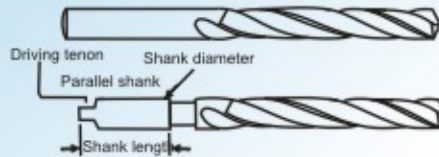


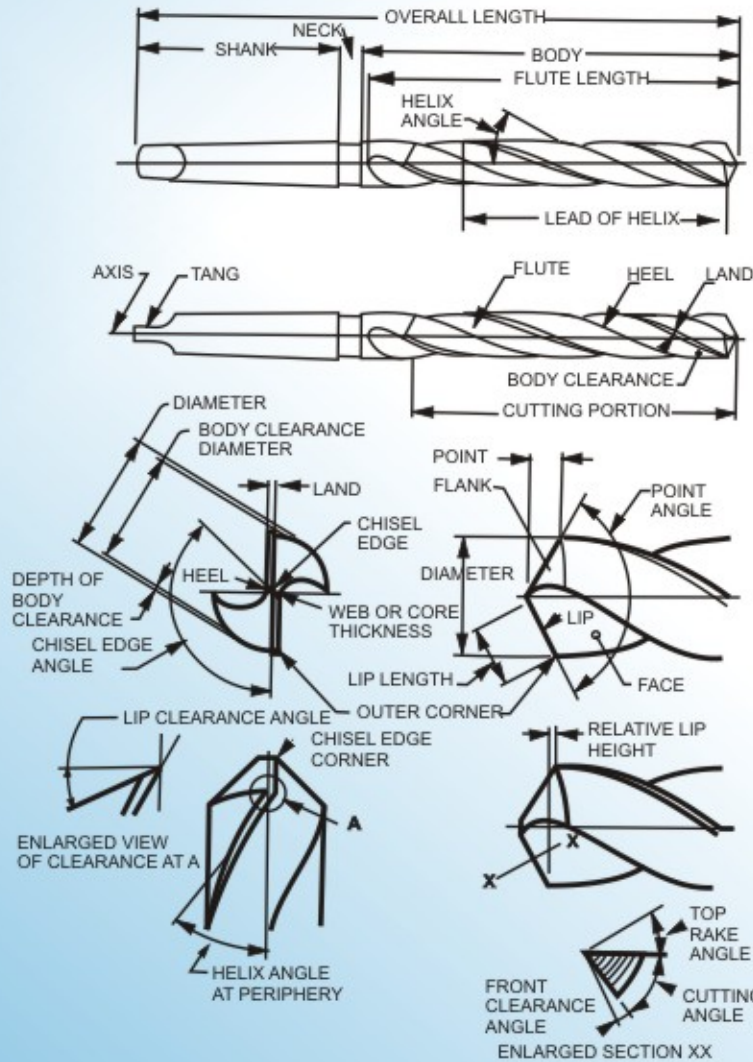


Elements of a Twist Drill and Related Terms

Twist drill with parallel shank



Twist drill with Taper shank





TWIST DRILLS



Specifications conform to
 IS 5103 : 2002
 ISO 235/1 : 1980
 BS 328 Part 1 : 1993
 DIN 345 : 1978

High Speed Steel TAPER SHANK TWIST DRILLS (With Standard Shank)

Size (h8)			Flute Length	Overall Length	MT Shank No
mm	inch	No			
3.00			33	114	1
3.05		31	36	117	1
3.10			36	117	1
3.17	1/8		36	117	1
3.20			36	117	1
3.26		30	36	117	1
3.30			36	117	1
3.40			39	120	1
3.45		29	39	120	1
3.50			39	120	1
3.57	9/64	28	39	120	1
3.60			39	120	1
3.66		27	39	120	1
3.70			39	120	1
3.73		26	39	120	1
3.80		25	43	124	1
3.86		24	43	124	1
3.90			43	124	1
3.91		23	43	124	1
3.97	5/32		43	124	1
3.99		22	43	124	1
4.00			43	124	1
4.04		21	43	124	1
4.09		20	43	124	1
4.10			43	124	1
4.20			43	124	1
4.22		19	43	124	1
4.30		18	47	128	1
4.37	11/64		47	128	1
4.39		17	47	128	1
4.40			47	128	1
4.50		16	47	128	1
4.57		15	47	128	1
4.60			47	128	1
4.62		14	47	128	1
4.70		13	47	128	1
4.76	3/16		52	133	1
4.80		12	52	133	1
4.85		11	52	133	1
4.90			52	133	1
4.91		10	52	133	1
4.98		9	52	133	1
5.00			52	133	1
5.06		8	52	133	1
5.10			52	133	1
5.11		7	52	133	1
5.16	13/64		52	133	1

