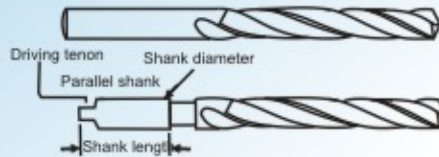


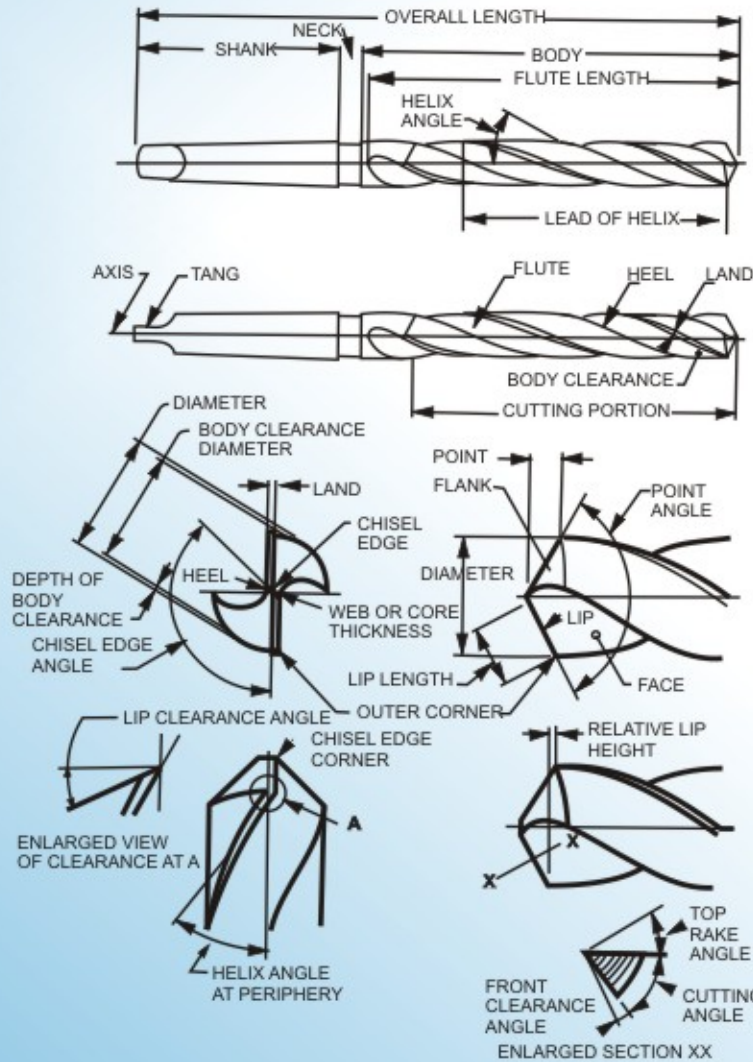


Elements of a Twist Drill and Related Terms

Twist drill with parallel shank



Twist drill with Taper shank



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



Size (h8)		No.	Flute Length	Overall Length
mm	inch			
1.00			12	34
1.02		60	12	34
1.04		59	12	34
1.07		58	14	36
1.09		57	14	36
1.10			14	36
1.18		56	14	36
1.19	3/64		16	38
1.20			16	38
1.30			16	38
1.32		55	16	38
1.40		54	18	40
1.50			18	40
1.51		53	20	43
1.59	1/16		20	43
1.60			20	43
1.61		52	20	43
1.70		51	20	43
1.78		50	22	46
1.80			22	46
1.85		49	22	46
1.90			22	46
1.93		48	24	49
1.98	5/64		24	49
1.99		47	24	49
2.00			24	49
2.06		46	24	49
2.08		45	24	49
2.10			24	49
2.18		44	27	53
2.20			27	53
2.26		43	27	53
2.30			27	53
2.37		42	30	57
2.38	3/32		30	57
2.40			30	57
2.44		41	30	57
2.49		40	30	57
2.50			30	57
2.53		39	30	57
2.58		38	30	57
2.60			30	57
2.64		37	30	57
2.7			33	61
2.71		36	33	61

