

Drills

Screw Machine Length

Cobalt Heavy-Duty Style 559, 559-TN (2559), 559-TA

DRILLS

REAMERS

OTHER TOOLS

SETS

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Features/Benefits:

- Heavy-duty geometry for drilling tougher materials by hand or machine.
- Shorter flute and overall length provide superior rigidity to minimize deflection when using heavy feed rates.
- Manufactured from premium cobalt high-speed steel.
- 135° P3 split point is self-centering for reduced thrust and easier penetration. Sizes under .0625" do not have split points.
- Straw and titanium nitride (TiN) finishes standard from stock; titanium aluminum nitride (TiAlN) is a non-stocked standard; alternate coatings available as stock modifications.

Application Information:

- tool steel (TiAlN, TiN, straw)
- alloy steel (TiAlN, straw)
- carbon steel (TiAlN, TiN, straw)
- cast iron (TiAlN, TiN, straw)

Surface Treatment Information:

- Straw finish allows for easy identification of cobalt tools.
- Titanium nitride (TiN) PVD coating adds lubricity and hardness which enhances chip flow, finish hole quality, and drill life.
- Titanium aluminum nitride (TiAlN) PVD coating combines the ability to work in high temperatures with added hardness to increase drill life.



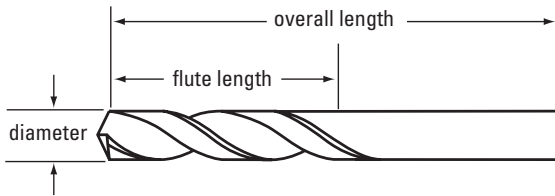
Style 559 Straw Finish



Style 559-TN TiN-Coated



Style 559-TA TiAlN-Coated



INCH SIZES

Fract	Drill Diameter		Overall Length		Flute Length		Style 559 Straw	Style 559-TN TiN	Style 559-TA TiAlN	
	Wire/Let	Decimal	mm	Inch	mm	Inch				mm
	60	.0400	1.02	1.3750	34.93	.5000	12.70	50915	—	—
	59	.0410	1.04	1.3750	34.93	.5000	12.70	50914	—	—
	58	.0420	1.07	1.3750	34.93	.5000	12.70	50913	—	—
	57	.0430	1.09	1.3750	34.93	.5000	12.70	50912	—	—
	56	.0465	1.18	1.3750	34.93	.5000	12.70	50911	—	—
	55	.0520	1.32	1.6250	41.28	.6250	15.88	50910	—	—
	54	.0550	1.40	1.6250	41.28	.6250	15.88	50909	—	—
	53	.0595	1.51	1.6250	41.28	.6250	15.88	50908	—	—
1/16		.0625	1.59	1.6250	41.28	.6250	15.88	50801	51801	52804
	52	.0635	1.61	1.6875	42.86	.6875	17.46	50907	—	—
	51	.0670	1.70	1.6875	42.86	.6875	17.46	50906	—	—
	50	.0700	1.78	1.6875	42.86	.6875	17.46	50905	—	—
	49	.0730	1.85	1.6875	42.86	.6875	17.46	50904	—	—
	48	.0760	1.93	1.6875	42.86	.6875	17.46	50903	—	—
5/64		.0781	1.98	1.6875	42.86	.6875	17.46	50802	51802	52805
	47	.0785	1.99	1.7500	44.45	.7500	19.05	50902	—	—

Sizes smaller than .0625" do not have split points.

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Customer Service: 800.348.2885

