



**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