Figures mentioned in **Red** are for reference only

Range of Application:
 For general purpose use.

**High Speed Steel
TAPER SHANK TWIST DRILLS
(With Standard Shank)**



Size (h8)			Flute Length	Overall Length	MT Shank No
mm	inch	No/Letter			
5.18		6	52	133	1
5.20			52	133	1
5.22		5	52	133	1
5.30			52	133	1
5.31		4	57	138	1
5.40			57	138	1
5.41		3	57	138	1
5.50			57	138	1
5.56	7/32		57	138	1
5.60			57	138	1
5.61		2	57	138	1
5.70			57	138	1
5.79		1	57	138	1
5.80			57	138	1
5.90			57	138	1
5.94		A	57	138	1
5.95	15/64		57	138	1
6.00			57	138	1
6.05		B	63	144	1
6.10			63	144	1
6.15		C	63	144	1
6.20			63	144	1
6.25		D	63	144	1
6.30			63	144	1
6.35	1/4	E	63	144	1
6.40			63	144	1
6.50			63	144	1
6.53		F	63	144	1
6.60			63	144	1
6.63		G	63	144	1
6.70			63	144	1
6.75	17/64		69	150	1
6.76		H	69	150	1
6.80			69	150	1
6.90			69	150	1
6.91		I	69	150	1
7.00			69	150	1
7.04		J	69	150	1
7.10			69	150	1
7.14	9/32	K	69	150	1
7.20			69	150	1
7.30			69	150	1
7.37		L	69	150	1
7.40			69	150	1
7.49		M	69	150	1
7.50			69	150	1
7.54	19/64		75	156	1
7.60			75	156	1
7.67		N	75	156	1

Figures mentioned in **Red** are for reference only
Range of Application:
For general purpose use.



TWIST DRILLS

Specifications conform to
IS 5103 : 2002
ISO 235/1 : 1980
BS 328 Part 1 : 1993
DIN 345 : 1978



TWIST DRILLS



Specifications conform to
 IS 5103 : 2002
 ISO 235/1 : 1980
 BS 328 Part 1 : 1993
 DIN 345 : 1978

High Speed Steel TAPER SHANK TWIST DRILLS (With Standard Shank)

Size (h8)			Flute Length	Overall Length	MT Shank No
mm	inch	Letter			
7.70			75	156	1
7.80			75	156	1
7.90			75	156	1
7.94	5/16		75	156	1
8.00			75	156	1
8.03		O	75	156	1
8.10			75	156	1
8.20		P	75	156	1
8.30			75	156	1
8.33	21/64		75	156	1
8.40			75	156	1
8.43		Q	75	156	1
8.50			75	156	1
8.60			81	162	1
8.61		R	81	162	1
8.70			81	162	1
8.73	11/32		81	162	1
8.80			81	162	1
8.84		S	81	162	1
8.90			81	162	1
9.00			81	162	1
9.09		T	81	162	1
9.10			81	162	1
9.13	23/64		81	162	1
9.20			81	162	1
9.30			81	162	1
9.35		U	81	162	1
9.40			81	162	1
9.50			81	162	1
9.52	3/8		87	168	1
9.58		V	87	168	1
9.60			87	168	1
9.70			87	168	1
9.80		W	87	168	1
9.90			87	168	1
9.92	25/64		87	168	1
10.00			87	168	1
10.08		X	87	168	1
10.10			87	168	1
10.20			87	168	1
10.26		Y	87	168	1
10.30			87	168	1
10.32	13/32		87	168	1
10.40			87	168	1
10.49		Z	87	168	1
10.50			87	168	1
10.60			87	168	1

Figures mentioned in **Red** are for reference only

Range of Application:
 For general purpose use.

