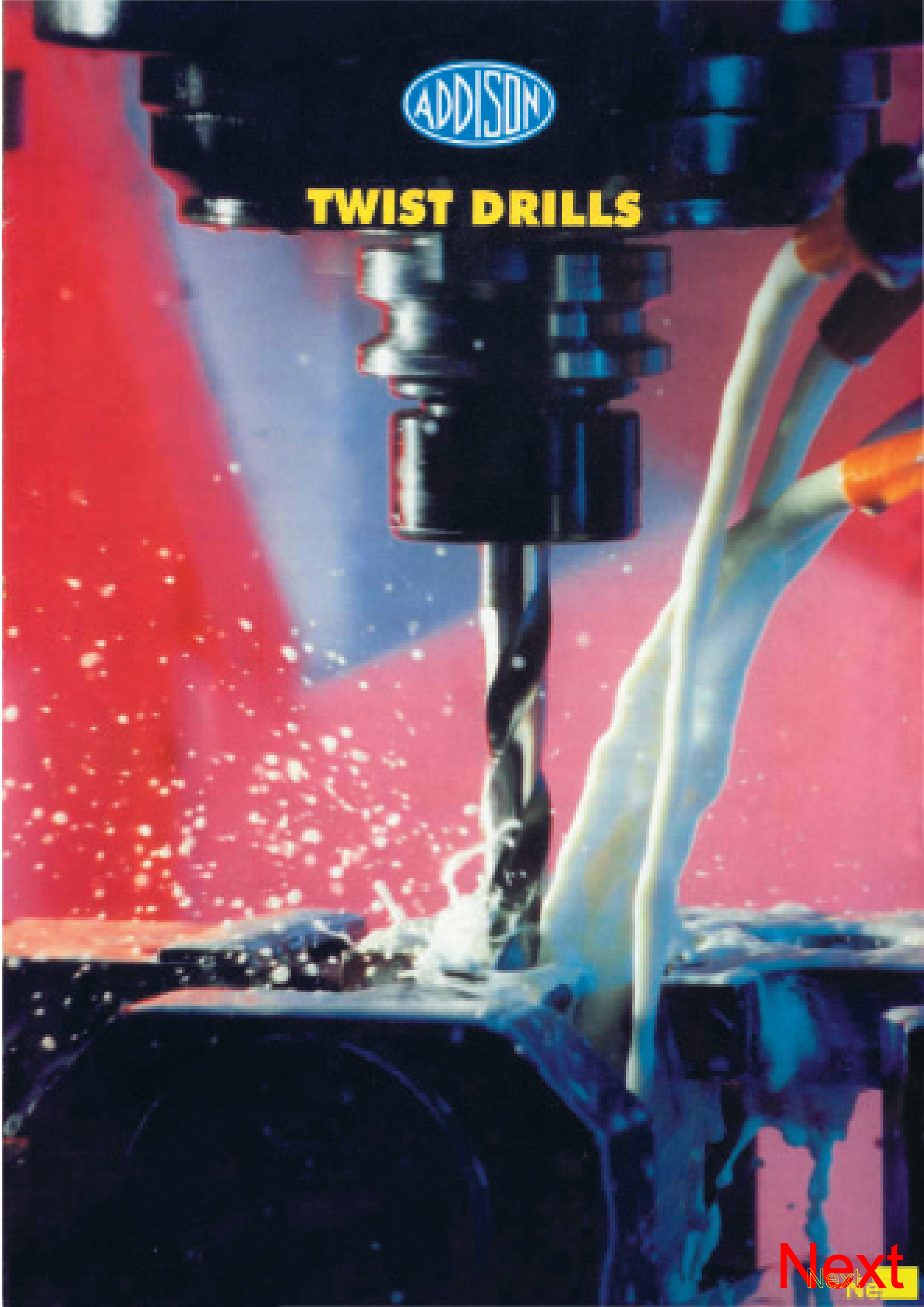




# TWIST DRILLS



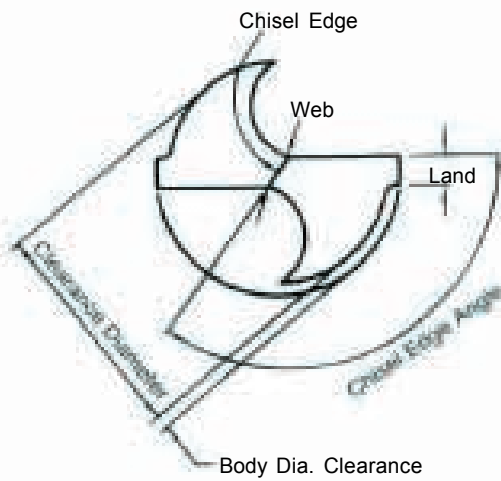
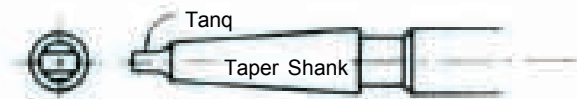
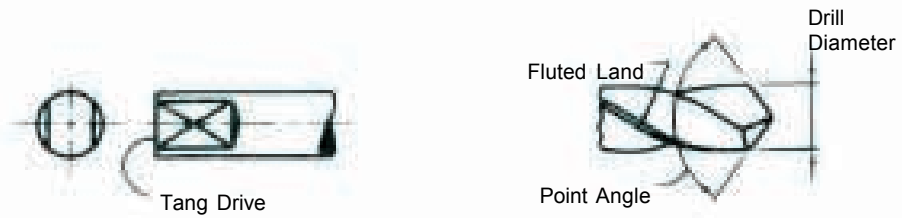
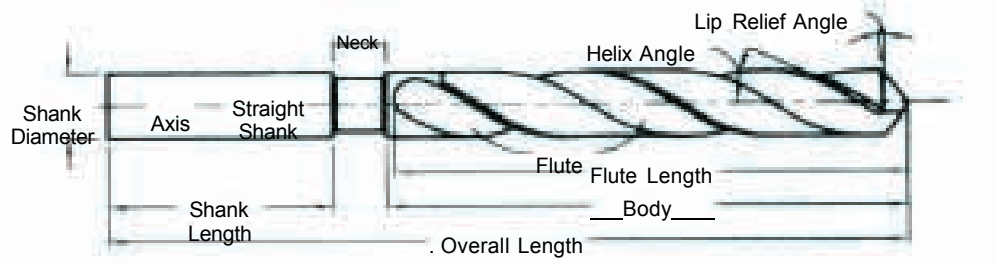
Next  
Next

# CONTENTS

	Page No.
Drill-Nomenclature	6
Parallel Shank Twist Drills - Jobber Series	7
Parallel Shank Twist Drills - Stub Series	12
Parallel Shank Twist Drills - Long Series	15
Parallel Shank Twist Drills - Extra Long Series	19
Silver and Deming Drills	20
Taper Shank Twist Drills	22
Taper Shank Twist Drills - Long Series	26
Taper Shank Twist Drills - Extra Long Series	30
Taper Shank Core Drills	35
Centre Drills	37
Subland Drills - Parallel Shank	41
Subland Drills - Morse Tape Shank	43



# DRILL - NOMENCLATURE





## High Speed Steel PARALLEL SHANK TWIST DRILLS Jobber Series

Specifications conform to  
IS 5101-1991  
ISO 235-1980  
DIN 338-1978  
BS 328 : Part 1 : 1986  
Dimensions in mm / inch



Diameter h8			Flute Length	Overall Length
mm	inch	Number Series		
0.30	-		3	19
0.40	1/64		5	20
0.50	-		6	22
0.60	-		7	24
0.70	-		9	28
0.80	1/32	68, 67, 66	10	30
0.90	-	65, 64, 63	11	32
1.00	-	62, 61, 60, 59	12	34
1.10	-	58, 57	14	36
1.20	3/64	56	16	38
1.30	-	55	16	38
1.40	-	54	18	40
1.50			18	40
1.60	1/16	53, 52	20	43
1.70			20	43
1.80		51, 50	22	46
1.90		49	22	46
2.00	5/64	48, 47	24	49
2.10		46, 45	24	49
2.20		44	27	53
2.30		43	27	53
2.40	3/32	42, 41	30	57
2.50		40, 39	30	57
2.60		38, 37	30	57
2.70		36	33	61

Diameter h8			Flute Length	Overall Length
mm	inch	Number Series		
2.80	7/64	35, 34	33	61
2.90		33, 32	33	61
3.00			33	61
3.10		31	36	65
3.20	1/8		36	65
3.30		30	36	65
3.40			39	70
3.50		29	39	70
3.60	9/64	28	39	70
3.7		27, 26	39	70
3.80		25	43	75
3.90		24, 23	43	75
4.00	5/32	22, 21	43	75
4.10		20	43	75
4.20	5/32	19	43	75
4.30		18	47	80
4.40	11/64	17	47	80
4.50		16	47	80
4.60		15, 14	47	80
4.70		13	47	80
4.80	3/16	12	52	86
4.90		11, 10	52	86
5.00		9	52	86
5.10		8, 7	52	86
5.20	13/64	6, 5	52	86

A drill having two helical flutes and a parallel shank of approximately the same diameter as the cutting end.

Type 'N' Drills shall be supplied unless otherwise specified.



