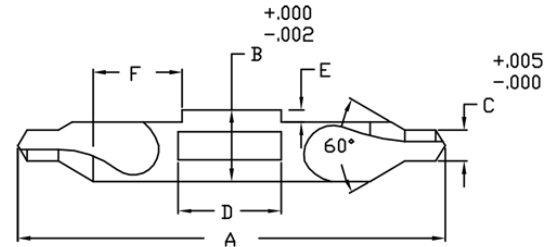


### Hey Centerdrill ST Type

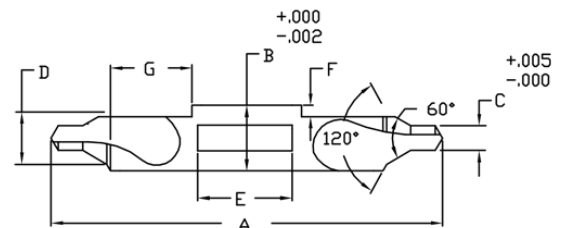
LINK Hey Drills offer the high quality and precision workmanship of our standard line of Centerdrills, with strategically positioned flats for locking set screws and to accommodate adjacent tooling. The position of the center flat is exactly 90° from the Hey Flat location. These drills feature our ST tip form.



60° Double End									
Drill Type	Part No.			OAL (A)	Body DIA (B)	Drill DIA (C)	Central Flat Length (D)	End Flat Depth (E)	End Flat Length (F)
	HSS	HSS-TiN	HSS-TiAIN						
4ST	21-L2-654	21-TN-654	21-TL-654	2-1/8	5/16	1/8	1/2	.075	9/16
5ST	21-L2-655	21-TN-655	21-TL-655	2-3/4	7/16	3/16	3/4	.086	5/8
6ST	21-L2-656	21-TN-656	21-TL-656	3	1/2	7/32	3/4	.086	5/8
7ST	21-L2-657	21-TN-657	21-TL-657	3-1/4	5/8	1/4	3/4	.105	5/8
8ST	21-L2-658	21-TN-658	21-TL-658	3-1/2	3/4	5/16	3/4	.105	5/8
Drill Type	COBALT	COBALT - TiN	COBALT-TiAIN	OAL (A)	Body DIA (B)	Drill DIA (C)	Central Flat Length (D)	End Flat Depth (E)	End Flat Length (F)
4ST	21-CO-654	CO-TN-654	CO-TL-654	2-1/8	5/16	1/8	1/2	.075	9/16
5ST	21-CO-655	CO-TN-655	CO-TL-655	2-3/4	7/16	3/16	3/4	.086	5/8
6ST	21-CO-656	CO-TN-656	CO-TL-656	3	1/2	7/32	3/4	.086	5/8
7ST	21-CO-657	CO-TN-657	CO-TL-657	3-1/4	5/8	1/4	3/4	.105	5/8
8ST	21-CO-658	CO-TN-658	CO-TL-658	3-1/2	3/4	5/16	3/4	.105	5/8

### Hey Centerdrill B Type Bell

The B Type Hey Drill is a dual-purpose drill which includes a 60° angle for burnishing and 120° flair for chamfering. It is used in conjunction with facing inserts. The position for the central flat is exactly 90° from the Hey Flat location. These drills feature our B tip form.

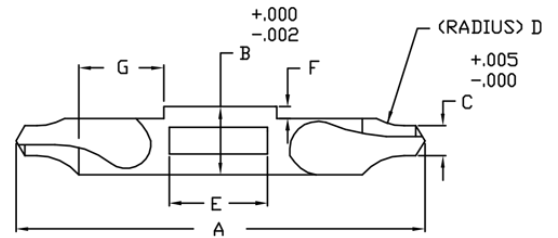


60°/120° Double End										
Drill Type	Part No.			OAL (A)	Body DIA (B)	Drill DIA (C)	Bell DIA (D)	Central Flat Length (E)	End Flat Depth (F)	End Flat Length (G)
	HSS	HSS-TiN	HSS-TiAIN							
13B	26-L2-673	26-TN-673	26-TL-673	2	1/4	3/32	.200	5/16	.055	7/16
14B	26-L2-674	26-TN-674	26-TL-674	2-1/8	5/16	7/64	.250	1/2	.075	9/16
15B	26-L2-675	26-TN-675	26-TL-675	2-3/4	7/16	5/32	.350	3/4	.086	5/8
16B	26-L2-676	26-TN-676	26-TL-676	3	1/2	3/16	.400	3/4	.086	5/8
17B	26-L2-677	26-TN-677	26-TL-677	3-1/4	5/8	7/32	.500	3/4	.105	5/8
18B	26-L2-678	26-TN-678	26-TL-678	3-1/2	3/4	1/4	.600	3/4	.105	5/8
Drill Type	COBALT	COBALT - TiN	COBALT-TiAIN	OAL (A)	Body DIA (B)	Drill DIA (C)	Bell DIA (D)	Central Flat Length (E)	End Flat Depth (F)	End Flat Length (G)
15B	26-CO-675	CO-TN-675	CO-TL-675	2-3/4	7/16	5/32	.350	3/4	.086	5/8
16B	26-CO-676	CO-TN-676	CO-TL-676	3	1/2	3/16	.400	3/4	.086	5/8
17B	26-CO-677	CO-TN-677	CO-TL-677	3-1/4	5/8	7/32	.500	3/4	.105	5/8
18B	26-CO-678	CO-TN-678	CO-TL-678	3-1/2	3/4	1/4	.600	3/4	.105	5/8



### Hey Centerdrill R Type

The R Type Hey Drill provides an increased cross-sectional area that is directly related to the depth of the cut and the resulting tool force. The position for the central flat is exactly 90° from the Hey Flat location.



Radius Double End										
Drill Type	Part No.			OAL (A)	Body DIA (B)	Drill DIA (C)	Radius (D)	Central Flat Length (E)	End Flat Depth (F)	End Flat Length (G)
	HSS	HSS-TiN	HSS-TiAIN							
5R	27-L2-684	27-TN-684	27-TL-684	2-3/4	7/16	3/16	.323	3/4	.086	5/8
6R	27-L2-685	27-TN-685	27-TL-685	3	1/2	7/32	.407	3/4	.086	5/8
7R	27-L2-686	27-TN-686	27-TL-686	3-1/4	5/8	1/4	.593	3/4	.105	5/8
8R	27-L2-687	27-TN-687	27-TL-687	3-1/2	3/4	5/16	.663	3/4	.105	5/8
Drill Type	COBALT	COBALT - TiN	COBALT-TiAIN	OAL (A)	Body DIA (B)	Drill DIA (C)	Radius (D)	Central Flat Length (E)	End Flat Depth (F)	End Flat Length (G)
6R	27-CO-685	CO-TN-685	CO-TL-685	3	1/2	7/32	.407	3/4	.086	5/8
7R	27-CO-686	CO-TN-686	CO-TL-686	3-1/4	5/8	1/4	.593	3/4	.105	5/8
8R	27-CO-687	CO-TN-687	CO-TL-687	3-1/2	3/4	5/16	.663	3/4	.105	5/8