**High Speed Steel
TAPER SHANK TWIST DRILLS
(With Standard Shank)**



Size (h8)		Flute Length	Overall Length	MT Shank No
mm	inch			
10.70		94	175	1
10.72	27/64	94	175	1
10.80		94	175	1
10.90		94	175	1
11.00		94	175	1
11.10		94	175	1
11.11	7/16	94	175	1
11.20		94	175	1
11.30		94	175	1
11.40		94	175	1
11.50		94	175	1
11.51	29/64	94	175	1
11.60		94	175	1
11.70		94	175	1
11.80		94	175	1
11.90		101	182	1
11.91	15/32	101	182	1
12.00		101	182	1
12.10		101	182	1
12.20		101	182	1
12.30	31/64	101	182	1
12.40		101	182	1
12.50		101	182	1
12.60		101	182	1
12.70	1/2	101	182	1
12.80		101	182	1
12.90		101	182	1
13.00		101	182	1
13.10	33/64	101	182	1
13.20		101	182	1
13.30		108	189	1
13.40		108	189	1
13.49	17/32	108	189	1
13.50		108	189	1
13.60		108	189	1
13.70		108	189	1
13.80		108	189	1
13.89	35/64	108	189	1
13.90		108	189	1
14.00		108	189	1
14.25		114	212	2
14.29	9/16	114	212	2
14.50		114	212	2
14.68	37/64	114	212	2
14.75		114	212	2
15.00		114	212	2
15.08	19/32	120	218	2

Figures mentioned in **Red** are for reference only

Range of Application:
For general purpose use.



TWIST DRILLS

Specifications conform to
IS 5103 : 2002
ISO 235/1 : 1980
BS 328 Part 1 : 1993
DIN 345 : 1978



TWIST DRILLS



Specifications conform to
 IS 5103 : 2002
 ISO 235/1 : 1980
 BS 328 Part 1 : 1993
 DIN 345 : 1978

High Speed Steel TAPER SHANK TWIST DRILLS (With Standard Shank)

Size (h8)		Flute Length	Overall Length	MT Shank No
mm	inch			
15.25		120	218	2
15.48	39/64	120	218	2
15.50		120	218	2
15.75		120	218	2
15.87	5/8	120	218	2
16.00		120	218	2
16.25		125	223	2
16.27	41/64	125	223	2
16.50		125	223	2
16.67	21/32	125	223	2
16.75		125	223	2
17.00		125	223	2
17.07	43/64	130	228	2
17.25		130	228	2
17.46	11/16	130	228	2
17.50		130	228	2
17.75		130	228	2
17.86	45/64	130	228	2
18.00		130	228	2
18.25		135	233	2
18.26	23/32	135	233	2
18.50		135	233	2
18.65	47/64	135	233	2
18.75		135	233	2
19.00		135	233	2
19.05	3/4	140	238	2
19.25		140	238	2
19.45	49/64	140	238	2
19.50		140	238	2
19.75		140	238	2
19.84	25/32	140	238	2
20.00		140	238	2
20.24	51/64	145	243	2
20.25		145	243	2
20.50		145	243	2
20.64	13/16	145	243	2
20.75		145	243	2
21.00		145	243	2
21.03	53/64	145	243	2
21.25		150	248	2
21.43	27/32	150	248	2
21.50		150	248	2
21.75		150	248	2
21.83	55/64	150	248	2
22.00		150	248	2
22.22	7/8	150	248	2
22.25		150	248	2

Figures mentioned in **Red** are for reference only

Range of Application:
 For general purpose use.

