



# Drills for Industrial Maintenance and Repair Applications





Dormer Pramet is your one-stop manufacturer with a comprehensive program of rotary and indexable tooling with more than 150 years of industry experience. Our core offer includes drilling, milling, threading and turning tools for the general engineering sector. Market-leading brands include Precision Twist Drill (PTD), Union Butterfield, Dormer and Pramet.

As a full service supplier, we are committed to assisting our customers in implementing their machining processes efficiently with productivity as our goal.

Since its founding in 1952, the Precision Twist Drill brand of cutting tools has represented both reliability and quality to its extensive customer base. This standard continues with the **PRECISIONLIGHT** program of drills introduced specifically for the MRO (Maintenance, Repair and Overhaul) market and proudly manufactured in the USA.

Delivering affordable reliability to the maintenance and repair professional, the program meets user needs with a broad offering of screw machine, jobber, mechanics length and reduced shank drills. The **PRECISIONLIGHT** program continues to support the one-stop-shop philosophy of Dormer Pramet while carrying on the established tradition of Precision Twist Drill quality and performance.

## **WORK** **LIGHT**

The focus product design within the **PRECISIONLIGHT** program is the **WORKLIGHT**. This unique design is optimized for ease of use and reliability and includes enhanced penetration geometry that improves chip evacuation, allows cutting fluid better access to the point and reduces the effort required to push the drill through the workpiece. The **WORKLIGHT** drill design is offered in five series' 332HD, 333HD, 312SM, 342SDT and 344RS.













# Heavy Duty Screw Machine Length Drills



## 135° Split Point

The short flute and overall length increases their rigidity, which improves hole accuracy and subsequently extends tool life. The Self-Centering 135° Split Point additionally reduces the thrust requirements and minimizes 'walking' particularly on curved surfaces. Recommended for use in portable power tools.

### 311SM - Steam Oxide

for improved abrasion resistance.



### 312SM - Steam & Bronze Oxide

WORK LIGHT abrasion resistance & improved lubricity, enhanced penetration geometry



Drill Sizes				Flute Length	Over-All-Length	Pkg Qty	311SM EDP#	312SM EDP#
Fractional	Wire Gauge	Letter	Decimal					
	N60		0.0400	1/2	1.3/8	12	46480855	
	N59		0.0410	1/2	1.3/8	12	46480856	
	N58		0.0420	1/2	1.3/8	12	46480857	
	N57		0.0430	1/2	1.3/8	12	46480858	
	N56		0.0465	1/2	1.3/8	12	46480859	
	N55		0.0520	5/8	1.5/8	12	46480860	
	N54		0.0550	5/8	1.5/8	12	46480861	
	N53		0.0595	5/8	1.5/8	12	46480862	
1/16			0.0625	5/8	1.5/8	12	46480863	47233779
	N52		0.0635	11/16	1.11/16	12	46480864	
	N51		0.0670	11/16	1.11/16	12	46480865	
	N50		0.0700	11/16	1.11/16	12	46480866	
	N49		0.0730	11/16	1.11/16	12	46480867	
	N48		0.0760	11/16	1.11/16	12	46480868	
5/64			0.0781	11/16	1.11/16	12	46480869	47233780
	N47		0.0785	11/16	1.11/16	12	46480870	
	N46		0.0810	3/4	1.3/4	12	46480871	
	N45		0.0820	3/4	1.3/4	12	46480872	
	N44		0.0860	3/4	1.3/4	12	46480873	
	N43		0.0890	3/4	1.3/4	12	46480874	
	N42		0.0935	3/4	1.3/4	12	46480875	
3/32			0.0937	3/4	1.3/4	12	46480876	47233781
	N41		0.0960	13/16	1.13/16	12	46480877	
	N40		0.0980	13/16	1.13/16	12	46480878	
	N39		0.0995	13/16	1.13/16	12	46480879	
	N38		0.1015	13/16	1.13/16	12	46480880	
	N37		0.1040	13/16	1.13/16	12	46480881	
	N36		0.1065	13/16	1.13/16	12	46480882	
7/64			0.1094	13/16	1.13/16	12	46480883	47233782
	N35		0.1100	7/8	1.7/8	12	46480884	
	N34		0.1110	7/8	1.7/8	12	46480885	
	N33		0.1130	7/8	1.7/8	12	46480886	
	N32		0.1160	7/8	1.7/8	12	46480887	
	N31		0.1200	7/8	1.7/8	12	46480888	
1/8			0.1250	7/8	1.7/8	12	46480889	47233783
	N30		0.1285	15/16	1.15/16	12	46480890	
	N29		0.1360	15/16	1.15/16	12	46480891	
	N28		0.1405	15/16	1.15/16	12	46480892	
9/64			0.1406	15/16	1.15/16	12	46480893	47233784
	N27		0.1440	1"	2.1/16	12	46480894	
	N26		0.1470	1"	2.1/16	12	46480895	
	N25		0.1495	1"	2.1/16	12	46480896	
	N24		0.1520	1"	2.1/16	12	46480897	
	N23		0.1540	1"	2.1/16	12	46480898	
5/32			0.1563	1"	2.1/16	12	46480899	47233785
	N22		0.1570	1.1/16	2.1/8	12	46480900	
	N21		0.1590	1.1/16	2.1/8	12	46480901	
	N20		0.1610	1.1/16	2.1/8	12	46480902	
	N19		0.1660	1.1/16	2.1/8	12	46480903	
	N18		0.1695	1.1/16	2.1/8	12	46480904	