# High Speed Steel PARALLEL SHANK TWIST DRILLS Jobber Series

Specifications conform to  
IS 5101-1991  
ISO 235-1980  
DIN 338-1978  
BS 328 : Part 1 : 1986  
Dimensions in mm / inch



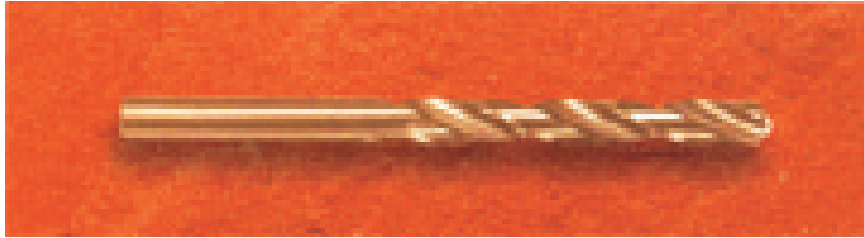
Diameter h8			Flute Length	Overall Length
mm	inch	Number & Letter Series		
5.30	-	-	52	86
5.40	-	4,3	57	93
5.50	-	-	57	93
5.60	7/32	2	57	93
5.70	-	-	57	93
5.80	-	1	57	93
5.90	-	A	57	93
6.00	15/64	-	57	93
6.10	-	B, C	63	101
6.20	-	D	63	101
6.30	-	-	63	101
6.40	1/4	E	63	101
6.50	-	F	63	101
6.60	-	G	63	101
6.70	-	-	63	101
6.80	17/64	H	69	109
6.90	-	I	69	109
7.00	-	J	69	109
7.10	9/32	K	69	109
7.20	-	-	69	109
7.30	-	-	69	109
7.40	-	L	69	109
7.50	-	M	69	109
7.60	19/64	-	75	117
7.70	-	N	75	117
7.80	-	-	75	117
7.90	5/16	-	75	117
8.00	-	O	75	117
8.10	-	-	75	117
8.20	-	P	75	117
8.30	21/64	-	75	117
8.40	-	Q	75	117
8.50	-	-	75	117

Diameter h8			Flute Length	Overall Length
mm	inch	Number & Letter Series		
8.60	-	R	81	125
8.70	11/32	-	81	125
8.80	-	S	81	125
8.90	-	-	81	125
9.00	-	-	81	125
9.10	23/64	T	81	125
9.20	-	-	81	125
9.30	-	U	81	125
9.40	-	-	81	125
9.50	-	-	81	125
9.60	3/8	V	87	133
9.70	-	-	87	133
9.80	-	w	87	133
9.90	25/64	-	87	133
10.00	-	-	87	133
10.10	-	X	87	133
10.20	-	-	87	133
10.30	13/32	Y	87	133
10.40	-	-	87	133
10.50	-	Z	87	133
10.60	-	-	87	133
10.70	27/64	-	94	142
10.80	-	-	94	142
10.90	-	-	94	142
11.00	-	-	94	142
11.10	7/16	-	94	142
11.20	-	-	94	142
11.30	-	-	94	142
11.40	-	-	94	142
11.50	29/64	-	94	142
11.60	-	-	94	142
11.70	-	-	94	142
11.80	-	-	94	142



**High Speed Steel**  
**PARALLEL SHANK TWIST DRILLS**  
**Jobber Series**

Specifications conform to  
 IS 5101-1991  
 ISO 235-1980  
 DIN 338-1978  
 BS 328 : Part 1 : 1986  
 Dimensions in mm / inch



Diameter h8		Flute Length	Overall Length
mm	inch		
11.90	15/32	101	151
12.00	-	101	151
12.10	-	101	151
12.20	-	101	151
12.30	31/64	101	151
12.40	-	101	151
12.50	-	101	151
12.60	-	101	151
12.70	1/2	101	151
12.80	-	101	151
12.90	-	101	151
13.00	-	101	151
13.10	33/64	101	151
13.20	-	101	151
13.30	-	108	160
13.40	-	108	160
13.50	17/32	108	160

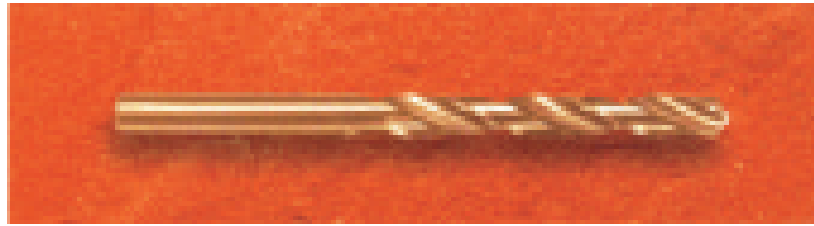
Diameter h8		Flute Length	Overall Length
mm	inch		
13.60	-	108	160
13.70	-	108	160
13.80	-	108	160
13.90	35/64	108	160
14.00	-	108	160
14.25	9/16	114	169
14.50	-	114	169
14.75	37/64	114	169
15.00	-	114	169
15.25	19/32	120	178
15.50	39/64	120	178
15.75	-	120	178
16.00	5/8	120	178
17.00	-	125	184
18.00	11/16	130	191
19.00	-	135	198
20.00	3/4	140	205



# High Speed Steel STRAIGHT SHANK TWIST DRILLS Jobbers Length

Specifications conform to  
ASME B94. 11m-1993

Dimensions in mm / inch



Diameter			Flute Length	Overall Length
Fraction	Number Series	mm		
-	-	0.3	2.4	19
1/64	-	0.4	5.0	19
-	-	0.5	5.0	22
-	-	0.6	8.0	29
-	-	0.7	10.0	32
1/32	68, 67, 66	0.8	13.0	35
-	65,64,63,62	0.9	16.0	38
-	61,60,59,58	1.0	17.0	41
3/64	57,56	1.1	19.0	44
-	-	1.2	22.0	48
-	55	1.3	22.0	48
-	54	1.4	22.0	48
-	53	1.5	22.0	48
1/16	52	1.6	22.0	48
-	51	1.7	25.0	51
-	50	1.8	25.0	51
-	49,48	1.9	25.0	51
5/64	47	2.0	25.0	51
-	46,45,44	2.1	29.0	54
-	-	2.2	32.0	57
3/32	43,42	2.3	32.0	57
-	41	2.4	35.0	60
-	40,39	2.5	35.0	60
-	38,37	2.6	37.0	64
-	36	2.7	37.0	64
7/64	35,34,33	2.8	38.0	67
-	32	2.9	41.0	70
-	31	3.0	41.0	70
-	-	3.1	41.0	70
1/8	30	3.2	41.0	70
-	-	3.3	44.0	73
-	29	3.4	44.0	73
9/64	28	3.5	44.0	73

Diameter			Flute Length	Overall Length
Fraction	Number & Letter Series	mm		
-	-	3.6	48	76
-	27,26	3.7	48	76
-	25	3.8	48	76
5/32	24,23,22	3.9	51	79
-	21	4.0	54	83
-	20	4.1	54	83
-	19	4.2	54	83
11/64	18	4.3	54	83
-	17	4.4	56	86
-	16	4.5	56	86
-	15,14	4.6	56	86
-	13	4.7	59	89
3/16	12,11	4.8	59	89
-	10	4.9	62	92
-	9	5.0	62	92
13/64	8,7	5.1	62	92
-	6,5	5.2	64	95
-	4	5.3	64	95
-	3	5.4	64	95
7/32	-	5.5	64	95
-	2	5.6	67	98
-	-	5.7	67	98
-	1	5.8	67	98
15/64	A	5.9	67	98
-	B	6.0	70	102
-	C	6.1	70	102
-	D	6.2	70	102
1/4	E	6.3	70	102
-	-	6.4	73	105
-	F	6.5	73	105
-	G	6.6	73	105
17/64	-	6.7	73	105
-	H	6.8	73	105



# High Speed Steel STRAIGHT SHANK TWIST DRILLS Jobbers Length

Specifications conform to  
ASME B94.11M-1993

Dimensions in mm / inch



Diameter			Flute Length	Overall Length
Fraction	Letter Series	mm		
-	I	6.9	73	105
-	J	7.0	73	105
9/32	K	7.1	75	108
-	-	7.2	75	108
-	L	7.3	75	108
-	-	7.4	78	111
19/64	M	7.5	78	111
-	N	7.6	78	111
-	-	7.7	81	114
-	-	7.8	81	114
5/16	-	7.9	81	114
-	O	8.0	81	114
-	-	8.1	84	117
-	P	8.2	84	117
21/64	-	8.3	84	117
-	Q	8.4	87	121
-	-	8.5	87	121
-	R	8.6	87	121
11/32	-	8.7	87	121
-	S	8.8	89	124
-	-	8.9	89	124
-	T	9.0	89	124
23/64	-	9.1	89	124
-	-	9.2	92	127
-	U	9.3	92	127
-	-	9.4	92	127
3/8	V	9.5	92	127
-	-	9.6	95	130
-	-	9.7	95	130
-	w	9.8	95	130
25/64	-	9.9	95	130
-	X	10.0	95	130

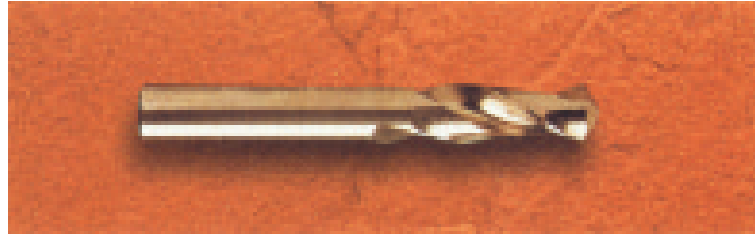
Diameter			Flute Length	Overall Length
Fraction	Letter Series	mm		
13/32	Y	10.20	98	133
-	Z	10.50	98	133
27/64	-	-	100	137
-	-	10.80	103	140
7/16	-	11.00	103	140
-	-	11.20	106	143
29/64	-	11.50	106	143
15/32	-	11.80	110	146
-	-	12.00	111	149
31/64	-	12.20	111	149
-	-	12.50	114	152
1/2	-	12.80	114	152
-	-	13.00	114	152
33/64	-	13.20	122	168
17/32	-	13.50	122	168
35/64	-	13.80	122	168
-	-	14.00	122	168
9/16	-	14.25	122	168
37/64	-	14.50	122	168
-	-	14.75	132	181
19/32	-	15.00	132	181
-	-	15.25	132	181
39/64	-	15.50	132	181
5/8	-	15.75	132	181
-	-	16.00	132	181
41/64	-	16.25	132	181
21/32	-	16.50	132	181
-	-	16.75	143	194
43/64	-	17.00	143	194
-	-	17.25	143	194
11/16	-	17.50	143	194





## High Speed Steel PARALLEL SHANK TWIST DRILLS Stub Series

Specifications conform to  
 IS 5100-1969  
 ISO 235-1980  
 DIN 1897-1984  
 BS 328 : Part 1 : 1986  
 Dimensions in mm / inch