Figures mentioned in Red are for reference only
Ground flutes upto 13 mm & milled flutes above 13 mm

Range of Application:
For general purpose use



TWIST DRILLS

Specifications conform to
IS 5101 : 2002
ISO 235 : 1980
BS 328 Part 1 : 1993
DIN 338 : 1984



TWIST DRILLS



Specifications conform to
 IS 5101 : 2002
 ISO 235 1980
 BS 328 Part 1 : 1993
 DIN 338 : 1984

High Speed Steel PARALLEL SHANK TWIST DRILLS (Jobber Series)

Size (h8)			Flute Length	Overall Length
mm	inch	No		
2.78	7/64		33	61
2.79		35	33	61
2.80			33	61
2.82		34	33	61
2.87		33	33	61
2.90			33	61
2.95		32	33	61
3.00			33	61
3.05		31	36	65
3.10			36	65
3.17	1/8		36	65
3.20			36	65
3.26		30	36	65
3.30			36	65
3.40			39	70
3.45		29	39	70
3.50			39	70
3.57	9/64	28	39	70
3.60			39	70
3.66		27	39	70
3.70			39	70
3.73		26	39	70
3.80		25	43	75
3.86		24	43	75
3.90			43	75
3.91		23	43	75
3.97	5/32		43	75
3.99		22	43	75
4.00			43	75
4.04		21	43	75
4.09		20	43	75
4.10			43	75
4.20			43	75
4.22		19	43	75
4.30		18	47	80
4.37	11/64		47	80
4.39		17	47	80
4.40			47	80
4.50		16	47	80
4.57		15	47	80
4.60			47	80
4.62		14	47	80
4.70		13	47	80
4.76	3/16		52	86
4.80		12	52	86
4.85		11	52	86

Figures mentioned in Red are for reference only
 Ground flutes upto 13 mm & milled flutes above 13 mm

Range of Application:
 For general purpose use

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



Size (h8)			Flute Length	Overall Length
mm	inch	No./Letter		
4.90			52	86
4.91		10	52	86
4.98		9	52	86
5.00			52	86
5.05		8	52	86
5.10			52	86
5.11		7	52	86
5.16	13/64		52	86
5.18		6	52	86
5.20			52	86
5.22		5	52	86
5.30			52	86
5.31		4	57	93
5.40			57	93
5.41		3	57	93
5.50			57	93
5.56	7/32		57	93
5.60			57	93
5.61		2	57	93
5.70			57	93
5.79		1	57	93
5.80			57	93
5.90			57	93
5.94		A	57	93
5.95	15/64		57	93
6.00			57	93
6.05		B	63	101
6.10			63	101
6.15		C	63	101
6.20			63	101
6.25		D	63	101
6.30			63	101
6.35	1/4	E	63	101
6.40			63	101
6.50			63	101
6.53		F	63	101
6.60			63	101
6.63		G	63	101
6.70			63	101
6.75	17/64		69	109
6.76		H	69	109
6.80			69	109
6.90			69	109
6.91		I	69	109
7.00			69	109
7.04		J	69	109
7.10			69	109
7.14	9/32	K	69	109
7.20			69	109
7.30			69	109

Figures mentioned in Red are for reference only
Ground flutes upto 13 mm & milled flutes above 13 mm

Range of Application:
For general purpose use



TWIST DRILLS

Specifications conform to
IS 5101 : 2002
ISO 235 : 1980
BS 328 Part 1 : 1993
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TWIST DRILLS



Specifications conform to
 IS 5101 : 2002
 ISO 235 1980
 BS 328 Part 1 : 1993
 DIN 338 : 1984

High Speed Steel PARALLEL SHANK TWIST DRILLS (Jobber Series)