# Heavy Duty Mechanics Length Drills



## 135° Split Point, Steam & Bronze Oxide

Shorter flute and overall length than the 332HD Jobber Length drills for superior rigidity when used in portable drills. Additionally features 3 flats on the shank for tighter chucking particularly in keyless chucks. The Self-Centering 135° Split Point additionally reduces the thrust requirements and minimizes 'walking' particularly on curved surfaces. Functional Steam & Bronze Oxide surface treatment provides both abrasion resistance & improved lubricity.

### 321MD



### 322MD - 3/8" Reduced Shank

The 3/8" diameter reduced shank with flats makes them ideal for portable drilling where the maximum chuck capacity is 3/8"



Drill Sizes		Flute Length	Over-All-Length	Pkg Qty	321MD EDP#	322MD EDP#
Fractional	Decimal					
1/16	0.0625	7/8	1.7/8	12	46480970	
5/64	0.0781	1"	2"	12	46480971	
3/32	0.0937	1.1/4	2.1/4	12	46480972	
7/64	0.1094	1.5/16	2.3/8	12	46480973	
1/8	0.1250	1.7/16	2.1/2	12	46480974	
9/64	0.1406	1.9/16	2.5/8	12	46480975	
5/32	0.1563	1.11/16	2.3/4	12	46480976	
11/64	0.1719	1.13/16	2.7/8	12	46480977	
3/16	0.1875	1.7/8	3"	12	46480978	
13/64	0.2031	1.15/16	3.1/8	12	46480979	
7/32	0.2187	2"	3.1/4	12	46480980	
15/64	0.2344	2.1/16	3.3/8	12	46480981	
1/4	0.2500	2"	3.1/2	12	46480982	
17/64	0.2656	2.1/8	3.5/8	12	46480983	
9/32	0.2813	2.1/4	3.3/4	12	46480984	
19/64	0.2969	2.3/8	3.7/8	12	46480985	
5/16	0.3125	2.1/2	4"	6	46480986	
21/64	0.3281	2.9/16	4.1/16	6	46480987	
11/32	0.3438	2.5/8	4.1/8	6	46480988	
23/64	0.3594	2.11/16	4.3/16	6	46480989	
3/8	0.3750	2.11/16	4.1/4	6	46480990	
25/64	0.3906	2.3/4	4.5/16	6	46480991	
13/32	0.4063	2.13/16	4.3/8	6	46480992	
27/64	0.4219	2.7/8	4.7/16	6	46480993	47233809
7/16	0.4375	2.15/16	4.1/2	6	46480994	47233810
29/64	0.4531	3"	4.5/8	6	46480995	47233811
15/32	0.4687	3.1/8	4.3/4	6	46480996	47233812
31/64	0.4844	3.1/4	4.7/8	6	46480997	47233813
1/2	0.5000	3.3/8	5"	6	46480998	47233814