Diameterh8		Flute Length	Overall Length
mm	inch		
1.00	-	6	26
1.20	3/64	8	30
1.50	-	9	32
-	1/16	10	34
1.80	-	11	36
2.00	5/64	12	38
2.20	-	13	40
2.50	3/32	14	43
2.80	7/64	16	46
3.00	-	16	46
3.20	1/8	18	49
3.50	9/64	20	52
3.80	-	22	55
4.00	5/32	22	55
4.20	-	22	55
4.50	11/64	24	58
4.80	3/16	26	62
5.00	-	26	62
5.20	13/64	26	62
5.50	7/32	28	66
5.80	-	28	66
6.00	15/64	28	66

Diameterh8		Flute Length	Overall Length
mm	inch		
6.20	-	31	70
6.50	1/4	31	70
6.80	17/64	34	74
7.00	-	34	74
7.20	9/32	34	74
7.50	-	34	74
7.80	19/64	37	79
8.00	5/16	37	79
8.20	21/64	37	79
8.50	-	37	79
8.80	11/32	40	84
9.00	-	40	84
9.20	23/64	40	84
9.50	-	40	84
9.80	3/8	43	89
10.00	25/64	43	89
10.20	13/32	43	89
10.50	-	43	89
10.80	27/64	47	95
11.00	-	47	95
11.20	7/16	47	95
11.50	29/64	47	95

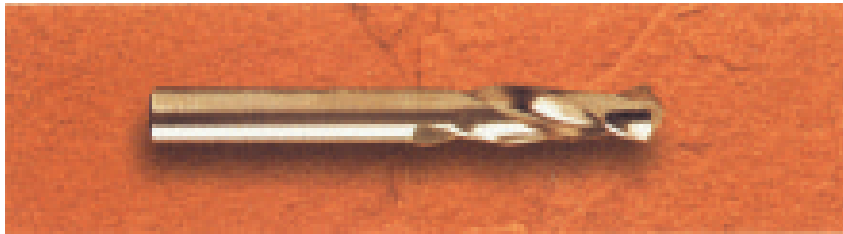
A shortened form of parallel shank jobber series twist drill, the reduction in length being in the flute length.

Type 'N' Drills shall be supplied unless otherwise specified.



## High Speed Steel PARALLEL SHANK TWIST DRILLS Stub Series

Specifications conform to  
IS 5100-1969  
ISO 235-1980  
DIN 1897-1984  
BS 328 : Part 1 : 1986  
Dimensions in mm / inch



Diameter h8		Flute Length	Overall Length
mm	inch		
11.80	-	47	95
12.00	15/32	51	102
12.20	31/64	51	102
12.50	-	51	102
12.80	1/2	51	102
13.00	33/64	51	102
13.20	-	51	102
13.50	17/32	54	107
13.80	35/64	54	107
14.00	-	54	107
14.25	9/16	56	111
14.50	-	56	111
14.75	37/64	56	111
15.00	-	56	111
15.25	19/32	58	115
15.50	39/64	58	115
15.75	5/8	58	115
16.00	-	58	115
16.25	41/64	60	119
16.50	-	60	119
16.75	21/32	60	119
17.00	-	60	119
17.25	43/64	62	123
17.50	11/16	62	123
17.75	45/64	62	123
18.00	-	62	123
18.25	23/32	64	127
18.50	-	64	127
18.75	47/64	64	127
19.00	-	64	127

Diameter h8		Flute Length	Overall Length
mm	inch		
19.25	3/4	66	131
19.50	49/64	66	131
19.75	25/32	66	131
20.00	-	66	131
20.25	51/64	68	136
20.50	-	68	136
20.75	13/16	68	136
21.00	53/64	68	136
21.25	-	70	141
21.50	27/32	70	141
21.75	55/64	70	141
22.00	-	70	141
22.25	7/8	70	141
22.50	-	72	146
22.75	57/64	72	146
23.00	29/32	72	146
23.25	-	72	146
23.50	59/64	72	146
23.75	15/16	75	151
24.00	-	75	151
24.25	61/64	75	151
24.50	31/32	75	151
24.75	-	75	151
25.00	-	75	151
25.25	63/64	78	156
25.50	1	78	156
25.75	-	78	156
26.00	-	78	156
26.25	1.1/32	78	156
26.50	-	78	156



## High Speed Steel PARALLEL SHANK TWIST DRILLS Stub Series

Specifications conform to  
IS 5100-1969  
ISO 235-1980  
DIN1897-1984  
BS 328 : Part 1 : 1986  
Dimensions in mm / inch



Diameter h8		Flute Length	Overall Length
mm	inch		
26.75	-	81	162
27.00	1.1/16	81	162
27.25	-	81	162
27.50	-	81	162
27.75	1.3/32	81	162
28.00	-	81	162
28.25	-	84	168
28.50	1.1/8/	84	168
28.75	-	84	168
29.00	-	84	168
29.25	-	84	168
29.50	1.5/32	84	168
29.75	-	84	168
30.00	-	84	168
30.25	1.3/16	87	174
30.50	-	87	174
30.75	-	87	174
31.00	1.7/32	87	174
31.25	-	87	174

Diameter h8		Flute Length	Overall Length
mm	inch		
31.50	-	87	174
31.75	1.1/4	90	180
32.00	-	90	180
32.50	1.9/32	90	180
33.00	-	90	180
33.50	1.5/16	90	180
34.00	1.11/32	93	186
34.50	-	93	186
35.00	1.3/8	93	186
35.50	-	93	186
36.00	1.13/32	96	193
36.50	1.7/16	96	193
37.00	-	96	193
37.50	1.15/32	96	193
38.00	1.1/2	100	200
38.50	-	100	200
39.00	-	100	200
39.50	-	100	200
40.00	-	100	200



## High Speed Steel PARALLEL SHANK TWIST DRILLS Long Series

Specifications conform to  
IS 5102-1969  
ISO 494-1975  
DIN 340-1978  
BS 328 : Part 1 : 1986  
Dimensions in mm / inch



Diameter h8		Flute Length	Overall Length
mm	inch		
1.00	-	33	56
1.10	-	37	60
1.20	3/64	41	65
1.30	-	41	65
1.40	-	45	70
1.50	-	45	70
1.60	1/16	50	76
1.70	-	50	76
1.80	-	53	80
1.90	-	53	80
2.00	5/64	56	85
2.10	-	56	85
2.20	-	59	90
2.30	-	59	90
2.40	3/32	62	95
2.50	-	62	95
2.60	-	62	95
2.70	-	66	100
2.80	7/64	66	100
2.90	-	66	100
3.00	-	66	100

Diameter h8		Flute Length	Overall Length
mm	inch		
3.10	-	69	106
3.20	1/8	69	106
3.30	-	69	106
3.40	-	73	112
3.50	-	73	112
3.60	9/64	73	112
3.70	-	73	112
3.80	-	78	119
3.90	-	78	119
4.00	5/32	78	119
4.10	-	78	119
4.20	-	78	119
4.30	-	82	126
4.40	11/64	82	126
4.50	-	82	126
4.60	-	82	126
4.70	-	82	126
4.80	3/16	87	132
4.90	-	87	132
5.00	-	87	132
5.10	-	87	132

A lengthened form of the parallel shank jobber series twist drill, the increase in length being in the flute length.

Type 'N' Drills shall be supplied unless otherwise specified.



# High Speed Steel PARALLEL SHANK TWIST DRILLS Long Series

Specifications conform to  
IS 5102-1969  
ISO 494-1975  
DIN 340-1978  
BS 328 : Part 1 : 1986  
Dimensions in mm / inch



Diameter h8		Flute Length	Overall Length
mm	inch		
5.20	13/64	87	132
5.30	-	87	132
5.40	-	91	139
5.50	-	91	139
5.60	7/32	91	139
5.70	-	91	139
5.80	-	91	139
5.90	-	91	139
6.00	15/64	91	139
6.10	-	97	148
6.20	-	97	148
6.30	-	97	148
6.40	1/4	97	148
6.50	-	97	148
6.60	-	97	148
6.70	-	97	148
6.80	17/64	102	156
6.90	-	102	156
7.00	-	102	156
7.10	9/32	102	156
7.20	-	102	156
7.30	-	102	156
7.40	-	102	156
7.50	-	102	156
7.60	19/64	109	165
7.70	-	109	165
7.80	-	109	165
7.90	5/16	109	165
8.00	-	109	165
8.10	-	109	165

Diameter h8		Flute Length	Overall Length
mm	inch		
8.20	-	109	165
8.30	21/64	109	165
8.40	-	109	165
8.50	-	109	165
8.60	-	115	175
8.70	11/32	115	175
8.80	-	115	175
8.90	-	115	175
9.00	-	115	175
9.10	23/64	115	175
9.20	-	115	175
9.30	-	115	175
9.40	-	115	175
9.50	-	115	175
9.60	3/8	121	184
9.70	-	121	184
9.80	-	121	184
9.90	25/64	121	184
10.00	-	121	184
10.10	-	121	184
10.20	-	121	184
10.30	13/32	121	184
10.40	-	121	184
10.50	-	121	184
10.60	-	121	184
10.70	27/64	128	195
10.80	-	128	195
10.90	-	128	195
11.00	-	128	195
11.10	7/16	128	195



## High Speed Steel PARALLEL SHANK TWIST DRILLS Long Series

Specifications conform to  
IS 5102-1969  
ISO 494-1975  
DIN 340-1978  
BS 328 : Part 1 : 1986  
Dimensions in mm / inch



Diameter h8		Flute Length	Overall Length
mm	inch		
11.20	-	128	195
11.30	-	128	195
11.40	-	128	195
11.50	29/64	128	195
11.60	-	128	195
11.70	-	128	195
11.80	-	128	195
11.90	15/32	134	205
12.00	-	134	205
12.10	-	134	205
12.20	-	134	205
12.30	31/64	134	205
12.40	-	134	205
12.50	-	134	205
12.60	-	134	205
12.70	1/2	134	205
12.80	-	134	205
12.90	-	134	205
13.00	-	134	205
13.10	33/64	134	205
13.20	-	134	205
13.30	-	140	214
13.40	-	140	214
13.50	17/32	140	214
13.60	-	140	214
13.70	-	140	214
13.80	-	140	214
13.90	35/64	140	214
14.00	-	140	214
14.25	9/16	144	220