Size (h8)		Letter	Flute Length	Overall Length
mm	inch			
7.37		L	69	109
7.40			69	109
7.49		M	69	109
7.50			69	109
7.54	19/64		75	117
7.60			75	117
7.67		N	75	117
7.70			75	117
7.80			75	117
7.90			75	117
7.94	5/16		75	117
8.00			75	117
8.03		O	75	117
8.10			75	117
8.20		P	75	117
8.30			75	117
8.33	21/64		75	117
8.40			75	117
8.43		Q	75	117
8.50			75	117
8.60			81	125
8.61		R	81	125
8.70			81	125
8.73	11/32		81	125
8.80			81	125
8.84		S	81	125
8.90			81	125
9.00			81	125
9.09		T	81	125
9.10			81	125
9.13	23/64		81	125
9.20			81	125
9.30			81	125
9.35		U	81	125
9.40			81	125
9.50			81	125
9.52	3/8		87	133
9.58		V	87	133
9.60			87	133
9.70			87	133
9.80		W	87	133
9.90			87	133
9.92	25/64		87	133
10.00			87	133
10.08		X	87	133
10.10			87	133
10.20			87	133
10.26		Y	87	133
10.30			87	133

Figures mentioned in Red are for reference only
 Ground flutes upto 13 mm & milled flutes above 13 mm

Range of Application:
 For general purpose use

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



Size (h8)			Flute Length	Overall Length
mm	inch	Letter		
10.32	13/32		87	133
10.40			87	133
10.49		Z	87	133
10.50			87	133
10.60			87	133
10.72	27/64		94	142
10.80			94	142
10.90			94	142
11.00			94	142
11.10			94	142
11.11	7/16		94	142
11.20			94	142
11.30			94	142
11.40			94	142
11.50			94	142
11.51	29/64		94	142
11.60			94	142
11.70			94	142
11.80			94	142
11.90			101	151
11.91	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			101	151
13.20			101	151
13.30			108	160
13.40			108	160
13.49	17/32		108	160
13.50			108	160
13.60			108	160
13.70			108	160
13.80			108	160
13.89	35/64		108	160
13.90			108	160
14.00			108	160
14.25			114	169
14.29	9/16		114	169
14.50			114	169
14.68	37/64		114	169
14.75			114	169

Figures mentioned in Red are for reference only
Ground flutes upto 13 mm & milled flutes above 13 mm

Range of Application:
For general purpose use



TWIST DRILLS

Specifications conform to
IS 5101 : 2002
ISO 235 : 1980
BS 328 Part 1 : 1993
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TWIST DRILLS



Specifications conform to
 IS 5101 : 2002
 ISO 235 1980
 BS 328 Part 1 : 1993
 DIN 338 : 1984

High Speed Steel PARALLEL SHANK TWIST DRILLS (Jobber Series)

Size (h8)		Flute Length	Overall Length
mm	inch		
15.00		114	169
15.08	19/32	120	178
15.25		120	178
15.48	39/64	120	178
15.50		120	178
15.75		120	178
15.87	5/8	120	178
16.00		120	178
16.25		125	184
16.27	41/64	125	184
16.50		125	184
16.67	21/32	125	184
16.75		125	184
17.00		125	184
17.07	43/64	130	191
17.25		130	191
17.46	11/16	130	191
17.50		130	191
17.75		130	191
17.86	45/64	130	191
18.00		130	191
18.25		135	198
18.26	23/32	135	198
18.50		135	198
18.65	47/64	135	198
18.75		135	198
19.00		135	198
19.05	3/4	140	205
19.25		140	205
19.45	49/64	140	205
19.50		140	205
19.75		140	205
19.84	25/32	140	205
20.00		140	205

Figures mentioned in Red are for reference only
 Ground flutes upto 13 mm & milled flutes above 13 mm

Range of Application:
 For general purpose use