# Reduced Shank Drills

118° Point, Steam Oxide & Bright

The 1/2" diameter reduced shank makes them ideal for portable drilling and drill presses where the maximum chuck capacity is 1/2". Surface treated with a black steam oxide finish for abrasion resistance and improved coolant adherence.

Not recommended for enlarging existing holes.

## 341SD - 1/2" Shank Diameter, Silver & Deming



Drill Sizes		Flute Length	Over-All-Length	Pkg Qty	341SD EDP#
Fractional	Decimal				
33/64	0.5156	3"	6"	1	46481031
17/32	0.5313	3"	6"	1	46481032
35/64	0.5469	3"	6"	1	46481033
9/16	0.5625	3"	6"	1	46481034
37/64	0.5781	3"	6"	1	46481035
19/32	0.5937	3"	6"	1	46481036
39/64	0.6094	3"	6"	1	46481030
5/8	0.6250	3"	6"	1	46481037
41/64	0.6406	3"	6"	1	46481038
21/32	0.6562	3"	6"	1	46481039
43/64	0.6719	3"	6"	1	46481040
11/16	0.6875	3"	6"	1	46481041
45/64	0.7031	3"	6"	1	46481042
23/32	0.7187	3"	6"	1	46481043
47/64	0.7344	3"	6"	1	46481044
3/4	0.7500	3"	6"	1	46481045
49/64	0.7656	3"	6"	1	46481046
25/32	0.7812	3"	6"	1	46481047
51/64	0.7969	3"	6"	1	46481048
13/16	0.8125	3"	6"	1	46481049
53/64	0.8281	3"	6"	1	46481050
27/32	0.8437	3"	6"	1	46481051
55/64	0.8594	3"	6"	1	46481052
7/8	0.8750	3"	6"	1	46481053
57/64	0.8906	3"	6"	1	46481028
29/32	0.9062	3"	6"	1	46481054
59/64	0.9219	3"	6"	1	46481055
15/16	0.9375	3"	6"	1	46481056
61/64	0.9531	3"	6"	1	46481029
31/32	0.9688	3"	6"	1	46481057
63/64	0.9844	3"	6"	1	46481058
1"	1.0000	3"	6"	1	46481059
1.1/32	1.0312	3"	6"	1	46481060
1.1/16	1.0625	3"	6"	1	46481061
1.3/32	1.0938	3"	6"	1	46481062
1.1/8	1.1250	3"	6"	1	46481063
1.5/32	1.1562	3"	6"	1	46481064
1.3/16	1.1875	3"	6"	1	46481065
1.7/32	1.2187	3"	6"	1	46481066
1.1/4	1.2500	3"	6"	1	46481067
1.5/16	1.3125	3"	6"	1	46481068
1.3/8	1.3750	3"	6"	1	46481069
1.7/16	1.4375	3"	6"	1	46481070
1.1/2	1.5000	3"	6"	1	46481071

# Reduced Shank Drills



## Steam & Bronze Oxide

The 1/2" diameter reduced shank makes them ideal for portable drilling and drill presses where the maximum chuck capacity is 1/2". The Self-Centering 118° Split Point additionally reduces the thrust requirements and minimizes 'walking' particularly on curved surfaces. The functional Steam & Bronze Oxide surface treatment provides both abrasion resistance & improved lubricity.



