

Left-Hand Helix Style 150L

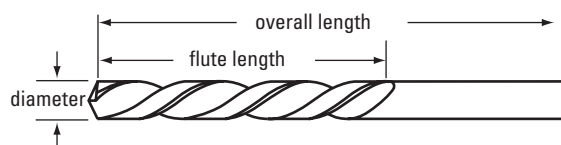
Features/Benefits:

- 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

Drill Diameter				Overall Length		Flute Length		Style 150L
Fraction	Wire/Let	Decimal	mm	Inch	mm	Inch	mm	Bright
1/32	69	.0292	0.74	1.3750	34.93	.5000	12.70	44539
	68	.0310	0.79	1.3750	34.93	.5000	12.70	44538
		.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
		.0625	1.59	1.8750	47.63	.8750	22.23	44404
1/16	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

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Left-Hand Helix (continued) Style 150L

INCH SIZES

Drill Diameter		Decimal	mm	Overall Length		Flute Length		Style 150L Bright
Fraction	Wire/Let			Inch	mm	Inch	mm	
3/32	42	.0935	2.37	2.2500	57.15	1.2500	31.75	44512
		.0938	2.38	2.2500	57.15	1.2500	31.75	44406
	41	.0960	2.44	2.3750	60.33	1.3750	34.93	44511
7/64	40	.0980	2.49	2.3750	60.33	1.3750	34.93	44510
	39	.0995	2.53	2.3750	60.33	1.3750	34.93	44509
	38	.1015	2.58	2.5000	63.50	1.4375	36.51	44508
1/8	37	.1040	2.64	2.5000	63.50	1.4375	36.51	44507
	36	.1065	2.71	2.5000	63.50	1.4375	36.51	44506
		.1094	2.78	2.6250	66.68	1.5000	38.10	44407
9/64	35	.1100	2.79	2.6250	66.68	1.5000	38.10	44505
	34	.1110	2.82	2.6250	66.68	1.5000	38.10	44504
	33	.1130	2.87	2.6250	66.68	1.5000	38.10	44503
5/32	32	.1160	2.95	2.7500	69.85	1.6250	41.28	44502
	31	.1200	3.05	2.7500	69.85	1.6250	41.28	44501
		.1250	3.18	2.7500	69.85	1.6250	41.28	44408
3/16	30	.1285	3.26	2.7500	69.85	1.6250	41.28	44500
	29	.1360	3.45	2.8750	73.03	1.7500	44.45	44499
	28	.1405	3.57	2.8750	73.03	1.7500	44.45	44498
1/4		.1406	3.57	2.8750	73.03	1.7500	44.45	44409
	27	.1440	3.66	3.0000	76.20	1.8750	47.63	44497
	26	.1470	3.73	3.0000	76.20	1.8750	47.63	44496
5/16	25	.1495	3.80	3.0000	76.20	1.8750	47.63	44495
	24	.1520	3.86	3.1250	79.38	2.0000	50.80	44494
	23	.1540	3.91	3.1250	79.38	2.0000	50.80	44493
3/8		.1562	3.97	3.1250	79.38	2.0000	50.80	44410
	22	.1570	3.99	3.1250	79.38	2.0000	50.80	44492
	21	.1590	4.04	3.2500	82.55	2.1250	53.98	44491
7/16	20	.1610	4.09	3.2500	82.55	2.1250	53.98	44490
	19	.1660	4.22	3.2500	82.55	2.1250	53.98	44489
	18	.1695	4.31	3.2500	82.55	2.1250	53.98	44488
1/2		.1719	4.37	3.2500	82.55	2.1250	53.98	44411
	17	.1730	4.39	3.3750	85.73	2.1875	55.56	44487
	16	.1770	4.50	3.3750	85.73	2.1875	55.56	44486
9/16	15	.1800	4.57	3.3750	85.73	2.1875	55.56	44485
	14	.1820	4.62	3.3750	85.73	2.1875	55.56	44484
	13	.1850	4.70	3.5000	88.90	2.3125	58.74	44483
5/8		.1875	4.76	3.5000	88.90	2.3125	58.74	44412
	12	.1890	4.80	3.5000	88.90	2.3125	58.74	44482
	11	.1910	4.85	3.5000	88.90	2.3125	58.74	44481
3/4	10	.1935	4.91	3.6250	92.08	2.4375	61.91	44480
	9	.1960	4.98	3.6250	92.08	2.4375	61.91	44479
	8	.1990	5.05	3.6250	92.08	2.4375	61.91	44478
7/8	7	.2010	5.11	3.6250	92.08	2.4375	61.91	44477
		.2031	5.16	3.6250	92.08	2.4375	61.91	44413
	6	.2040	5.18	3.7500	95.25	2.5000	63.50	44476
1 1/8	5	.2055	5.22	3.7500	95.25	2.5000	63.50	44475
	4	.2090	5.31	3.7500	95.25	2.5000	63.50	44474
	3	.2130	5.41	3.7500	95.25	2.5000	63.50	44473
1 1/4		.2188	5.56	3.7500	95.25	2.5000	63.50	44414
	2	.2210	5.61	3.8750	98.43	2.6250	66.68	44472

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

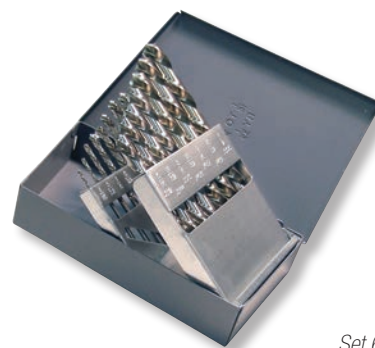
INCH SIZES

Drill Diameter		Overall Length		Flute Length		Style 150L	
Fraction	Wire/Let	Decimal	mm	Inch	mm	Inch	mm
	1	.2280	5.79	3.8750	98.43	2.6250	66.68
15/64		.2344	5.95	3.8750	98.43	2.6250	66.68
1/4		.2500	6.35	4.0000	101.60	2.7500	69.85
17/64		.2656	6.75	4.1250	104.78	2.8750	73.03
9/32		.2812	7.14	4.2500	107.95	2.9375	74.61
19/64		.2969	7.54	4.3750	111.13	3.0625	77.79
5/16		.3125	7.94	4.5000	114.30	3.1875	80.96
21/64		.3281	8.33	4.6250	117.48	3.3125	84.14
11/32		.3438	8.73	4.7500	120.65	3.4375	87.31
23/64		.3594	9.13	4.8750	123.83	3.5000	88.90
3/8		.3750	9.53	5.0000	127.00	3.6250	92.08
25/64		.3906	9.92	5.1250	130.18	3.7500	95.25
13/32		.4062	10.32	5.2500	133.35	3.8750	98.43
27/64		.4219	10.72	5.3750	136.53	3.9375	100.01
7/16		.4375	11.11	5.5000	139.70	4.0625	103.19
29/64		.4531	11.51	5.6250	142.88	4.1875	106.36
15/32		.4688	11.91	5.7500	146.05	4.3125	109.54
31/64		.4844	12.30	5.8750	149.23	4.3750	111.13
1/2		.5000	12.70	6.0000	152.40	4.5000	114.30

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.