**High Speed Steel
TAPER SHANK TWIST DRILLS
(With Standard Shank)**



Size (h8)		Flute Length	Overall Length	MT Shank No
mm	inch			
22.50		155	253	2
22.62	57/64	155	253	2
22.75		155	253	2
23.00		155	253	2
23.02	29/32	155	253	2
23.25		155	276	3
23.42	59/64	155	276	3
23.50		155	276	3
23.75		160	281	3
23.81	15/16	160	281	3
24.00		160	281	3
24.21	61/64	160	281	3
24.25		160	281	3
24.50		160	281	3
24.61	31/32	160	281	3
24.75		160	281	3
25.00	63/64	160	281	3
25.25		165	286	3
25.40	1	165	286	3
25.50		165	286	3
25.75		165	286	3
26.00		165	286	3
26.19	1.1/32	165	286	3
26.25		165	286	3
26.50		165	286	3
26.75		170	291	3
26.99	1.1/16	170	291	3
27.00		170	291	3
27.25		170	291	3
27.50		170	291	3
27.75		170	291	3
27.78	1.3/32	170	291	3
28.00		170	291	3
28.25		175	296	3
28.50		175	296	3
28.57	1.1/8	175	296	3
28.75		175	296	3
29.00		175	296	3
29.25		175	296	3
29.37	1.5/32	175	296	3
29.50		175	296	3
29.75		175	296	3
30.00		175	296	3
30.16	1.3/16	180	301	3
30.25		180	301	3
30.50		180	301	3
30.75		180	301	3

Figures mentioned in **Red** are for reference only

Range of Application:
For general purpose use.



TWIST DRILLS

Specifications conform to
IS 5103 : 2002
ISO 235/1 : 1980
BS 328 Part 1 : 1993
DIN 345 : 1978



TWIST DRILLS



Specifications conform to
 IS 5103 : 2002
 ISO 235/1 : 1980
 BS 328 Part 1 : 1993
 DIN 345 : 1978

High Speed Steel TAPER SHANK TWIST DRILLS (With Standard Shank)

Size (h8)		Flute Length	Overall Length	MT Shank No
mm	inch			
30.96	1.7/32	180	301	3
31.00		180	301	3
31.25		180	301	3
31.50		180	301	3
31.75	1.1/4	185	306	3
32.00		185	334	4
32.50		185	334	4
32.54	1.9/32	185	334	4
33.00		185	334	4
33.34	1.5/16	185	334	4
33.50		185	334	4
34.00		190	339	4
34.13	1.11/32	190	339	4
34.50		190	339	4
34.92	1.3/8	190	339	4
35.00		190	339	4
35.50		190	339	4
35.72	1.13/32	195	344	4
36.00		195	344	4
36.50		195	344	4
36.51	1.7/16	195	344	4
37.00		195	344	4
37.31	1.15/32	195	344	4
37.50		195	344	4
38.00		200	349	4
38.10	1.1/2	200	349	4
38.50		200	349	4
38.89	1.17/32	200	349	4
39.00		200	349	4
39.50		200	349	4
39.69	1.9/16	200	349	4
40.00		200	349	4
40.48	1.19/32	205	354	4
40.50		205	354	4
41.00		205	354	4
41.27	1.5/8	205	354	4
41.50		205	354	4
42.00		205	354	4
42.07	1.21/32	205	354	4
42.50		205	354	4
42.86	1.11/16	210	359	4
43.00		210	359	4
43.50		210	359	4
43.66	1.23/32	210	359	4
44.00		210	359	4
44.45	1.3/4	210	359	4
44.50		210	359	4

Figures mentioned in **Red** are for reference only

Range of Application:
 For general purpose use.