## 342SDT - 118° Split Point

**WORK LIGHT** 1/2" Shank Diameter, Silver & Deming with Tri-Flats, enhanced penetration geometry

Drill Sizes		Flute Length	Over-All-Length	Pkg Qty	342SDT EDP#
Fractional	Decimal				
33/64	0.5156	3"	6"	1	47233817
17/32	0.5313	3"	6"	1	47233818
35/64	0.5469	3"	6"	1	47233819
9/16	0.5625	3"	6"	1	47233820
37/64	0.5781	3"	6"	1	47233821
19/32	0.5937	3"	6"	1	47233822
39/64	0.6094	3"	6"	1	47233823
5/8	0.6250	3"	6"	1	47233824
41/64	0.6406	3"	6"	1	47233825
21/32	0.6562	3"	6"	1	47233826
43/64	0.6719	3"	6"	1	47233827
11/16	0.6875	3"	6"	1	47233828
45/64	0.7031	3"	6"	1	47233829
23/32	0.7187	3"	6"	1	47233830
47/64	0.7344	3"	6"	1	47233831
3/4	0.7500	3"	6"	1	47233832
49/64	0.7656	3"	6"	1	47233833
25/32	0.7812	3"	6"	1	47233834
51/64	0.7969	3"	6"	1	47233835
13/16	0.8125	3"	6"	1	47233836
53/64	0.8281	3"	6"	1	47233837
27/32	0.8437	3"	6"	1	47233838
55/64	0.8594	3"	6"	1	47233839
7/8	0.8750	3"	6"	1	47233840
57/64	0.8906	3"	6"	1	47233841
29/32	0.9062	3"	6"	1	47233842
59/64	0.9219	3"	6"	1	47233843
15/16	0.9375	3"	6"	1	47233844
61/64	0.9531	3"	6"	1	47233845
31/32	0.9688	3"	6"	1	47233846
63/64	0.9844	3"	6"	1	47233847
1	1.0000	3"	6"	1	47233848



## 344RS - 135° Split Point,

**WORK LIGHT** Heavy Duty, 3/8" shank diameter

Used where maximum chuck capacity is 3/8". Recommended for use in portable drills, enhanced penetration geometry

Drill Sizes		Flute Length	Over-All-Length	Pkg Qty	344RS EDP#
Fractional	Decimal				
25/64	0.3906	3.3/4	5.1/8	1	47233850
13/32	0.4062	3.7/8	5.1/4	1	47233851
27/64	0.4219	3.15/16	5.3/8	1	47233852
7/16	0.4375	4.1/16	5.1/2	1	47233853
29/64	0.4531	4.3/16	5.5/8	1	47233854
15/32	0.4688	4.5/16	5.3/4	1	47233855
31/64	0.4844	4.3/8	5.7/8	1	47233856
1/2	0.5000	4.1/2	6"	1	47233857



# Reduced Shank Drills

Bright Finish

Extends the capacity of a 1/4" & 3/8" drill chuck. Features a short rigid design and 118° split point is for self-centering and ease of penetration. Designed for Aluminum, Low to Medium Carbon Steels, Plastics and Wood.

## 345RSS - 118° Point, Economy Length 1/4" shank diameter



Drill Sizes		Flute Length	Over-All-Length	Pkg Qty	345RSS EDP#
Fractional	Decimal				
5/16	0.31250	2.1/4	4"	1	47233858
3/8	0.37500	2.1/4	4"	1	47233859
7/16	0.43750	2.1/4	4"	1	47233860
1/2	0.50000	2.1/4	4"	1	47233861

## 345RSM - 118° Split Point, Intermediate Length 1/4" shank diameter



Drill Sizes		Flute Length	Over-All-Length	Pkg Qty	345RSM EDP#
Fractional	Decimal				
5/16	0.31250	2.1/2	3.13/16	1	47233862
3/8	0.37500	2.7/8	4.1/4	1	47233863
7/16	0.43750	3.3/8	4.11/16	1	47233864
1/2	0.50000	3.5/8	5.1/16	1	47233865