Diameter h8		Flute Length	Overall Length
mm	inch		
14.50	-	144	220
14.75	37/64	144	220
15.00	-	144	220
15.25	19/32	149	227
15.50	39/64	149	227
15.75	-	149	227
16.00	5/8	149	227
16.25	41/64	154	235
16.50	-	154	235
16.75	21/32	154	235
17.00	-	154	235
17.25	43/64	158	241
17.50	11/16	158	241
17.75	45/64	158	241
18.00	-	158	241
18.25	23/32	162	247
18.50	-	162	247
18.75	47/64	162	247
19.00	-	162	247
19.25	3/4	166	254
19.50	49/64	166	254
19.75	25/32	166	254
20.00	-	166	254
20.25	51/64	171	261
20.50	-	171	261
20.75	13/16	171	261
21.00	53/64	171	261
21.25	-	176	268
21.50	27/32	176	268
21.75	55/64	176	268



## High Speed Steel PARALLEL SHANK TWIST DRILLS Long Series

Specifications conform to  
IS 5102-1969  
ISO 494-1975  
DIN 340-1978  
BS 328 : Part 1 : 1986  
Dimensions in mm / inch



Diameter h8		Flute Length	Overall Length
mm	inch		
22.00	-	176	268
22.25	7/8	176	268
22.50	-	180	275
22.75	57/64	180	275
23.00	29/32	180	275
23.25	-	180	275
23.50	59/64	180	275
23.75	15/16	185	282
24.00	-	185	282
24.25	61/64	185	282
24.50	31/32	185	282
24.75	-	185	282
25.00	-	185	282
25.25	63/64	190	290
25.50	1	190	290
25.75	-	190	290
26.00	-	190	290
26.25	1.1/32	190	290
26.50	-	190	290
26.75	-	195	298

Diameter h8		Flute Length	Overall Length
mm	inch		
27.00	1.1/16	195	298
27.25	-	195	298
27.50	-	195	298
27.75	1.3/32	195	298
28.00	-	195	298
28.25	-	201	307
28.50	1.1/8	201	307
28.75	-	201	307
29.00	-	201	307
29.25	-	201	307
29.50	1.5/32	201	307
29.75	-	201	307
30.00	-	201	307
30.25	1.3/16	207	316
30.50	-	207	316
30.75	-	207	316
31.00	1.7/32	207	316
31.25	-	207	316
31.50	-	207	316



High Speed Steel  
**PARALLEL SHANK TWIST DRILLS**  
 Extra Long Series

Specifications conform to  
 IS 7823 -1983  
 DIN 1869-1978

Dimensions in mm



Diameter h8	SERIES 1		SERIES 2		SERIES 3	
	Flute Length	Overall Length	Flute Length	Overall Length	Flute Length	Overall Length
3.0	100	150	130	190		
3.5	115	165	145	210	180	265
4.0	120	175	150	220	190	280
4.5	125	185	160	235	200	295
5.0	135	195	170	245	210	315
5.5	140	205	180	260	225	330
6.0	140	205	180	260	225	330
6.5	150	215	190	275	235	350
7.0	155	225	200	290	250	370
7.5	155	225	200	290	250	370
8.0	165	240	210	305	265	390
8.5	165	240	210	305	265	390
9.0	175	250	220	320	280	410
9.5	175	250	220	320	280	410
10.0	185	265	235	340	295	430





# High Speed Steel SILVER AND DEMING DRILLS-3/4" SHANK

(Size of Shank : 3/4" Dia x 2-1/4" Shank Length)

Dimensions in inch



Size	Flute Length	Overall Length
25/32	3	6
13/16	3	6
27/32	3	6
7/ 8	3	6
29/32	3	6
15/16	3	6
31/32	3	6
1	3	6
1.1/32	3	6
1.1/16	3	6
1.3/32	3	6
1.1/8	3	6
1.5/32	3	6
1.3/16	3	6
1.7/32	3	6
1.1/4	3	6
1.9/32	3	6
1.5/16	3	6
1.11/32	3	6
1.3/8	3	6

Size	Flute Length	Overall Length
1.13/32	3	6
1.7/16	3	6
1.15/32	3	6
1.1/2	3	6
1.17/32	3	6
1.9/16	3	6
1.19/32	3	6
1.5/8	3	6
1.21/32	3	6
1.11/16	3	6
1.23/32	3	6
1.3/4	3	6
1.25/32	3	6
1.13/16	3	6
1.27/32	3	6
1.7/8	3	6
1.29/32	3	6
1.15/16	3	6
1.31/32	3	6
2	3	6



High Speed Steel  
 SILVER AND DEMING DRILLS-1/2" SHANK  
 (Size of Shank : 1/2" Dia x 2-1/4" Shank Length)

Dimensions in inch



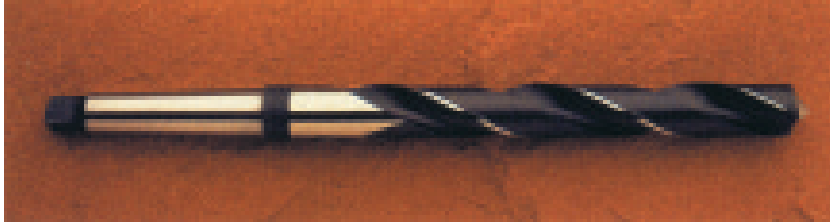
Size	Flute Length	Overall Length
33/64	3	6
17/32	3	6
35/64	3	6
9/16	3	6
37/64	3	6
19/32	3	6
39/64	3	6
5/8	3	6
41/64	3	6
21/32	3	6
43/64	3	6
11/16	3	6
45/64	3	6
23/32	3	6
47/64	3	6
3/4	3	6
49/64	3	6
25/32	3	6
51/64	3	6
13/16	3	6
53/64	3	6
27/32	3	6
55/64	3	6
7/8	3	6

Size	Flute Length	Overall Length
57/64	3	6
29/32	3	6
59/64	3	6
15/16	3	6
61/64	3	6
31/32	3	6
63/64	3	6
1	3	6
1.1/32	3	6
1.1/16	3	6
1.3/32	3	6
1.1/8	3	6
1.5/32	3	6
1.3/16	3	6
1.7/32	3	6
1.1/4	3	6
1.9/32	3	6
1.5/16	3	6
1.11/32	3	6
1.3/8	3	6
1.13/32	3	6
1.7/16	3	6
1.15/32	3	6
1.1/2	3	6



## High Speed Steel TAPER SHANK TWIST DRILLS

Specifications conform to  
IS 5103-1969  
ISO 235-1980  
DIN 345-1978  
BS 328 : Part 1 : 1986  
Dimensions in mm / inch



Diameter h8		Flute Length	Overall Length	Morse Taper No.
mm	inch			
3.00	-	33	114	1
3.20	1/8	36	117	1
3.50	9/64	39	120	1
3.80	-	43	124	1
4.00	5/32	43	124	1
4.20	-	43	124	1
4.50	11/64	47	128	1
4.80	3/16	52	133	1
5.00	-	52	133	1
5.20	13/64	52	133	1
5.50	7/32	57	138	1
5.80	-	57	138	1
6.00	15/64	57	138	1
6.20	-	63	144	1
6.50	1/4	63	144	1
6.80	17/64	69	150	1
7.00	-	69	150	1
7.20	9/32	69	150	1
7.50	-	69	150	1
7.80	19/64	75	156	1
8.00	5/16	75	156	1

Diameter h8		Flute Length	Overall Length	Morse Taper No.
mm	inch			
8.20	21/64	75	156	1
8.50	-	75	156	1
8.80	11/32	81	162	1
9.00	-	81	162	1
9.20	23/64	81	162	1
9.50	-	81	162	1
9.80	3/8	87	168	1
10.00	25/64	87	168	1
10.20	13/32	87	168	1
10.50	-	87	168	1
10.80	27/64	94	175	1
11.00	-	94	175	1
11.20	7/16	94	175	1
11.50	29/64	94	175	1
11.80	-	94	175	1
12.00	15/32	101	182	1
12.20	31/64	101	182	1
12.50	-	101	182	1
12.80	1/2	101	182	1
13.00	33/64	101	182	1
13.20	-	101	182	1

A drill having two helical flutes and a standard Morse Taper Shank

Type 'N' Drills shall be supplied unless otherwise specified .



## High Speed Steel TAPER SHANK TWIST DRILLS

Specifications conform to  
IS 5103-1969  
ISO 235-1980  
DIN 345-1978  
BS 328 : Part 1 : 1986  
Dimensions in mm / inch



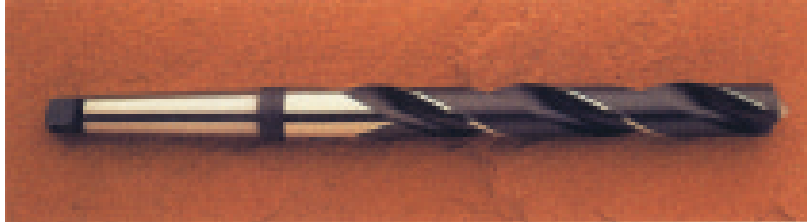
Diameter h8		Flute Length	Overall Length	Morse Taper No.
mm	inch			
13.50	17/32	108	189	1
13.80	35/64	108	189	1
14.00	-	108	189	1
14.25	9/16	114	212	2
14.50	-	114	212	2
14.75	37/64	114	212	2
15.00	-	114	212	2
15.25	19/32	120	218	2
15.50	39/64	120	218	2
15.75	-	120	218	2
16.00	5/8	120	218	2
16.25	41/64	125	223	2
16.50	-	125	223	2
16.75	21/32	125	223	2
17.00	-	125	223	2
17.25	43/64	130	228	2
17.50	11/16	130	228	2
17.75	-	130	228	2
18.00	45/64	130	228	2
18.25	23/32	135	233	2
18.50	-	135	233	2
18.75	47/64	135	233	2
19.00	-	135	233	2
19.25	3/4	140	238	2
19.50	49/64	140	238	2
19.75	25/32	140	238	2
20.00	-	140	238	2
20.25	51/64	145	243	2
20.50	-	145	243	2
20.75	13/16	145	243	2

