

## Left-Hand Helix Style 150L

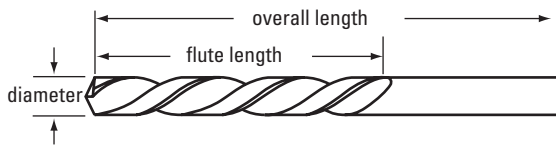
### Features/Benefits:

- General-purpose geometry for drilling in a wide range of operating conditions and materials.
- Manufactured from premium high-speed steel.
- 118° point.
- Left-hand helix is ideal for use in screw machines where machine spindle rotation is counter-clockwise.

- Can substitute for screw extractors to remove broken parts without damaging threaded holes.
- Bright finish standard from stock; alternate coatings available as stock modifications.

### Application Information:

- carbon steel
- alloy steel
- cast iron



Style 150L Bright Finish

### INCH SIZES

Fract	Drill Diameter		Overall Length		Flute Length		Style 150L Bright	
	Wire/Let	Decimal	mm	Inch	mm	Inch		mm
	69	.0292	0.74	1.3750	34.93	.5000	12.70	44539
	68	.0310	0.79	1.3750	34.93	.5000	12.70	44538
1/32		.0312	0.79	1.3750	34.93	.5000	12.70	44402
	67	.0320	0.81	1.3750	34.93	.5000	12.70	44537
	66	.0330	0.84	1.3750	34.93	.5000	12.70	44536
	65	.0350	0.89	1.5000	38.10	.6250	15.88	44535
	64	.0360	0.91	1.5000	38.10	.6250	15.88	44534
	63	.0370	0.94	1.5000	38.10	.6250	15.88	44533
	62	.0380	0.97	1.5000	38.10	.6250	15.88	44532
	61	.0390	0.99	1.6250	41.28	.6875	17.46	44531
	60	.0400	1.02	1.6250	41.28	.6875	17.46	44530
	59	.0410	1.04	1.6250	41.28	.6875	17.46	44529
	58	.0420	1.07	1.6250	41.28	.6875	17.46	44528
	57	.0430	1.09	1.7500	44.45	.7500	19.05	44527
	56	.0465	1.18	1.7500	44.45	.7500	19.05	44526
3/64		.0469	1.19	1.7500	44.45	.7500	19.05	44403
	55	.0520	1.32	1.8750	47.63	.8750	22.23	44525
	54	.0550	1.40	1.8750	47.63	.8750	22.23	44524
	53	.0595	1.51	1.8750	47.63	.8750	22.23	44523
1/16		.0625	1.59	1.8750	47.63	.8750	22.23	44404
	52	.0635	1.61	1.8750	47.63	.8750	22.23	44522
	51	.0670	1.70	2.0000	50.80	1.0000	25.40	44521
	50	.0700	1.78	2.0000	50.80	1.0000	25.40	44520
	49	.0730	1.85	2.0000	50.80	1.0000	25.40	44519
	48	.0760	1.93	2.0000	50.80	1.0000	25.40	44518
5/64		.0781	1.98	2.0000	50.80	1.0000	25.40	44405
	47	.0785	1.99	2.0000	50.80	1.0000	25.40	44517
	46	.0810	2.06	2.1250	53.98	1.1250	28.58	44516
	45	.0820	2.08	2.1250	53.98	1.1250	28.58	44515
	44	.0860	2.18	2.1250	53.98	1.1250	28.58	44514
	43	.0890	2.26	2.2500	57.15	1.2500	31.75	44513
	42	.0935	2.37	2.2500	57.15	1.2500	31.75	44512

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### Left-Hand Helix (continued) Style 150L

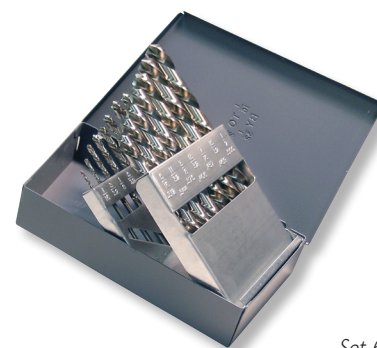
#### INCH SIZES

Fract	Drill Diameter		Overall Length		Flute Length		Style 150L Bright	
	Wire/Let	Decimal	mm	Inch	mm	Inch		mm
1/4		.2500	6.35	4.0000	101.60	2.7500	69.85	44416
17/64		.2656	6.75	4.1250	104.78	2.8750	73.03	44417
9/32		.2812	7.14	4.2500	107.95	2.9375	74.61	44418
19/64		.2969	7.54	4.3750	111.13	3.0625	77.79	44419
5/16		.3125	7.94	4.5000	114.30	3.1875	80.96	44420
21/64		.3281	8.33	4.6250	117.48	3.3125	84.14	44421
11/32		.3438	8.73	4.7500	120.65	3.4375	87.31	44422
23/64		.3594	9.13	4.8750	123.83	3.5000	88.90	44423
3/8		.3750	9.53	5.0000	127.00	3.6250	92.08	44424
25/64		.3906	9.92	5.1250	130.18	3.7500	95.25	44425
13/32		.4062	10.32	5.2500	133.35	3.8750	98.43	44426
27/64		.4219	10.72	5.3750	136.53	3.9375	100.01	44427
7/16		.4375	11.11	5.5000	139.70	4.0625	103.19	44428
29/64		.4531	11.51	5.6250	142.88	4.1875	106.36	44429
15/32		.4688	11.91	5.7500	146.05	4.3125	109.54	44430
31/64		.4844	12.30	5.8750	149.23	4.3750	111.13	44431
1/2		.5000	12.70	6.0000	152.40	4.5000	114.30	44432