## 346RS - 118° Point, Jobber Length 3/8" shank diameter



Drill Sizes		Flute Length	Over-All-Length	Pkg Qty	344RS EDP#
Fractional	Decimal				
25/64	0.3906	3.3/4	5.1/2	1	47233866
13/32	0.4062	3.7/8	5.1/4	1	47233867
27/64	0.4219	3.15/16	5.3/8	1	47233868
7/16	0.4375	4.1/16	5.1/2	1	47233869
29/64	0.4531	4.3/16	5.5/8	1	47233870
15/32	0.4688	4.5/16	5.3/4	1	47233871
31/64	0.4844	4.3/8	5.7/8	1	47233872
1/2	0.5000	4.1/2	6"	1	47233873

# Drill Sets



331HDSET	Size	Decimal Size	Pkg Qty	EDP#
135 Degree SP, HD, Black Jobber 29 pc. Set (1/16 - 1/2 x 64ths)	1/16 - 1/2 x 64ths	0.0625 - 0.5000 x 64ths	1	47233629
135 Degree SP, HD, Black Jobber 15 pc. Set (1/16 - 1/2 x 32nds)	1/16 - 1/2 x 32nds	0.0625 - 0.5000 x 32nds	1	47233630

301JDSET	Size	Decimal Size	Pkg Qty	EDP#
118 Degree, GP, Black Jobber 29 pc. Set (1/16 - 1/2 x 64ths)	1/16 - 1/2 x 64ths	0.0625 - 0.5000 x 64ths	1	46481072
118 Degree, GP, Black Jobber 15 pc. Set (1/16 - 1/2 x 32nds)	1/16 - 1/2 x 32nds	0.0625 - 0.5000 x 32nds	1	47233502

332HDSET <b>WORK LIGHT</b>	Size	Decimal Size	Pkg Qty	EDP#
135 Degree SP, HD, Black & Bronze Jobber 29 pc. Set (1/16 - 1/2 x 64ths)	1/16 - 1/2 x 64ths	0.0625 - 0.5000 x 64ths	1	47233746
135 Degree SP, HD, Black & Bronze Jobber 15 pc. Set (1/16 - 1/2 x 32nds)	1/16 - 1/2 x 32nds	0.0625 - 0.5000 x 32nds	1	47233747

333HDSET <b>WORK LIGHT</b>	Size	Decimal Size	Pkg Qty	EDP#
135 Degree SP, HD, TiN Coated Jobber 29 pc. Set (1/16 - 1/2 x 64ths)	1/16 - 1/2 x 64ths	0.0625 - 0.5000 x 64ths	1	47233777

311SMSET	Size	Decimal Size	Pkg Qty	EDP#
135 Degree SP, HD, Black Screw Machine 29 pc. Set (1/16 - 1/2 x 64ths)	1/16 - 1/2 x 64ths	0.0625 - 0.5000 x 64ths	1	47233778

321MDSET	Size	Decimal Size	Pkg Qty	EDP#
135 Degree SP Black & Bronze, HD, Mechanics Length 29 pc. Set (1/16 - 1/2 x 64ths)	1/16 - 1/2 x 64ths	0.0625 - 0.5000 x 64ths	1	46481073
135 Degree SP Black & Bronze, HD, Mechanics Length 15 pc. Set (1/16 - 1/2 x 32nds)	1/16 - 1/2 x 32nds	0.0625 - 0.5000 x 32nds	1	47233808

322MDSET	Size	Decimal Size	Pkg Qty	EDP#
135° SP Black & Bronze, HD, Mechanics Length 29 pc. Set (1/16 - 1/2 x 64ths) $\varnothing 27/64'' - \varnothing 1/2''$ (6 sizes) with 3/8" reduced Shank	1/16 - 1/2 x 64ths	0.0625 - 0.5000 x 64ths	1	47233815