Diameter h8		Flute Length	Overall Length	Morse Taper No.
mm	inch			
21.00	53/64	145	243	2
21.25	-	150	248	2
21.50	27/32	150	248	2
21.75	55/64	150	248	2
22.00	-	150	248	2
22.25	7/8	150	248	2
22.50	57/64	155	253	2
22.75	-	155	253	2
23.00	29/32	155	253	2
23.25	-	155	276	3
23.50	59/64	155	276	3
23.75	15/16	160	281	3
24.00	-	160	281	3
24.25	61/64	160	281	3
24.50	31/32	160	281	3
24.75	-	160	281	3
25.00	-	160	281	3
25.25	63/64	165	286	3
25.50	1	165	286	3
25.75	1.1/64	165	286	3
26.00	-	165	286	3
26.25	1.1/32	165	286	3
26.50	-	165	286	3
26.75	1.3/64	170	291	3
27.00	1.1/16	170	291	3
27.25	-	170	291	3
27.50	1.5/64	170	291	3
27.75	1.3/32	170	291	3
28.00	-	170	291	3
28.25	1.7/64	175	296	3



## High Speed Steel TAPER SHANK TWIST DRILLS

Specifications conform to  
IS 5103-1969  
ISO 235-1980  
DIN 345-1978  
BS 328 : Part 1 : 1986  
Dimensions in mm / inch



Diameter h8		Flute Length	Overall Length	Morse Taper No.
mm	inch			
28.50	1.1/8	175	296	3
28.75	-	175	296	3
29.00	1.9/64	175	296	3
29.25	-	175	296	3
29.50	1.5/32	175	296	3
29.75	1.11/64	175	296	3
30.00	-	175	296	3
30.25	1.3/16	180	301	3
30.50	1.13/64	180	301	3
30.75	-	180	301	3
31.00	1.7/32	180	301	3
31.25	1.15/64	180	301	3
31.50	-	180	301	3
31.75	1.1/4	185	306	3
32.00	-	185	334	4
32.50	1.9/32	185	334	4
33.00	-	185	334	4
33.50	1.5/16	185	334	4
34.00	1.11/32	190	339	4
34.50	-	190	339	4
35.00	1.3/8	190	339	4
35.50	-	190	339	4
36.00	1.13/32	195	344	4
36.50	1.7/16	195	344	4
37.00	-	195	344	4
37.50	1.15/32	195	344	4
38.00	1.1/2	200	349	4
38.50	-	200	349	4
39.00	1.17/32	200	349	4
39.50	1.9/16	200	349	4
40.00	-	200	349	4

Diameter h8		Flute Length	Overall Length	Morse Taper No.
mm	inch			
40.50	1.19/32	205	354	4
41.00	-	205	354	4
41.50	1.5/8	205	354	4
42.00	1.21/32	205	354	4
42.50	-	205	354	4
43.00	1.11/16	210	359	4
43.50	1.23/32	210	359	4
44.00	-	210	359	4
44.50	1.3/4	210	359	4
45.00	-	210	359	4
45.50	1.25/32	215	364	4
46.00	1.13/16	215	364	4
46.50	-	215	364	4
47.00	1.27/32	215	364	4
47.50	-	215	364	4
48.00	1.7/8	220	369	4
48.50	1.29/32	220	369	4
49.00	1.15/16	220	369	4
49.50	-	220	369	4
50.00	-	220	369	4
50.50	1.31/32,2	225	374	4
51.00	-	225	412	5
52.00	2.1/16	225	412	5
53.00	-	225	412	5
54.00	2.1/8	230	417	5
55.00	-	230	417	5
56.00	2.3/16	230	417	5
57.00	2.1/4	235	422	5
58.00	-	235	422	5
59.00	2.5/16	235	422	5
60.00	-	235	422	5



## High Speed Steel TAPER SHANK TWIST DRILLS

Specifications conform to  
IS 5103-1969  
ISO 235-1980  
DIN 345-1978  
BS 328 : Part 1 : 1986  
Dimensions in mm / inch



Diameter h8		Flute Length	Overall Length	Morse Taper No.
mm	inch			
61.00	2.3/8	240	427	5
62.00	2.7/16	240	427	5
63.00	-	240	427	5
64.00	2.1/2	245	432	5
65.00	2.9/16	245	432	5
66.00	-	245	432	5
67.00	2.5/8	245	432	5
68.00	2.11/16	250	437	5
69.00	-	250	437	5
70.00	2.3/4	250	437	5
71.00	-	250	437	5
72.00	2.13/16	255	442	5
73.00	2.7/8	255	442	5
74.00	-	255	442	5
75.00	2.15/16	255	442	5
76.00	3	260	447	5
77.00	-	260	514	6
78.00	3.1/16	260	514	6
79.00	3.1/8	260	514	6
80.00	-	260	514	6
81.00	3.3/16	265	519	6

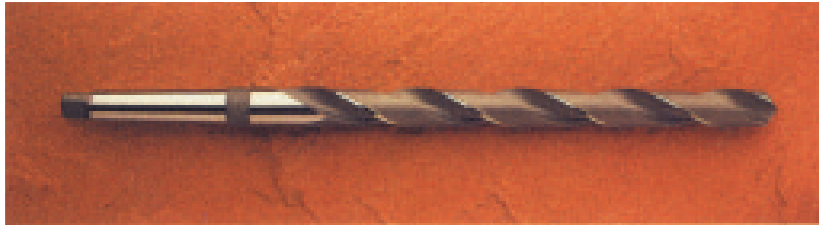
Diameter h8		Flute Length	Overall Length	Morse Taper No.
mm	inch			
82.00	-	265	519	6
83.00	3.1/4	265	519	6
84.00	3.5/16	265	519	6
85.00	-	265	519	6
86.00	3.3/8	270	524	6
87.00	3.7/16	270	524	6
88.00	-	270	524	6
89.00	3.1/2	270	524	6
90.00	-	270	524	6
91.00	3.9/16	275	529	6
92.00	3.5/8	275	529	6
93.00	-	275	529	6
94.00	3.11/16	275	529	6
95.00	-	275	529	6
96.00	3.3/4	280	534	6
97.00	3.13/16	280	534	6
98.00	3.7/8	280	534	6
99.00	-	280	534	6
100.00	-	280	534	6
101.00	3.15/16	285	539	6
102.00	4	285	539	6



# High Speed Steel TAPER SHANK TWIST DRILLS Long Series

Specifications conform to  
IS 8305-1976  
DIN 341-1978

Dimensions in mm



Diameter h8	Flute Length	Overall Length	Morse Taper No.
5.0	74	155	1
5.1	74	155	1
5.2	74	155	1
5.3	74	155	1
5.4	80	161	1
5.5	80	161	1
5.6	80	161	1
5.7	80	161	1
5.8	80	161	1
5.9	80	161	1
6.0	80	161	1
6.1	86	167	1
6.2	86	167	1
6.3	86	167	1
6.4	86	167	1
6.5	86	167	1
6.6	86	167	1
6.7	86	167	1
6.8	93	174	1
6.9	93	174	1
7.0	93	174	1
7.1	93	174	1

Diameter h8	Flute Length	Overall Length	Morse Taper No.
7.2	93	174	1
7.3	93	174	1
7.4	93	174	1
7.5	93	174	1
7.6	100	181	1
7.7	100	181	1
7.8	100	181	1
7.9	100	181	1
8.0	100	181	1
8.1	100	181	1
8.2	100	181	1
8.3	100	181	1
8.4	100	181	1
8.5	100	181	1
8.6	107	188	1
8.7	107	188	1
8.8	107	188	1
8.9	107	188	1
9.0	107	188	1
9.1	107	188	1
9.2	107	188	1
9.3	107	188	1

A lengthened form of the Taper Shank Twist Drill, the increase in length being in the flute length.

Type 'N' Drills shall be supplied unless otherwise specified.



# High Speed Steel TAPER SHANK TWIST DRILLS Long Series

Specifications conform to  
IS 8305-1976  
DIN 341-1978

Dimensions in mm



Diameter h8	Flute Length	Overall Length	Morse Taper No.
9.4	107	188	1
9.5	107	188	1
9.6	116	197	1
9.7	116	197	1
9.8	116	197	1
9.9	116	197	1
10.0	116	197	1
10.1	116	197	1
10.2	116	197	1
10.3	116	197	1
10.4	116	197	1
10.5	116	197	1
10.6	116	197	1
10.7	125	206	1
10.8	125	206	1
10.9	125	206	1
11.0	125	206	1
11.1	125	206	1
11.2	125	206	1
11.3	125	206	1
11.4	125	206	1
11.5	125	206	1
11.6	125	206	1
11.7	125	206	1
11.8	125	206	1
11.9	134	215	1
12.0	134	215	1
12.1	134	215	1
12.2	134	215	1
12.3	134	215	1
12.4	134	215	1

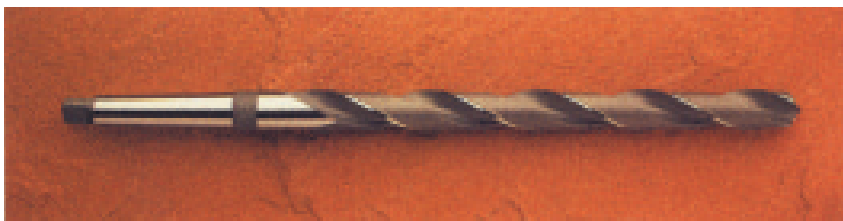
Diameter h8	Flute Length	Overall Length	Morse Taper No.
12.5	134	215	1
12.6	134	215	1
12.7	134	215	1
12.8	134	215	1
12.9	134	215	1
13.0	134	215	1
13.1	134	215	1
13.2	134	215	1
13.3	142	223	1
13.4	142	223	1
13.5	142	223	1
13.6	142	223	1
13.7	142	223	1
13.8	142	223	1
13.9	142	223	1
14.0	142	223	1
14.25	147	245	2
14.5	147	245	2
14.75	147	245	2
15.0	147	245	2
15.25	153	251	2
15.5	153	251	2
15.75	153	251	2
16.0	153	251	2
16.25	159	257	2
16.5	159	257	2
16.75	159	257	2
17.0	159	257	2
17.25	165	263	2
17.5	165	263	2
17.75	165	263	2