#### INCH SETS

##### Sets in Metal Index Cases

Number of Tools	Size Range	Style 150L
		Bright
15	1/16 - 1/2 X 1/32	69881
21	1/16 - 3/8 X 1/64	69882
29	1/16 - 1/2 X 1/64	69876



Set 69881

## TECH TIP

#### WHY LEFT-HAND DRILLS?

Obviously because some people are left-handed! But actually, drills are also made with a left-hand flute spiral as opposed to the customary right hand spiral. Normally, these are seen in the jobbers and screw machine style and have the same flute and overall dimensions as their right-handed mirror image. They are normally in the general-purpose design to drill a wide range of materials and are available in other styles as specials.

Initially, left hand drills were primarily made for multi spindle (two or more) gear driven drilling heads, where the spindles rotated in opposite directions. They also are used in screw machines whose spindle may be rotated counterclockwise. Screw machines are used to manufacture smaller parts made from bar stock or tubing. Screw machines are multi-tasking and may turn, cut-off, drill and tap using multiple cutting tools with different holders.

Left hand drills are often used today to help extract a broken bolt or screw from a threaded hole. In some cases a left hand drill can be used counterclockwise to bring the right hand threaded fastener without damaging the part. This is sometimes done when a preferred screw extractor is not available.

**Jobber Drill Sets  
High-Speed Steel and Cobalt**

DRILLS

REAMERS

OTHER TOOLS

SETS

INDEX

**HIGH-SPEED STEEL SETS IN METAL INDEX CASES**

No of Tools	Sizes in Set	Style	General Purpose			Left-Hand 150L Bright	Heavy-Duty				Parabolic 150DH-TN TiN
			150 Blk Oxide	150D Bright	150-TN TiN		150ASP Blk Oxide	150ASP-TN TiN	150ASP-TC TiCN	150ASP-TA TiAlN	
<b>Inch Sizes</b>											
13	1/16 - 1/4 x 1/64		57711	49911			69847	41798	43638	42801	
15	1/16 - 1/2 x 1/32		57713	49913	69862	69881	69850	41797	43637	42800	
21	1/16 - 3/8 x 1/64		57712	49912		69882	69851	41799	43639		
29	1/16 - 1/2 x 1/64		57714	49914	69861	69876	45640	41800	43640		57734
26	Let A - Let Z		57718	49918	69883		45638	41801			
60	#1 - #60		57716	49916	69863		45639	41802			
20	#61 - #80		57720	57715	69897		45656	41803			
80	#1 - #80		57717								
115	1/16 - 1/2 x 1/64, Let A - Let Z, #1 - #60		57728	49928			45650	41804			
114	1/16 - 1/2 x 1/64, #1 - #60, 1mm - 13mm x .5mm		57726								
<b>Metric Sizes</b>											
11	1mm - 6mm x .5mm		57723								
13	1mm - 7mm x .5mm		57729								
25	1mm - 13mm x .5mm		57725				45925				
118	1mm - 13mm x .1mm		57727								

**COBALT SETS IN METAL INDEX CASES**

No of Tools	Sizes in Set	Style	Heavy-Duty		
			550 Straw	550-TN TiN	550ASP Straw
<b>Inch Sizes</b>					
13	1/16 - 1/4 x 1/64		57851	69891	
15	1/16 - 1/2 x 1/32		57852	69871	47795
21	1/16 - 3/8 x 1/64		69887	69892	
29	1/16 - 1/2 x 1/64		57850	69870	47796
26	Let A - Let Z		69886		
60	#1 - #60		57853		
20	#61 - #80		45657		
115	1/16 - 1/2 x 1/64, Let A - Let Z, #1 - #60		46650		
<b>Metric Sizes</b>					
11	1mm - 6mm x .5mm		54126		
19	1mm - 10mm x .5mm				47924
25	1mm - 13mm x .5mm		54127		47925

**JOBBER DRILL SETS STYLE SUMMARY**

Drill Style	Material	Point	Finish	Description
150	HSS	118°	Black Oxide	General Purpose
150D	HSS	118°	Bright	General Purpose
150T	HSS	118°	TiN-coated	General Purpose
150L	HSS	118°	Bright	Left-Hand Spiral
150ASP	HSS	135° Split	Black Oxide	Heavy-duty
150ASP-TN	HSS	135° Split	TiN-coated	Heavy-duty
150ASP-TC	HSS	135° Split	TiCN-coated	Heavy-duty
150ASP-TA	HSS	135° Split	TiAlN-coated	Heavy-duty
150DHT	HSS	135° K-Notch	TiN-coated	Parabolic Deep-Hole
550	Cobalt	135° Split	Straw	Heavy-duty
2550	Cobalt	135° Split	TiN-coated	Heavy-duty
550ASP	Cobalt	135° Split	Straw	Heavy-duty



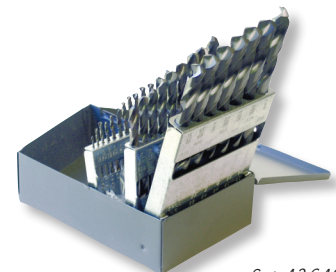
Set 57725



Set 69883



Set 47795



Set 43640

more sets on next page