

For more information on Drill Bits, see page 2239.

**Drill Bit Blanks**

- Ground finish
- Carbide material
- Dia. tolerance: +0.0000/-0.0005"

These solid carbide drill bit blanks come in standard sizes expressed in fractional inches, which are the most common trade size used for drill bits. They are harder than cobalt steel and high-speed steel drill bit blanks. They provide good wear resistance when drilling into the toughest materials. Machined to create custom drill bits with precise dimensions to suit specific applications. Typically used to check size of a drilled hole or to create gauges, drifts, punches, rollers, locating pins, spindles, or knockout pins.

Decimal Dia. Equivalent	L	Item No.	Decimal Dia. Equivalent	L	Item No.		
1/32"	0.0312	1 1/2"	402Y50	3/16"	0.3125	12"	403C63
1/32"	0.0312	12"	403C19	2 1/4"	0.3281	12"	403C67
3/64"	0.0469	1 1/2"	402Y52	1 1/2"	0.3438	12"	403C69
3/64"	0.0469	12"	403C21	2 3/4"	0.3594	12"	403C73
1/16"	0.0625	1 1/2"	402Y54	3/8"	0.3750	1 1/2"	403A47
1/16"	0.0625	12"	403C23	3/8"	0.3750	6"	402Z48
3/64"	0.0781	1 1/2"	402Y56	2 3/4"	0.3906	12"	403C77
3/64"	0.0781	12"	403C25	2 3/4"	0.4219	12"	403C83
3/32"	0.0938	1 1/2"	402Y58	1/16"	0.4375	2 1/2"	402Z49
3/32"	0.0938	12"	402Y61	7/16"	0.4375	6"	402Z59
1/8"	0.1094	12"	403C29	2 3/4"	0.4531	12"	403C88
1/8"	0.1250	3/4"	403A30	1 1/2"	0.4688	12"	403C90
1/8"	0.1250	1"	402Y69	3 1/4"	0.4844	12"	403C94
3/64"	0.1406	12"	403C35	1/2"	0.5000	1 1/2"	403A49
3/32"	0.1562	1 1/2"	402Y89	1/2"	0.5000	12"	403C96
3/32"	0.1562	12"	403C37	1 1/2"	0.5312	12"	403D01
1 1/64"	0.1719	12"	403C41	9/16"	0.5625	3 1/2"	402Z78
3/16"	0.1875	1"	403A37	9/16"	0.5625	12"	403D03
3/16"	0.1875	12"	403C43	5/8"	0.6250	3"	402Z80
1 3/64"	0.2031	12"	403C47	5/8"	0.6250	12"	403D05
1 5/64"	0.2344	12"	403C51	3/4"	0.7500	7"	403A06
1/4"	0.2500	1"	403A42	3/4"	0.7500	12"	403D13
1/4"	0.2500	12"	403C55	1 3/16"	0.8125	12"	403D15
1 1/64"	0.2656	12"	403C57	7/8"	0.8750	4"	403A13
3/32"	0.2812	12"	403C59	7/8"	0.8750	12"	403D17
1 3/64"	0.2969	12"	403C61	1"	1.0000	4"	403A15
3/16"	0.3125	1 1/4"	403A46	1"	1.0000	12"	403D22



- Additional material and sizes are available on Grainger.com®

**Series 777 Tool Blanks**

- Unfinished
- Carbide material
- Parallelism and flatness tolerances: ±0.020"



Commonly used as wear parts, tools, grinder rests, and appliance parts, these solid C-2 grade medium-grain carbide strips contain 6% to 8% cobalt.

- Minimum grind stock: Thickness: +0.008"; Width: +0.012"; Length: +0.008"
- Additional material and sizes are available on Grainger.com®

Thickness	W	L	Item No.	Thickness	W	L	Item No.
1/32 in	1/16 in	1 in	403F67	1/8 in	1 1/4 in	6 in	403H16
1/32 in	1/16 in	1 1/2 in	403F68	3/32 in	3/8 in	6 in	403H12
3/64 in	1/32 in	1 3/16 in	403F70	3/32 in	1 1/2 in	6 in	403H03
3/64 in	3/32 in	1 in	403F69	3/16 in	3/16 in	12 in	403G73
3/16 in	1 in	6 in	403G22	3/16 in	3/4 in	2 in	403F87
3/64 in	1/8 in	1 1/2 in	403F72	3/16 in	1 in	6 in	403G70
3/32 in	3/8 in	6 in	403G29	1/4 in	1/4 in	12 in	403G99
3/32 in	3/8 in	8 in	403G38	1/4 in	1/2 in	2 in	403G81
1/8 in	1/4 in	1 in	403F89	1/4 in	5/8 in	6 in	403G83
1/8 in	1/4 in	2 1/4 in	403F92	5/16 in	5/16 in	12 in	403G98
1/8 in	3/8 in	6 in	403G57	1/2 in	3/4 in	12 in	403G97
1/8 in	3/4 in	12 in	403G60				



Sharpener 6YB32



**Drill Bit Sharpeners**

**Sharpener**—Easy chuck alignment system for quick, precise sharpening. 110V, 1.75 amp motor produces 20,000 rpm. Long-lasting diamond wheel sharpens standard twist, HSS, TiN, cobalt, carbide, and masonry drills in under 60 sec. 6YB32 and 6YB33 can be used with split point bits. 6YB32 includes carrying case.