# High Speed Steel TAPER SHANK TWIST DRILLS Long Series

Specifications conform to  
IS 8305-1976  
DIN 341-1978  
Dimensions in mm



Diameter h8	Flute Length	Overall Length	Morse Taper No.
18.00	165	263	2
18.25	171	269	2
18.50	171	269	2
18.75	171	269	2
19.00	171	269	2
19.25	177	275	2
19.50	177	275	2
19.75	177	275	2
20.00	177	275	2
20.25	184	282	2
20.50	184	282	2
20.75	184	282	2
21.00	184	282	2
21.25	191	289	2
21.50	191	289	2
21.75	191	289	2
22.00	191	289	2
22.25	191	289	2
22.50	198	296	2
22.75	198	296	2
23.00	198	296	2
23.25	198	319	3
23.50	198	319	3
23.75	206	327	3
24.00	206	327	3
24.25	206	327	3
24.50	206	327	3
24.75	206	327	3
25.00	206	327	3
25.25	214	335	3

Diameter h8	Flute Length	Overall Length	Morse Taper No.
25.50	214	335	3
25.75	214	335	3
26.00	214	335	3
26.25	214	335	3
26.50	214	335	3
26.75	222	343	3
27.00	222	343	3
27.25	222	343	3
27.50	222	343	3
27.75	222	343	3
28.00	222	343	3
28.25	230	351	3
28.50	230	351	3
28.75	230	351	3
29.00	230	351	3
29.25	230	351	3
29.50	230	351	3
29.75	230	351	3
30.00	230	351	3
30.25	239	360	3
30.50	239	360	3
30.75	239	360	3
31.00	239	360	3
31.25	239	360	3
31.50	239	360	3
31.75	248	369	3
32.00	248	397	4
32.50	248	397	4
33.00	248	397	4
33.50	248	397	4



## High Speed Steel TAPER SHANK TWIST DRILLS Long Series

Specifications conform to  
IS 8305-1976  
DIN 341-1978  
Dimensions in mm



Diameter h8	Flute Length	Overall Length	Morse Taper No,
34.00	257	406	4
34.25	257	406	4
34.50	257	406	4
35.00	257	406	4
35.50	257	406	4
36.00	267	416	4
36.50	267	416	4
36.75	267	416	4
37.00	267	416	4
37.50	267	416	4
38.00	277	426	4
38.50	277	426	4
39.00	277	426	4
39.50	277	426	4
40.00	277	426	4
40.50	287	436	4
41.00	287	436	4
41.50	287	436	4

Diameter h8	Flute Length	Overall Length	Morse Taper No.
42.00	287	436	4
42.50	287	436	4
43.00	298	447	4
43.50	298	447	4
44.00	298	447	4
44.50	298	447	4
45.00	298	447	4
45.50	310	459	4
46.00	310	459	4
46.50	310	459	4
47.00	310	459	4
47.50	310	459	4
48.00	321	470	4
48.50	321	470	4
49.00	321	470	4
49.50	321	470	4
50.00	321	470	4



# High Speed Steel TAPER SHANK TWIST DRILLS Extra Long Series

Specifications conform to  
IS 7822-1983  
DIN 1870-1978  
Dimensions in mm



Diameter h8	SERIES1		SERIES2		Morse Taper No
	Flute Length	Overall Length	Flute Length	Overall Length	
8.0	165	265	210	330	1
8.5	165	265	210	330	1
9.0	175	275	220	345	1
9.5	175	275	220	345	1
10.0	185	285	235	360	1
10.5	185	285	235	360	1
11.0	195	300	250	375	1
11.5	195	300	250	375	1
12.0	205	310	260	395	1
12.5	205	310	260	395	1
13.0	205	310	260	395	1
13.5	220	325	275	410	1
14.0	220	325	275	410	1
14.5	220	340	275	425	2
15.0	220	340	275	425	2
15.5	230	355	295	445	2
16.0	230	355	295	445	2
16.5	230	355	295	445	2
17.0	230	355	295	445	2
17.5	245	370	310	465	2
18.0	245	370	310	465	2
18.5	245	370	310	465	2
19.0	245	370	310	465	2
19.5	260	385	325	490	2
20.0	260	385	325	490	2
20.5	260	385	325	490	2
21.0	260	385	325	490	2
21.5	270	405	345	515	2
22.0	270	405	345	515	2
22.5	270	405	345	515	2
23.0	270	405	345	515	2
23.5	270	405	345	535	3

A lengthened form of the Morse Taper Shank Twist Drill, longer than the long series.

Type 'N' Drills shall be supplied unless otherwise specified.



High Speed Steel  
TAPER SHANK TWIST DRILLS  
Extra Long Series

Specifications conform to  
IS 7822-1983  
DIN 1870-1978  
Dimensions in mm



Diameter h8	SERIES 1		Morse Taper No.
	Flute Length	Overall Length	
24.0	290	440	3
24.5	290	440	3
25.0	290	440	3
25.5	290	440	3
26.0	290	440	3
26.5	290	440	3
27.0	305	460	3
27.5	305	460	3
28.0	305	460	3
28.5	305	460	3
29.0	305	460	3
29.5	305	460	3
30.0	305	460	3
31.0	320	480	3
32.0	320	505	4
33.0	320	505	4
34.0	340	530	4
35.0	340	530	4
36.0	340	530	4
37.0	340	530	4
38.0	360	555	4
39.0	360	555	4
40.0	360	555	4
41.0	360	555	4
42.0	360	555	4
43.0	385	585	4
44.0	385	585	4
45.0	385	585	4
46.0	385	585	4
47.0	385	585	4
48.0	405	605	4
49.0	405	605	4
50.0	405	605	4



## High Speed Steel TAPER SHANK TWIST DRILLS

Specifications conform to  
ASME B94. 11M-1993

Dimensions in mm / inch



Diameter		REGULAR SHANK		
Fraction	mm	Flute Length	Overall Length	Morse Taper No.
1/8	3.0	48	130	1
	3.2	54	137	1
9/64	3.5	54	137	1
5/32	3.8	54	137	1
	4.0	64	146	1
11/64	4.2	64	146	1
3/16	4.5	64	146	1
	4.8	70	152	1
	5.0	70	152	1
13/64	5.2	70	152	1
7/32	5.5	70	152	1
	5.8	73	156	1
15/64	6.0	73	156	1
1/4	6.2	73	156	1
	6.5	76	159	1
17/64	6.8	76	159	1
9/32	7.0	76	159	1
	7.2	79	162	1
19/64	7.5	79	162	1
5/16	7.8	79	162	1
	8.0	83	165	1

Diameter		REGULAR SHANK		
Fraction	mm	Flute Length	Overall Length	Morse Taper No.
21/64	8.2	83	165	1
11/32	8.5	83	165	1
	8.8	89	171	1
	9.0	89	171	1
23/64	9.2	89	171	1
3/8	9.5	89	171	1
	9.8	92	178	1
25/64	10.0	92	178	1
13/32	10.2	92	178	1
	10.5	98	184	1
27/64	10.8	98	184	1
7/16	11.0	98	184	1
	11.2	105	190	1
29/64	11.5	105	190	1
15/32	11.8	105	190	1
	12.0	111	210	2
31/64	12.2	111	210	2
1/2	12.5	111	210	2
	12.8	117	216	2
33/64	13.0	117	216	2
	13.2	117	216	2



# High Speed Steel TAPER SHANK TWIST DRILLS

Specifications conform to  
ASME B94. 11M-1993

Dimensions in mm / inch



Diameter		REGULAR SHANK		
Fraction	mm	Flute Length	Overall Length	Morse Taper No.
17/32	13.50	117	216	2
35/64	13.80	124	222	2
-	14.00	124	222	2
9/16	14.25	124	222	2
-	14.50	124	222	2
37/64	14.75	124	222	2
19/32	15.00	124	222	2
-	15.25	124	222	2
39/64	15.50	124	222	2
5/8	15.75	124	222	2
-	16.00	130	229	2
41/64	16.25	130	229	2
21/32	16.50	130	229	2
-	16.75	137	235	2
43/64	17.00	137	235	2
11/16	17.25	137	235	2
-	17.50	143	241	2
45/64	18.00	143	241	2
23/32	-	143	241	2
47/64	18.50	149	248	2
3/4	19.00	149	248	2
49/64	19.50	152	251	2
25/32	-	152	251	2
51/64	20.00	156	273	3
13/16	20.50	156	273	3
53/64	21.00	156	273	3
27/32	21.50	156	273	3
55/64	22.00	156	273	3
7/8,57/64	22.50	156	273	3

Diameter		REGULAR SHANK		
Fraction	mm	Flute Length	Overall Length	Morse Taper No.
29/32	23.00	156	273	3
59/64,15/16	23.50	156	273	3
61/64	24.00	162	279	3
31/32	24.50	162	279	3
63/64,1	25.00	162	279	3
1.1/64	25.50	165	283	3
1.1/32	26.00	165	283	3
1.3/64	26.50	168	286	3
1.1/16	27.00	168	286	3
1.5/64,1.3/32	27.50	175	318	4
1.7/64	28.00	181	324	4
1.1/8	28.50	181	324	4
1.9/64,1.5/32	29.00	184	327	4
1.11/64	29.50	187	330	4
1.3/16	30.00	187	330	4
1.13/64,1.7/32	30.50	190	333	4
1.15/64	31.00	200	343	4
1.1/4	31.50	200	343	4
1.17/64	32.00	216	359	4
1.9/32	32.50	216	359	4
1.19/64,1.5/16	33.00	219	362	4
1.21/64	33.50	222	365	4
1.11/32	34.00	222	365	4



