

**DRILLS**



**HSS JOBBER DRILLS  
ANSI/ISO**



Dormer Style 0102 is a general purpose drill with a standard helix flute and 118° point angle, surface treated bright 1/32" and below with blue 3/64" and above.

Available in sizes:

- Style 0102 1/64" to 3/4"
- Style 0104 #1 to #60 gauge
- Style 0106 A to Z letter
- Style 0107 .30mm to 20.00mm metric

**HSS JOBBER DRILLS  
AIRCRAFT SPEC A/A 135°  
SPLIT POINT**

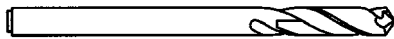


Dormer Style 0170 is a medium duty drill for use in aircraft industry. A split point 135° with a standard helix and thick web and blue finish. The split point allows for easy hole start.

Available in sizes:

- Style 0170 1/64" to 1/2"
- Style 0171 #1 to #52 gauge
- Style 0172 A to Z letter

**HSCO JOBBER DRILLS  
FRACTIONAL TYPE J A/A  
135° SPLIT POINT**



Dormer Style 0176 is a Cobalt Jobber Drill to be used when higher heat is generated during drilling. Example: on higher tensile tougher materials. It is a standard helix flute with a thick web point and a 135° split point.

Available in sizes:

- Style 0176 1/32" to 1/2"
- Style 0177 #1 to #80 gauge
- Style 0178 A to Z letter

**ORDERING INFORMATION**

Order by style number and size (ie. DOR010212 for Style 0102 at 1/2").

**HSS STUB DRILLS  
GAUGE ANSI BLUE**

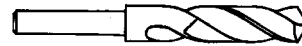


Dormer Style 0212 is a HSS screw machine length drill (stub drill). Is a standard helix with a 118° point (135° above 1/16" to 1/2") with a blue finish. Is used with portable drills turret and automatic lathes. General duty, high speed.

Available in sizes:

- Style 0211 #1 to #60 gauge
- Style 0212 1/16" to 1/2"
- Style 0214 A to Z letter
- Style 0215 3.00mm to 13.00mm metric

**HSS PRENTICE DRILLS 1/2"  
PARALLEL SHANK**

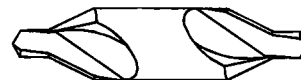


HSS Prentice Drills have a 1/2" parallel shank, flute type with a standard helix point of 118°. This is a general purpose light duty drill only.

Available in sizes:

- Style 0234 1/2" to 1 1/2"
- Style 0235 1/2" to 1 1/2" (flatted shank)
- Style 0236 1" to 2" (3/4" parallel shank)
- Style 0238 17/32" to 1 1/2" (1/2" flatted shank) (HSCO)

**HSS COMBINATION CENTRE  
DRILLS ISO**

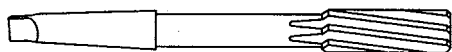


HSS Combination Centre Drills (combined drill and countersink) are a flute type, right hand helix with a 118° point angle and a 60° countersink. Used for producing centre holes in components which require machining between centres.

Available in sizes:

- Style 0240 BSI to BS7
- Style 0241 BS1 to BS5 (left hand) (Helix)
- Style 0243 0.80 x 3.15 to 10.00 x 25.00 (Metric)
- Style 0244 #1 to #8 (82° ANSI)
- Style 0245 #1 to #7 (60° ANSI)
- Style 0246 #1 to #8 (90° ANSI)
- Style 0275 #00 to #10 (HSS Comb. Centre Drills ANSI)

**HSS MORSE TAPER SHANK CHUCKING REAMERS SPIRAL FLUTE FRACTIONAL**



Dormer HSS Morse Taper Shank Chucking Reamers right hand spiral flutes, right hand cut, bevel lead 45° aside. Diameter tolerances: 1/4" + .0001 to .0004; 1/4" to 1" 0.0001 to 0.0005; 1"+ above 0.0002 to 0.0006.

Available in sizes:  
Style 1611 1/4" to 1 1/2"

**HSS MORSE TAPER SHANK LEFT HAND SPIRAL, RIGHT HAND CUT SPIRAL FLUTE BRIDGE REAMERS**



HSS Morse Taper Shank Bridge Reamers, left hand spiral flutes, right hand cut, pater lead -1 to 10. Used to open out existing holes for alignment on construction work which requires robust service reaming.

Available in sizes:  
Style 1616 7/16" to 1 5/16"  
Style 1625 13.00mm to 40.00mm (left hand spiral)

**EXPANDING HAND REAMERS WITH HSS STEEL BLADES**



Dormer Expanding Hand Reamers with high speed steel blades flute type, 6 blades. Used for sizing and finishing of existing holes screw-on extension pilots which assist in alignment.

Available in sizes:  
Style 1650 V to Z letter (1/4" to 3/8")  
H1 to H18 (3/8" to 3/32")

**DORMER**

**HSS END MILLS**



HSS End Mills are a 2-flute single end centre cutting right hand helix and right hand cutting used for milling slots, pockets and plunge cuts. The end teeth are cutting to centre allowing these end mills to plunge into solid material at the beginning of a slotting cut. Provides good chip removal.

