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HSS drill, 135° split point

The standard twist drill for aluminium.

Specification

Item	Value
Type	Twist drill
Point	135°, split point
Material	High speed steel
Use for	Aluminium alloy sheet. Also 135° for stainless (H-31 p. 4-83)
Do not use for	—

A dash means the sources do not state it.

Sizes

Size	For	Inches (official)	mm (converted, not official)	Nearest metric alternative, mm
3/32 in	Work, 3/32 rivet	0.09375 in	2.381	2.40
#40	Final, 3/32 rivet	0.0980 in	2.489	2.50
1/8 in	Work, 1/8 rivet	0.1250 in	3.175	3.15 or 3.20
#30	Final, 1/8 rivet	0.1285 in	3.264	3.25
5/32 in	Work, 5/32 rivet	0.15625 in	3.969	3.95
#21	Final, 5/32 rivet	0.1590 in	4.039	4.05
3/16 in	Work, 3/16 rivet	0.1875 in	4.763	4.75
#11	Final, 3/16 rivet	0.1910 in	4.851	4.85
1/4 in	Work, 1/4 rivet	0.2500 in	6.350	6.35
F	Final, 1/4 rivet	0.2570 in	6.528	6.55

Exact mm = inches × 25.4. The alternative is the nearest 0.05 mm step: commonly used where inch drills cannot be bought, NOT the official drill. The manual sets the tolerance.

Notes

- **Inch values are official.** Aviation is designed and worked in inches. Millimetres are converted and are not official; where one is shown, the metric drill is the nearest alternative, not the official drill.

SOURCES · FAA-H-8083-31, AMT Handbook, Airframe, Volume 1

SCAN · OPEN THIS DATA SHEET
theaviationpoint.com/parts/drills/hss-135-split-point/

Reference data. The aircraft manufacturer's documentation (SRM / IPC) takes precedence.