# High Speed Steel TAPER SHANK TWIST DRILLS

Specifications conform to  
ASME B94. 11M-1993

Dimensions in mm / inch



Diameter		REGULAR SHANK		
Fraction	mm	Flute Length	Overall Length	Morse Taper No.
1.23/64, 1.3/8	34.50	225	368	4
1.25/64	35.00	229	371	4
1.13/32	35.50	229	371	4
1.27/64	36.00	232	375	4
1.7/16	36.50	232	375	4
1.29/64, 1.15/32	37.00	235	378	4
1.31/64	37.50	238	381	4
1.1/2	38.00	238	381	4
1.17/32	-	238	416	5
1.9/16	39.00	244	422	5
1.19/32	40.00	251	429	5
1.5/8	41.00	254	432	5
1.21/32	42.00	257	435	5
1.11/16	43.00	257	435	5
1.23/32, 1.3/4	44.00	257	435	5
1.25/32	45.00	257	435	5
1.13/16	46.00	257	435	5
1.27/32	-	257	435	5
1.7/8	47.00	264	441	5
1.29/32	48.00	264	441	5
1.15/16	49.00	264	441	5
1.31/32	50.00	264	441	5
2.2.1/32	51.00	264	441	5
2.1/16	52.00	260	441	5
2.3/32	53.00	260	441	5
2.1/8	54.00	260	441	5

Diameter		REGULAR SHANK		
Fraction	mm	Flute Length	Overall Length	Morse Taper No.
2.5/32, 2.3/16	55.00	260	441	5
2.7/32	56.00	257	441	5
2.1/4	57.00	257	441	5
-	58.00	257	441	5
2.5/16	59.00	257	441	5
2.3/8	60.00	257	441	5
-	61.00	286	476	5
2.7/16	62.00	286	476	5
2.1/2	63.00	286	476	5
-	64.00	302	495	5
2.9/16	65.00	302	495	5
2.5/8	66.00	302	495	5
-	67.00	324	518	5
2.11/16	68.00	324	518	5
2.3/4	69.00	324	518	5
-	70.00	340	537	5
2.13/16	71.00	340	537	5
-	72.00	340	537	5
2.7/8	73.00	340	537	5
-	74.00	356	552	5
2.15/16	75.00	356	552	5
3	76.00	356	552	5
-	77.00	371	622	6
-	78.00	371	622	6
3.1/8	-	371	622	6
3.1/4	-	394	648	6



## High Speed Steel TAPER SHANK CORE DRILLS

Specifications conform to  
 IS 5366 : 1978  
 ISO 7079 : 1981  
 DIN 343 : 1981  
 BS 328 : 1959  
 Dimensions in mm / inch



Diameter h8		Flute Length	Overall Length	Morse Taper No.
mm	inch			
7.00	9/32	69	150	1
8.00	5/16	75	156	1
9.00	11/32	81	162	1
10.00	3/8, 13/32	87	168	1
11.00	7/16	94	175	1
12.00	15/32	101	182	1
13.00	1/2	101	182	1
14.00	17/32	108	189	1
15.00	9/16	114	212	2
16.00	19/32, 5/8	120	218	2
17.00	21/32	125	223	2
18.00	11/16	130	228	2
19.00	23/32	135	233	2
20.00	3/4, 25/32	140	238	2
21.00	13/16	145	243	2
22.00	27/32, 7/8	150	248	2
23.00	29/32	155	253	2
24.00	-	160	281	3
25.00	15/16, 31/32	160	281	3
26.00	1, 1.1/32	165	286	3
27.00	1.1/16	170	291	3
28.00	1.3/32	170	291	3

Diameter h8		Flute Length	Overall Length	Morse Taper No.
mm	inch			
29.00	1.1/8, 1.5/32	175	296	3
30.00	-	175	296	3
31.00	1.3/16, 1.7/32	180	301	3
-	1.1/4	185	306	3
32.00	1.9/32	185	334	4
33.00	1.5/16	185	334	4
34.00	1.11/32	190	339	4
35.00	1.3/8	190	339	4
36.00	1.13/32	195	344	4
37.00	1.7/16, 1.15/32	195	344	4
38.00	1.1/2	200	349	4
39.00	-	200	349	4
40.00	1.9/16	200	349	4
41.00	1.5/8	205	354	4
42.00	-	205	354	4
43.00	1.11/16	210	359	4
44.00	1.3/4	210	359	4
45.00	-	210	359	4
46.00	1.13/16	215	364	4
47.00	-	215	364	4
48.00	1.7/8	220	369	4
49.00	1.15/16	220	369	4

A drill having three or more helical flutes and a standard Morse Taper Shank designed for opening out or enlarging holes.





## High Speed Steel TAPER SHANK CORE DRILLS

Specifications conform to  
 IS 5366 : 1978  
 ISO 7079 : 1981  
 DIN 343 : 1981  
 BS 328 : 1959  
 Dimensions in mm / inch



Diameter h8		Flute Length	Overall Length	Morse Taper No.
mm	inch			
50.00		220	369	4
50.50	2	225	374	4
51.00		225	412	5
52.00	2.1/16	225	412	5
53.00		225	412	5
54.00	2.1/8	230	417	5
55.00		230	417	5
56.00	2.3/16	230	417	5
57.00	2.1/4	235	422	5
58.00		235	422	5
59.00	2.5/16	235	422	5
60.00		235	422	5
61.00	2.3/8	240	427	5
62.00	2.7/16	240	427	5
63.00		240	427	5
64.00	2.1/2	245	432	5

Diameter h8		Flute Length	Overall Length	Morse Taper No.
mm	inch			
65.00	2.9/16	245	432	5
66.00		245	432	5
67.00	2.5/8	245	432	5
68.00	2.11/16	250	437	5
69.00		250	437	5
70.00	2.3/4	250	437	5
71.00		250	437	5
72.00	2.13/16	255	442	5
73.00	2.7/8	255	442	5
74.00		255	442	5
75.00	2.15/16	255	442	5
76.00	3	260	447	5
77.00		260	514	6
78.00	3.1/16	260	514	6
79.00	3.1/8	260	514	6
80.00		260	514	6

ISO 7079 : 1981 Specifies the Diameter ranges , over 75 to 50 mm

DIN 343 : 1981 Specifies the Diameter ranges , over 85 to 50 mm

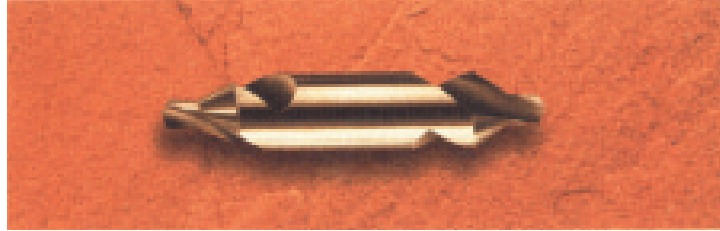
- 1) Taper Shank Core drills upto and including 20 mm dia are supplied with 3 flutes, over 20 mm dia to 75 mm dia are supplied with 4 flutes and over 75 mm dia are supplied with 6 flutes.  
(For DIN Specification, the No. of Flutes shall be 3 for sizes upto & incl. 50mm dia)
- 2) Type 'N' Drills shall be supplied unless otherwise specified.



## High Speed Steel CENTRE DRILLS - Type 'A'

Specifications conform to  
IS 6708 : 1977  
ISO 866 : 1975  
DIN 333 : 1986

Dimensions in mm



Pilot Dia k12	Body Dia h9	Overall Length		Pilot Length	
		Max	Min	Max	Min
1.00	3.15	33.5	29.5	1.90	1.3
1.25	3.15	33.5	29.5	2.20	1.6
1.60	4.00	37.5	33.5	2.80	2.0
2.00	5.00	42.0	38.0	3.30	2.5
2.50	6.30	47.0	43.0	4.10	3.1
3.15	8.00	52.0	48.0	4.90	3.9
4.00	10.00	59.0	53.0	6.20	5.0
5.00	12.50	66.0	60.0	7.50	6.3
6.30	16.00	74.0	68.0	9.20	8.0
8.00	20.00	83.0	77.0	11.50	10.1
10.00	25.00	103.0	97.0	14.20	12.8

Type - 'A' Centre Drill for centre holes without protecting chamfer.



## High Speed Steel CENTRE DRILLS

Specifications conform to  
BS 328 : Part 2 : 1950

Dimensions in inch

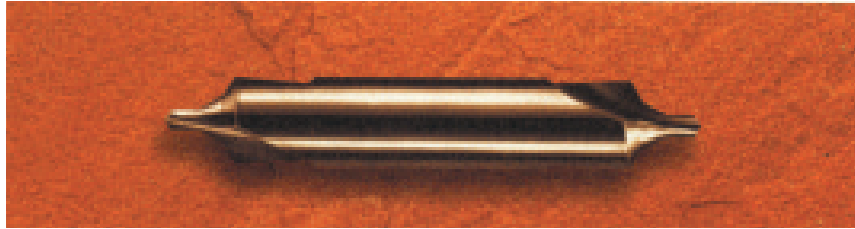
BS No.	Body Dia.	Pilot Dia.	Pilot Length		OAL	Tolerance on Overall Length
			Max	Min		
1	1/8	3/64	5/64	1/16	1.1/2	± 1/32
2	3/16	1/16	3/32	5/64	1.3/4	± 1/32
3	1/4	3/32	5/32	1/8	2	± 1/16
4	5/16	1/8	3/16	5/32	2.1/4	± 1/16
5	7/16	3/16	9/32	1/4	2.1/2	± 3/32
6	5/8	1/4	3/8	5/16	3	± 3/32
7	3/4	5/16	15/32	13/32	3.1/2	± 3/32



## High Speed Steel CENTRE DRILLS - Type 'B'

Specifications conform to  
IS 6709 : 1977  
ISO 2540 : 1972  
DIN 333 : 1986

Dimensions in mm



Pilot Dia k12	Body Dia h9	Overall Length		Pilot Length	
		Max	Min	Max	Min
1.60	6.3	47	43	2.8	2.0
2.00	8.0	52	48	3.3	2.5
2.50	10.0	59	53	4.1	3.1
3.15	11.2	63	57	4.9	3.9
4.00	14.0	70	64	6.2	5.0
5.00	18.0	78	72	7.5	6.3
6.30	20.0	83	77	9.2	8.0
8.00	25.0	103	97	11.5	10.1

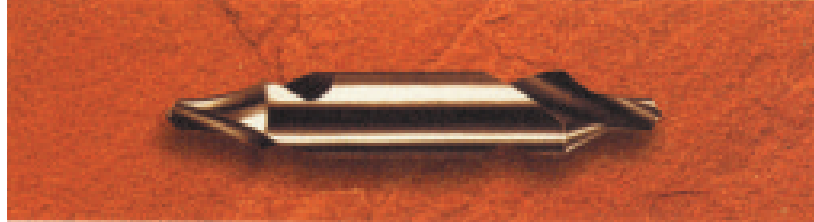
Type - 'B' Centre Drills for centre holes with protecting chamfers.