**Sharpening Attachment**—Locks into 5 standard angles (88°, 68°, 59°, 49°, and 41°) to quickly sharpen drill bits. Use with ANSI, OSHA, UL Listed standard electric bench or surface grinders.



Sharpening Attachment 3ZH44

Sharpener	Features	Brand	Mfr. Model	Item No.
On-Chuck Alignment, Permanent Magnet Motor, V-Block Chuck Jaws Eliminate Jaw Twisting on Small Bits, Cast Aluminum Point Angle Shuttle, Jaw Guides Eliminate Jaw Twisting on Small Bits, Longer Chuck Jaws Hold Bits More Precisely, Permanent Magnet Motor, Push-to-Stop Drill Point Splitting Port		Drill Doctor	DD350X	6YB34
Adjustable Material Take-Off, Cast Aluminum Point Angle Shuttle, Jaw Guides Eliminate Jaw Twisting on Small Bits, Longer Chuck Jaws Hold Bits More Precisely, Permanent Magnet Motor, Push-to-Stop Drill Point Splitting Port		Drill Doctor	DD500X	6YB33
Adjustable Material Take-Off, Cast Aluminum Point Angle Shuttle, Jaw Guides Eliminate Jaw Twisting on Small Bits, Longer Chuck Jaws Hold Bits More Precisely, Permanent Magnet Motor, Push-to-Stop Drill Point Splitting Port		Drill Doctor	DD750X	6YB32
Automatically Adjusts to the Correct Clearance Angle, For Standard Angles 88°, 68°, 59°, 49°, 41°, Works with 1/8 in to 3/4 in, #1 to #30, A to Z, 3 to 19mm Drill Bits		General Tools	825	3ZH44

  

Type	For Use With Mfr. Model Number	Brand	Mfr. Model	Item No.
<b>Replacement Grinding Wheels</b>				
Standard, Diamond 180 Grit	400, 500, 750	Drill Doctor	SA01326GA	2EJX5
	DD750X, DD500X	Drill Doctor	DA31320GF	2EJX1
Coarse, Diamond 100 Grit	300, 400, 500, 750	Drill Doctor	SA01328GA	2EJX6
	DD750X, DD500X	Drill Doctor	DA31325GF	2EJX2
<b>Replacement Chucks</b>				
Chuck	DD750X, DD500X	Drill Doctor	DA70100PF	2EJX3
		Drill Doctor	DA02105PF	2EJX4



Drill Sharpener V-390 6MVH6



Drill Sharpener XT-3000 6MVH7



**Drill Bit Sharpeners**



For standard conic and split point styles. Drill Sharpener V-390 6MVH6 is for light-duty, intermittent jobs. Drill Sharpener XT-3000 6MVH7 is an advanced manual sharpener for use on a variety of drill sizes and styles. Drill Sharpener with Auto Sharpener XT-3000 6MVK0 performs the same functions as 6MVH7, but automates the drill sharpening process for higher volume requirements.

Table Description	Grinding Wheel Dia. (in.)	Drill Dia./Cap.	Angles Sharpened	Mfr. Model	Item No.
Drill Sharpener V-390	3	1/8"-3/4"	118° to 140°	JVT125GF	6MVH6
Drill Sharpener XT-3000	6	1/8"-1 1/2"	118° to 150°	LEX900	6MVH7
Drill Sharpener w/Auto Sharpener XT-3000	6	1/8" - 1 1/2"	118° to 150°	LEX900A	6MVK0

  

Description	Mfr. Model	Item No.
<b>For Use With No. 6MVH6</b>		
Cubic Boron Nitride Grinding Wheel, 3" Dia., 180 Grit	PP11125GF	6MVK3
Diamond Grinding Wheel, 3" Dia., 180 Grit	PP11115GF	6MVK4
<b>For Use With Nos. 6MVH7/6MVK0</b>		
Cubic Boron Nitride Grinding Wheel, 6" Dia., 100 Grit	PP16060GF	6MVK7
Cubic Boron Nitride Grinding Wheel, 6" Dia., 180 Grit	PP16050GF	6MVK5
Diamond Grinding Wheel, 6" Dia., 180 Grit	PP16052GF	6MVK6
<b>LEX200, LEX250, Mfr. No. XT-3000, Required with Attachments: Mfr. No. LEX150, XT-3000 Auto</b>		
Drill Bit/End Mill Sharpener Part	LEX100	6MVJ0
<b>Mfr. No. XT-3000</b>		
Drill Bit/End Mill Sharpener Part, 3-21mm XT	LEX500	6MVJ9
<b>Mfr. No. XT-3000, Mfr. No. XT-3000 Auto, Must Be Used with X-Y Table Mfr. No. LEX100</b>		
Drill Bit/End Mill Sharpener Part, For Drill Bits and End Mills	LEX150	6MVJ1 *
<b>Mfr. No. XT-3000, XT-3000 Auto</b>		
Drill Bit/End Mill Sharpener Part, XT-3000	LEX300	6MVJ4

\* Requires LEX100.