Available in sizes:  
Style 1800 1/8" x 3/8" to 2" x 1 1/4" (regular)  
Style 1801 3/8" x 3/8" to 2" x 1 1/4" (long)  
Style 1802 1/4" x 3/8" to 1 1/4" x 1 1/4" (extra long)  
Style 1810 1/8" x 3/8" to 2" x 1 1/4" (multi-flute, non-centre cutting, regular)  
Style 1811 1/4" x 3/8" to 2" x 1 1/4" (long)  
Style 1812 1/4" x 3/8" to 1 1/2" x 1 1/4" (extra long)

**HSS THREADED SHANK MULTI-FLUTE END MILLS REGULAR**



Heavy duty non-centre cut, 4 flute with threaded shank. Designed for high efficiency. NC-machining and cam-milling applications.

Available in sizes:  
Style 1840 1/16" x 1/4" to 2" x 1 1/4" (regular)  
Style 1842 1/16" x 1/4" to 2" x 1 1/4" (long)  
Style 1844 1/16" x 1/4" to 2" x 1 1/4" (2 flutes, regular, center cutting)  
Style 1846 1/16" x 1/4" to 2" x 1 1/4" (2 flutes, long)

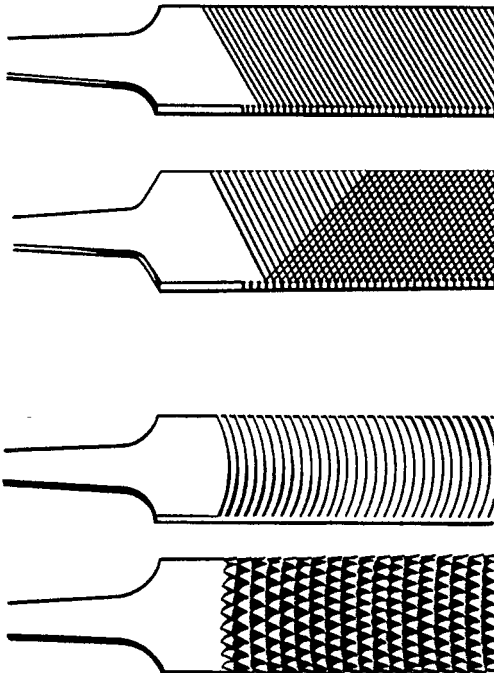
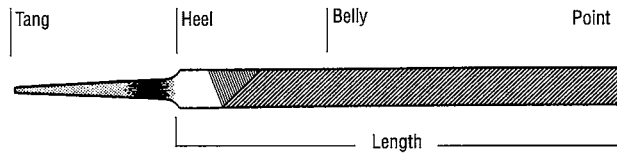
**ORDERING INFORMATION**

Order by style number and size (ie. DOR161114 for Style 1611 at 1/4").

FILES AND RASPS

# Nicholson®

Length



### KINDS OF TEETH

#### Single-cut

Single set of parallel, diagonal rows of teeth. Single-cut files are often used with light pressure to produce a smooth surface finish or to put a keen edge on knives, shears or saws.

#### Double-cut

Two sets of diagonal rows of teeth. The second set of teeth is cut in the opposite diagonal direction and on top of the first set. The first set of teeth is known as the overcut while the second is called the upcut. The upcut is finer than the overcut. The double-cut file is used with heavier pressure than the single-cut and removes material faster from the workpiece.

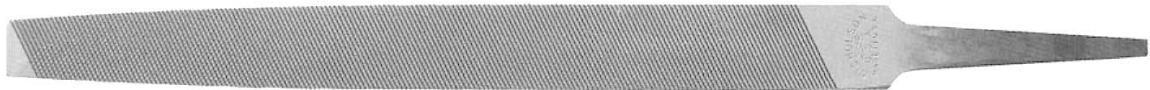
#### Curved-cut

Teeth arranged in curved contours across the file face. The curved-cut file is normally used in automotive body shops for smoothing body panels.

#### Rasp-cut

Series of individual teeth which are formed by a single-pointed tool. This produces a rough cut that is used primarily on wood, hooves, aluminum and lead.

### FLAT FILES



Flat files are used by machinists, machinery builders, ship and engine builders, repair men and others who require rapid removal of metal. They are rectangular in cross section and taper slightly towards point in width. Double-cut on both sides, single-cut on both edges.

ITEM#	SIZE (IN)	CUT
NIC03367	4	Bastard
NIC03466	6	Bastard
NIC03566	8	Bastard
NIC03665	10	Bastard
NIC03764	12	Bastard
NIC03863	14	Bastard
NIC03401	4	Second Cut
NIC03500	6	Second Cut
NIC03599	8	Second Cut
NIC03698	10	Second Cut
NIC03797	12	Second Cut
NIC03896	14	Second Cut
NIC03434	4	Flat
NIC03533	6	Smooth
NIC03632	8	Smooth
NIC03731	10	Smooth
NIC03830	12	Smooth
NIC03929	14	Smooth

### Coarseness

Work to be accomplished, roughing or finishing, will determine type of teeth and coarseness for each application. Most American pattern files are available with 3 grades of cut: bastard-cut, second-cut and smooth-cut, Swiss pattern files are available in seven cuts, 00, 0, 1, 2, 3, 4, 6.

The degree of coarseness is greater in longer files, but differences between bastard, second cut and smooth are proportionate.