## High Speed Steel CENTRE DRILLS - Type 'R'

Specifications conform to  
IS 6710 : 1977  
ISO 2541 : 1972  
DIN 333 : 1986

Dimensions in mm



Pilot Dia k12	Body Dia h9	Overall Length		Pilot Length	Radius	
		Max	Min		Max.	Min.
1.00	3.15	33.5	29.5	3.00	3.15	2.50
1.25	3.15	33.5	29.5	3.35	4.00	3.15
1.60	4.00	37.5	33.5	4.25	5.00	4.00
2.00	5.00	42.0	38.0	5.30	6.30	5.00
2.50	6.30	47.0	43.0	6.70	8.00	6.30
3.15	8.00	52.0	48.0	8.50	10.00	8.00
4.00	10.00	59.0	53.0	10.60	12.50	10.00
5.00	12.50	66.0	60.0	13.20	16.00	12.50
6.30	16.00	74.0	68.0	17.00	20.00	16.00
8.00	20.00	83.0	77.0	21.20	25.00	20.00
10.00	25.00	103.0	97.0	26.50	31.50	25.00

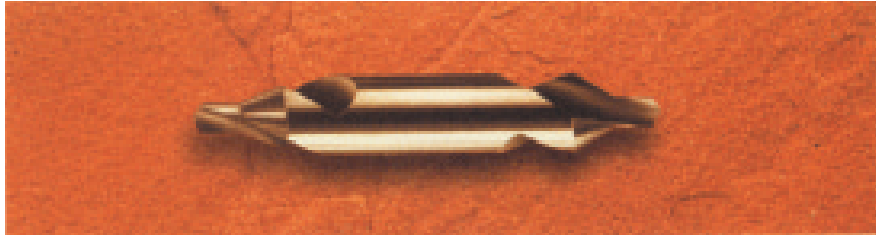
Type - 'R' Centre Drills for centre holes with radius form.



## COMBINED DRILLS AND COUNTERSINKS

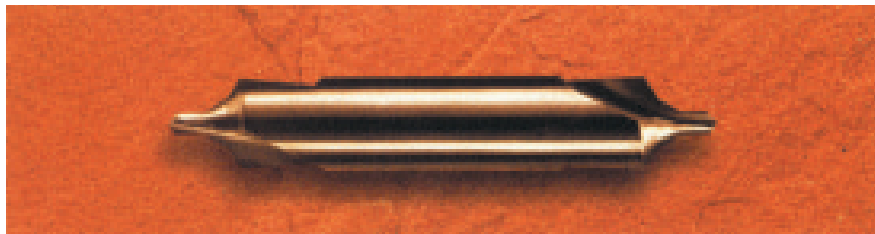
Specifications conform to  
ASME B94. 11M- 1993

Dimensions in inch



PLAIN TYPE

Size	Body Diameter	Drill Diameter	Overall Length
1	1/8	3/64	1.1/4
2	3/16	5/64	1.7/8
3	1/4	7/64	2
4	5/16	1/8	2.1/8
5	7/16	3/16	2.3/4
6	1/2	7/32	3
7	5/8	1/4	3.1/4
8	3/4	5/16	3.1/2



BELL TYPE

Size	Body Diameter	Drill Diameter	Overall Length
13	1/4	3/32	2
14	5/16	7/64	2.1/8
15	7/16	5/32	2.3/4
16	1/2	3/16	3
17	5/8	7/32	3.1/4
18	3/4	1/4	3.1/2



**High Speed Steel**  
**SUBLAND TWIST DRILLS WITH PARALLEL SHANK**  
 For clearance holes and countersinks for countersunk head screws

Specifications conform to  
 IS 12692: 1989

Dimensions in mm



For Medium series Type - A Countersinks

Big Dia h8	Small Dia h9	Step Length	Flute Length	Overall Length	Suitable for Countersunk head screws
13.0	6.6	15	101	151	M6x 1
17.2	9.0	19	130	191	M8x 1.25

For Fine series Type - A Countersinks

Big Dia h8	Small Dia h9	Step Length	Flute Length	Overall Length	Suitable for Countersunk head screws
11.5	6.4	15	94	142	M6 x 0.75
15.0	8.4	19	114	169	M8 x 0.75
19.0	10.5	23	135	198	M10 x 0.75

Tool Type 'N' Subland Drills shall be supplied unless otherwise specified.



## High Speed Steel

### SUBLAND TWIST DRILLS WITH PARALLEL SHANK

For clearance holes and countersinks for countersunk head screws

Specifications conform to  
IS 12691: 1989

Dimensions in mm



Big Dia h8	Small Dia h9	Step Length	Flute Length	Overall Length	Suitable for screw threads
9.0	6.8	21.0	81	125	M8 x 1.25
11.0	8.5	25.5	94	142	M10 x 1.5
14.0	10.2	30.0	108	160	M12 x 1.75
15.5	12.0	34.5	120	178	M14 x 2.0

Note : For fine pitch threads, subland twist drills shall be manufactured to the same dimensions of 'd' L' 'l<sub>1</sub>' and 'l<sub>2</sub>'. They can be ordered as special tools and diameter 'd1' must be specified in such cases as given in IS : 10952 -1984.

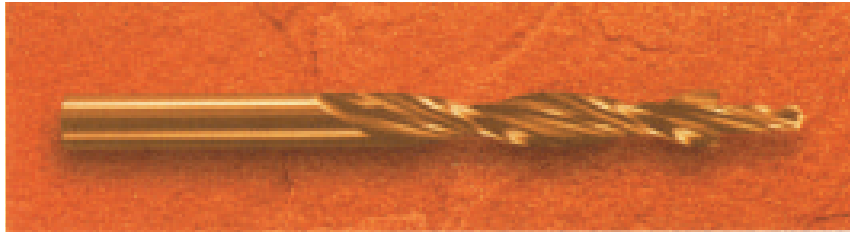
Tool Type 'N' subland drills shall be supplied unless otherwise specified.



**High Speed Steel**  
**SUBLAND TWIST DRILLS WITH PARALLEL SHANK**  
 For clearance holes and counterbores  
 for slotted cheese head screws

Specifications conform to  
 IS 12689: 1989

Dimensions in mm



Big Dia h8	Small Dia h9	Step Length	Flute Length	Overall Length	Suitable for Cheese head screws
11	6.6	15	94	142	M6 x 1
15	9.0	19	114	169	M8 x 1.25
18	11.0	23	130	191	M10 x 1.5

Tool Type 'N' subland drills shall be supplied unless otherwise specified.



**High Speed Steel**  
**SUBLAND TWIST DRILLS WITH  
 MORSE TAPER SHANK**  
 For clearance holes and countersinks for countersunk head screws

Specifications conform to  
 IS 12688: 1989

Dimensions in mm



Big Dia h8	Small Dia h9	Step length	Flute length	Overall length	Morse Taper No.	Suitable for Countersunk head screws
13.0	6.6	15	101	182	1	M6 x 1
17.2	9.0	19	130	228	2	M8 x 1.25
21.5	11.0	23	150	248	2	M10 x 1.5
25.0	13.5	27	160	281	3	M12 x 1.75
28.0	15.5	31	170	291	3	M14 x 2.0

Tool Type 'N' subland drills shall be supplied unless otherwise specified.





**High Speed Steel**  
**SUBLAND TWIST DRILLS WITH**  
**MORSE TAPER SHANK**  
 For holes prior to tapping screw threads

Specifications conform to  
 IS 12687: 1989

Dimensions in mm



Big Dia h8	Small Dia h9	Step Length	Flute Length	Overall Length	Morse Taper No.	Suitable for screw threads
9	6.8	21.0	81	162	1	M8 x 1.25
11	8.5	25.5	94	175	1	M10 x 1.5
14	10.2	30.0	108	189	1	M12 x 1.75
16	12.0	34.5	120	218	2	M14 x 2.0
18	14.0	38.5	130	228	2	M16 x 2.0
20	15.5	43.5	140	238	2	M18 x 2.0
22	17.5	47.5	150	248	2	M20 x 2.5
24	19.5	51.5	160	281	3	M22 x 2.5
26	21.0	56.5	165	286	3	M24 x 3.0
30	24.0	62.5	175	296	3	M27 x 3.0
33	26.5	70.0	185	334	4	M30 x 3.5

Note : For fine pitch threads, these sub land twist drills shall be manufactured to the same dimensions of d, L, L<sub>1</sub>, L<sub>2</sub> and Morse Taper Number as given in the above table, but can be ordered as a special tool with diameter 'd1' specified according to IS: 10952-1984,

Tool Type 'N' Subland Drills shall be supplied unless otherwise specified.



## High Speed Steel

Specifications conform to  
IS 12692: 1989

### SUBLAND TWIST DRILLS WITH MORSE TAPER SHANK

For clearance holes and counterbores for slotted head screws

Dimensions in mm



Big Dia h8	Small Dia h9	Step Length	Flute Length	Overall Length	Morse Taper No.	Suitable for Slotted Cheese head screws
11	6.6	15	94	175	1	M6 x 1
15	9.0	19	114	212	2	M8 x 1.25
18	11.0	23	130	228	2	M10 x 1.5
20	13.5	27	140	238	2	M12 x 1.75
24	15.5	31	160	281	3	M14 x 2.0
26	17.5	35	165	286	3	M16 x 2.0
30	20.0	39	175	296	3	M18 x 2.5
33	22.0	43	185	334	4	M20 x 2.5

Tool Type 'N' subland drills shall be supplied unless otherwise specified.