341SDSET	Size	Decimal Size	Pkg Qty	EDP#
118 Degree Point Black & Bright, 1/2" reduced shank, S & D 8 pc. Set	$\varnothing 9/16 - \varnothing 1''$ x 16ths	0.5625 - 1.0000 x 16ths	1	47233816

342SDTSET <b>WORK LIGHT</b>	Size	Decimal Size	Pkg Qty	EDP#
118 Degree SP Black & Bronze, 1/2" reduced shank w/Tri-Flats, S & D 8 pc. Set	$\varnothing 9/16 - \varnothing 1''$ x 16ths	0.5625 - 1.0000 x 16ths	1	47233849



# Terms & Conditions

## Statement of Policy

Dormer, Pramet, Precision and Union Butterfield are trademarks of the Sandvik Group. All prices and specifications are subject to change by Precision Dormer LLC (the "Company") at any time without notice. The most current price list supersedes all previously dated price lists.

Any individual purchases of any products by a distributor shall be governed by the Company's standard terms and conditions of sales located at [www.dormerpramet.com](http://www.dormerpramet.com).

## Warehouse

America's Distribution Center (ADC) in Hebron, KY is the stocking warehouse for the Company's products. There are many benefits offered to our distributors by utilizing the ADC as the primary warehouse. We encourage drop shipment of product directly to our mutual customers. Delivery security on stock standard products is targeted at 96%.

## Payment Terms

The company's standard payment terms are one percent (1%) twenty (20) days, net thirty (30) days. Payments not posted by the 45th day will result in a credit card hold status. Disputed balances in excess of 60 days outstanding will also result in credit hold status. All prices, terms and discounts are subject to change without notice.

## Freight Terms

- All orders are F.O.B. our warehouse.
- Freight prepaid via economical route of our choice on individual orders valued at \$500.00 net billing or more within the continental United States.
- Flat rate shipping program available for orders valued under \$500.00 net.
- Back-orders will be shipped freight prepaid via economical route of our choice, unless requested by consignee for UPS or FedEx collect at the time of the order

Service	Weight (lbs)	Rate	Service	Weight (lbs)	Rate	Service	Weight (lbs)	Rate
Air	1-5	\$12.00	2 <sup>nd</sup> Day	1-5	\$9.00	Ground	1-5	\$5.00
Air	6-15	\$22.00	2 <sup>nd</sup> Day	6-15	\$16.00	Ground	6-15	\$7.00
Air	16+	\$33.00	2 <sup>nd</sup> Day	16+	\$25.00	Ground	16+	\$13.50

- There is a minimum order value of \$50 for orders placed via fax, email or over the phone. There is **no order value minimum** for orders placed through EDI or online through the eShop.
- Within the continental United States, the minimum order requirement will be waived for next day air and second day air orders shipped directly to end users.

## Electronic Ordering Options (Please call 800-877-3745 for more information)

Online ordering through the eShop via [www.dormerpramet.com](http://www.dormerpramet.com)

- This no-charge password-protected web site lets an authorized distributor check stock and price, place orders, track packages and view invoices for standard tools. Ground orders placed by 3:30 p.m. CST will ship same day. Air orders placed by 4:30 p.m. CST will ship same day.

Epicor

- This software package is provided by Epicor for electronic transactions that occur between the distributor's computer system, Epicor and the Company.
- The distributor must be subscribed to Trading Partner Connect (TPx or TPc) before using.

EDI

- This computer to computer transaction system requires programming and set-up time at both the distributor and the Company.
- Distributors must spend \$50,000.00 or more per year with the Company to qualify.
- Current transactions available are: 850 – Purchase Order, 810 – Invoice, 997 – Functional Acknowledgement, 855 – PO Acknowledgement, 856 – Advance Ship Notice.

# SIMPLY RELIABLE

As a professional you can judge the quality of work by just looking at the chip. Our chip is a clean and uncomplicated shape that in itself tells a story. It is a clear and consistent signal and that's why we use it as a symbol for being **Simply Reliable**.

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