Technical Support: 800.892.4281

Screw Machine Length

Cobalt Heavy-Duty (continued)
Style 559, 559-TN (2559), 559-TA

INCH SIZES

Fract	Drill Diameter		Overall Length		Flute Length		Style 559	Style 559-TN	Style 559-TA	
	Wire/Let	Decimal	mm	Inch	mm	Inch	mm	Straw	TiN	TiAIN
	46	.0810	2.06	1.7500	44.45	.7500	19.05	50901	—	—
	45	.0820	2.08	1.7500	44.45	.7500	19.05	50900	—	—
	44	.0860	2.18	1.7500	44.45	.7500	19.05	50899	—	—
	43	.0890	2.26	1.7500	44.45	.7500	19.05	50898	—	—
	42	.0935	2.37	1.7500	44.45	.7500	19.05	50897	—	—
3/32		.0938	2.38	1.7500	44.45	.7500	19.05	50803	51803	52806
	41	.0960	2.44	1.8125	46.04	.8125	20.64	50896	—	—
	40	.0980	2.49	1.8125	46.04	.8125	20.64	50895	—	—
	39	.0995	2.53	1.8125	46.04	.8125	20.64	50894	—	—
	38	.1015	2.58	1.8125	46.04	.8125	20.64	50893	—	—
	37	.1040	2.64	1.8125	46.04	.8125	20.64	50892	—	—
	36	.1065	2.71	1.8125	46.04	.8125	20.64	50891	—	—
7/64		.1094	2.78	1.8125	46.04	.8125	20.64	50804	51804	52807
	35	.1100	2.79	1.8750	47.63	.8750	22.23	50890	—	—
	34	.1110	2.82	1.8750	47.63	.8750	22.23	50889	—	—
	33	.1130	2.87	1.8750	47.63	.8750	22.23	50888	—	—
	32	.1160	2.95	1.8750	47.63	.8750	22.23	50887	—	—
	31	.1200	3.05	1.8750	47.63	.8750	22.23	50886	—	—
1/8		.1250	3.18	1.8750	47.63	.8750	22.23	50805	51805	52808
	30	.1285	3.26	1.9375	49.21	.9375	23.81	50885	—	—
	29	.1360	3.45	1.9375	49.21	.9375	23.81	50884	—	—
	28	.1405	3.57	1.9375	49.21	.9375	23.81	50883	—	—
9/64		.1406	3.57	1.9375	49.21	.9375	23.81	50806	51806	52809
	27	.1440	3.66	2.0625	52.39	1.0000	25.40	50882	—	—
	26	.1470	3.73	2.0625	52.39	1.0000	25.40	50881	—	—
	25	.1495	3.80	2.0625	52.39	1.0000	25.40	50880	—	—
	24	.1520	3.86	2.0625	52.39	1.0000	25.40	50879	—	—
	23	.1540	3.91	2.0625	52.39	1.0000	25.40	50878	—	—
5/32		.1562	3.97	2.0625	52.39	1.0000	25.40	50807	51807	52810
	22	.1570	3.99	2.1250	53.98	1.0625	26.99	50877	—	—
	21	.1590	4.04	2.1250	53.98	1.0625	26.99	50876	—	—
	20	.1610	4.09	2.1250	53.98	1.0625	26.99	50875	—	—
	19	.1660	4.22	2.1250	53.98	1.0625	26.99	50874	—	—
	18	.1695	4.31	2.1250	53.98	1.0625	26.99	50873	—	—
11/64		.1719	4.37	2.1250	53.98	1.0625	26.99	50808	51808	52811
	17	.1730	4.39	2.1875	55.56	1.2500	31.75	50872	—	—
	16	.1770	4.50	2.1875	55.56	1.2500	31.75	50871	—	—
	15	.1800	4.57	2.1875	55.56	1.2500	31.75	50870	—	—
	14	.1820	4.62	2.1875	55.56	1.2500	31.75	50869	—	—
	13	.1850	4.70	2.1875	55.56	1.2500	31.75	50868	—	—
3/16		.1875	4.76	2.1875	55.56	1.2500	31.75	50809	51809	52812
	12	.1890	4.80	2.2500	57.15	1.1875	30.16	50867	—	—
	11	.1910	4.85	2.2500	57.15	1.1875	30.16	50866	—	—
	10	.1935	4.91	2.2500	57.15	1.1875	30.16	50865	—	—
	9	.1960	4.98	2.2500	57.15	1.1875	30.16	50864	—	—
	8	.1990	5.05	2.2500	57.15	1.1875	30.16	50863	—	—
	7	.2010	5.11	2.2500	57.15	1.1875	30.16	50862	—	—
13/64		.2031	5.16	2.2500	57.15	1.1875	30.16	50810	51810	52813
	6	.2040	5.18	2.3750	60.33	1.2500	31.75	50861	—	—
	5	.2055	5.22	2.3750	60.33	1.2500	31.75	50860	—	—

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