

# CHAMPION

## 18" Longboy Drills

List No. 1800

118° Point / 13" Flute Length / Bright Finish /  
Straight Shank / HSS

**Description:** Designed for general purpose drilling in a wide range of materials in deep hole applications where a maximum 13" flute length is required.

Drills 17/32" and larger will not fit into 1/2" chucks.



| EDP No./ Diameter | Decimal Equivalent | Flute Length | Overall Length |
|-------------------|--------------------|--------------|----------------|
| 1800-3/16         | .1875              | 13           | 18             |
| 1800-7/32         | .2188              | 13           | 18             |
| 1800-1/4          | .2500              | 13           | 18             |
| 1800-9/32         | .2812              | 13           | 18             |
| 1800-5/16         | .3125              | 13           | 18             |
| 1800-11/32        | .3438              | 13           | 18             |
| 1800-3/8          | .3750              | 13           | 18             |
| 1800-13/32        | .4062              | 13           | 18             |
| 1800-7/16         | .4375              | 13           | 18             |
| 1800-15/32        | .4688              | 13           | 18             |
| 1800-1/2          | .5000              | 13           | 18             |
| 1800-17/32        | .5312              | 13           | 18             |
| 1800-9/16         | .5625              | 13           | 18             |
| 1800-5/8          | .6250              | 13           | 18             |
| 1800-41/64        | .6406              | 13           | 18             |
| 1800-21/32        | .6562              | 13           | 18             |
| 1800-43/64        | .6719              | 13           | 18             |
| 1800-11/16        | .6875              | 13           | 18             |
| 1800-45/64        | .7031              | 13           | 18             |

| EDP No./ Diameter | Decimal Equivalent | Flute Length | Overall Length |
|-------------------|--------------------|--------------|----------------|
| 1800-23/32        | .7188              | 13           | 18             |
| 1800-47/64        | .7344              | 13           | 18             |
| 1800-3/4          | .7500              | 13           | 18             |
| 1800-49/64        | .7656              | 13           | 18             |
| 1800-25/32        | .7812              | 13           | 18             |
| 1800-51/64        | .7969              | 13           | 18             |
| 1800-13/16        | .8125              | 13           | 18             |
| 1800-53/64        | .8281              | 13           | 18             |
| 1800-27/32        | .8438              | 13           | 18             |
| 1800-55/64        | .8594              | 13           | 18             |
| 1800-7/8          | .8750              | 13           | 18             |
| 1800-57/64        | .8906              | 13           | 18             |
| 1800-29/32        | .9062              | 13           | 18             |
| 1800-59/64        | .9219              | 13           | 18             |
| 1800-15/16        | .9375              | 13           | 18             |
| 1800-61/64        | .9531              | 13           | 18             |
| 1800-31/32        | .9688              | 13           | 18             |
| 1800-63/64        | .9844              | 13           | 18             |
| 1800-1            | 1.0000             | 13           | 18             |

# CHAMPION

## 1/2" Shank Longboy Drills

List No. 1212

118° Point / Bright Finish / HSS

**Description:** 1/2" reduced shank for use where chuck capacity is limited to 1/2".

**Application:** Low carbon steels, alloyed steels, steel drop forgings, grey cast iron, wood.



| EDP No. / Diameter | Decimal Equivalent | Flute Length | Overall Length |
|--------------------|--------------------|--------------|----------------|
| 1212-17/32         | .5312              | 9            | 12             |
| 1212-9/16          | .5625              | 9            | 12             |
| 1212-5/8           | .6250              | 9            | 12             |
| 1212-3/4           | .7500              | 9            | 12             |
| 1212-7/8           | .8750              | 9            | 12             |
| 1212-1             | 1.0000             | 9            | 12             |



Flute milling of large diameter twist drills