.3	-	5.30	0.2087	52.0	86.0	5.30
A1155.4	-	5.40	0.2126	57.0	93.0	5.40
A1155.5	-	5.50	0.2165	57.0	93.0	5.50

Product	DC	DC	DC	LCF	OAL	DCON MS
	(Wire gauge size)	(mm)	(inch)	(mm)	(mm)	(mm)
A1155.6	–	5.60	0.2205	57.0	93.0	5.60
A1155.7	–	5.70	0.2244	57.0	93.0	5.70
A1155.8	–	5.80	0.2283	57.0	93.0	5.80
A1155.9	–	5.90	0.2323	57.0	93.0	5.90
A1156.0	–	6.00	0.2362	57.0	93.0	6.00
A1156.1	–	6.10	0.2402	63.0	101.0	6.10
A1156.2	–	6.20	0.2441	63.0	101.0	6.20
A1156.3	–	6.30	0.2480	63.0	101.0	6.30
A1156.4	–	6.40	0.2520	63.0	101.0	6.40
A1156.5	–	6.50	0.2559	63.0	101.0	6.50
A1156.6	–	6.60	0.2598	63.0	101.0	6.60
A1156.7	–	6.70	0.2638	63.0	101.0	6.70
A1156.8	–	6.80	0.2677	69.0	109.0	6.80
A1156.9	–	6.90	0.2717	69.0	109.0	6.90
A1157.0	–	7.00	0.2756	69.0	109.0	7.00
A1157.1	–	7.10	0.2795	69.0	109.0	7.10
A1157.2	–	7.20	0.2835	69.0	109.0	7.20
A1157.3	–	7.30	0.2874	69.0	109.0	7.30
A1157.4	–	7.40	0.2913	69.0	109.0	7.40
A1157.5	–	7.50	0.2953	69.0	109.0	7.50
A1157.6	–	7.60	0.2992	75.0	117.0	7.60
A1157.7	–	7.70	0.3031	75.0	117.0	7.70
A1157.8	–	7.80	0.3071	75.0	117.0	7.80
A1157.9	–	7.90	0.3110	75.0	117.0	7.90
A1158.0	–	8.00	0.3150	75.0	117.0	8.00
A1158.1	–	8.10	0.3189	75.0	117.0	8.10
A1158.2	–	8.20	0.3228	75.0	117.0	8.20
A1158.3	–	8.30	0.3268	75.0	117.0	8.30
A1158.4	–	8.40	0.3307	75.0	117.0	8.40
A1158.5	–	8.50	0.3346	75.0	117.0	8.50
A1158.6	–	8.60	0.3386	81.0	125.0	8.60
A1158.7	–	8.70	0.3425	81.0	125.0	8.70
A1158.8	–	8.80	0.3465	81.0	125.0	8.80
A1158.9	–	8.90	0.3504	81.0	125.0	8.90
A1159.0	–	9.00	0.3543	81.0	125.0	9.00
A1159.1	–	9.10	0.3583	81.0	125.0	9.10
A1159.2	–	9.20	0.3622	81.0	125.0	9.20
A1159.3	–	9.30	0.3661	81.0	125.0	9.30
A1159.4	–	9.40	0.3701	81.0	125.0	9.40
A1159.5	–	9.50	0.3740	81.0	125.0	9.50
A1159.6	–	9.60	0.3780	87.0	133.0	9.60
A1159.7	–	9.70	0.3819	87.0	133.0	9.70
A1159.8	–	9.80	0.3858	87.0	133.0	9.80
A1159.9	–	9.90	0.3898	81.0	125.0	9.90

Product	DC	DC	DC	LCF	OAL	DCON MS
	(Wire gauge size)	(mm)	(inch)	(mm)	(mm)	(mm)
A11510.0	–	10.00	0.3937	87.0	133.0	10.00
A11510.1	–	10.10	0.3976	87.0	133.0	10.10
A11510.2	–	10.20	0.4016	87.0	133.0	10.20
A11510.3	–	10.30	0.4055	87.0	133.0	10.30
A11510.4	–	10.40	0.4094	87.0	133.0	10.40
A11510.5	–	10.50	0.4134	87.0	133.0	10.50
A11510.6	–	10.60	0.4173	87.0	133.0	10.60
A11510.7	–	10.70	0.4213	94.0	142.0	10.70
A11510.8	–	10.80	0.4252	94.0	142.0	10.80
A11510.9	–	10.90	0.4291	94.0	142.0	10.90
A11511.0	–	11.00	0.4331	94.0	142.0	11.00
A11511.1	–	11.10	0.4370	94.0	142.0	11.10
A11511.2	–	11.20	0.4409	94.0	142.0	11.20
A11511.3	–	11.30	0.4449	94.0	142.0	11.30
A11511.4	–	11.40	0.4488	94.0	142.0	11.40
A11511.5	–	11.50	0.4528	94.0	142.0	11.50
A11511.6	–	11.60	0.4567	94.0	142.0	11.60
A11511.7	–	11.70	0.4606	94.0	142.0	11.70
A11511.8	–	11.80	0.4646	94.0	142.0	11.80
A11511.9	–	11.90	0.4685	101.0	151.0	11.90
A11512.0	–	12.00	0.4724	101.0	151.0	12.00
A11512.1	–	12.10	0.4764	101.0	151.0	12.10
A11512.2	–	12.20	0.4803	101.0	151.0	12.20
A11512.3	–	12.30	0.4843	101.0	151.0	12.30
A11512.4	–	12.40	0.4882	101.0	151.0	12.40
A11512.5	–	12.50	0.4921	101.0	151.0	12.50
A11512.6	–	12.60	0.4961	101.0	151.0	12.60
A11512.7	–	12.70	0.5000	101.0	151.0	12.70
A11512.8	–	12.80	0.5039	101.0	151.0	12.80
A11512.9	–	12.90	0.5079	101.0	151.0	12.90
A11513.0	–	13.00	0.5118	101.0	151.0	13.00
A11513.1	–	13.10	0.5157	101.0	151.0	13.10
A11513.2	–	13.20	0.5197	101.0	151.0	13.20
A11513.5	–	13.50	0.5315	108.0	160.0	13.50
A11513.8	–	13.80	0.5433	108.0	160.0	13.80
A11514.0	–	14.00	0.5512	108.0	160.0	14.00
A11514.5	–	14.50	0.5709	114.0	169.0	14.50
A11515.0	–	15.00	0.5906	114.0	169.0	15.00
A11515.5	–	15.50	0.6102	120.0	178.0	15.50
A11516.0	–	16.00	0.6299	120.0	178.0	16.00
A11516.5	–	16.50	0.6496	125.0	184.0	16.50
A11517.0	–	17.00	0.6693	125.0	184.0	17.00
A11518.0	–	18.00	0.7087	130.0	191.0	18.00