**High Speed Steel
TAPER SHANK TWIST DRILLS
(With Standard Shank)**



Size (h8)		Flute Length	Overall Length	MT Shank No
mm	inch			
45.00		210	359	4
45.24	1.25/32	215	364	4
45.50		215	364	4
46.00		215	364	4
46.04	1.13/16	215	364	4
46.50		215	364	4
46.83	1.27/32	215	364	4
47.00		215	364	4
47.50		215	364	4
47.62	1.7/8	220	369	4
48.00		220	369	4
48.42	1.29/32	220	369	4
48.50		220	369	4
49.00		220	369	4
49.21	1.15/16	220	369	4
49.50		220	369	4
50.00		220	369	4
50.01	1.31/32	225	374	4
50.50		225	374	4
50.80	2	225	374	4
51.00		225	412	5
52.00		225	412	5
52.39	2.1/16	225	412	5
53.00		225	412	5
53.97	2.1/8	230	417	5
54.00		230	417	5
55.00		230	417	5
55.56	2.3/16	230	417	5
56.00		230	417	5
57.00		235	422	5
57.15	2.1/4	235	422	5
58.00		235	422	5
58.74	2.5/16	235	422	5
59.00		235	422	5
60.00		235	422	5
60.32	2.3/8	240	427	5
61.00		240	427	5
61.91	2.7/16	240	427	5
62.00		240	427	5
63.00		240	427	5
63.50	2.1/2	245	432	5
64.00		245	432	5
65.00		245	432	5
65.09	2.9/16	245	432	5
66.00		245	432	5
66.67	2.5/8	245	432	5
67.00		245	432	5

Figures mentioned in **Red** are for reference only

Range of Application:
For general purpose use.



TWIST DRILLS

Specifications conform to
IS 5103 : 2002
ISO 235/1 : 1980
BS 328 Part 1 : 1993
DIN 345 : 1978



TWIST DRILLS



Specifications conform to
 IS 5103 : 2002
 ISO 235/1 : 1980
 BS 328 Part 1 : 1993
 DIN 345 : 1978

High Speed Steel TAPER SHANK TWIST DRILLS (With Standard Shank)

Size (h8)		Flute Length	Overall Length	MT Shank No
mm	inch			
68.00		250	437	5
68.26	2.11/16	250	437	5
69.00		250	437	5
69.85	2.3/4	250	437	5
70.00		250	437	5
71.00		250	437	5
71.44	2.13/16	255	442	5
72.00		255	442	5
73.00		255	442	5
73.02	2.7/8	255	442	5
74.00		255	442	5
74.61	2.15/16	255	442	5
75.00		255	442	5
76.00		260	447	5
76.20	3	260	447	5
77.00		260	514	6
77.79	3.1/16	260	514	6
78.00		260	514	6
79.00		260	514	6
79.37	3.1/8	260	514	6
80.00		260	514	6
80.96	3.3/16	265	519	6
81.00		265	519	6
82.00		265	519	6
82.55	3.1/4	265	519	6
83.00		265	519	6
84.00		265	519	6
84.14	3.5/16	265	519	6
85.00		265	519	6
85.72	3.3/8	270	524	6
86.00		270	524	6
87.00		270	524	6
87.31	3.7/16	270	524	6
88.00		270	524	6
88.90	3.1/2	270	524	6
89.00		270	524	6
90.00		270	524	6
90.49	3.9/16	275	529	6
91.00		275	529	6
92.00		275	529	6
92.07	3.5/8	275	529	6
93.00		275	529	6
93.66	3.11/16	275	529	6
94.00		275	529	6
95.00		275	529	6
95.25	3.3/4	280	534	6
96.00		280	534	6

Figures mentioned in **Red** are for reference only

Range of Application:
 For general purpose use.

**High Speed Steel
TAPER SHANK TWIST DRILLS
(With Standard Shank)**



Size (h8)		Flute Length	Overall Length	MT Shank No
mm	inch			
96.84	3.13/16	280	534	6
97.00		280	534	6
98.00		280	534	6
98.42	3.7/8	280	534	6
99.00		280	534	6
100.00		280	534	6
100.01	3.15/16	285	539	6
101.00		285	539	6
101.60	4	285	539	6
102.00		285	539	6
103.00		285	539	6
104.00		285	539	6
105.00		285	539	6
106.00		285	539	6

Figures mentioned in **Red** are for reference only



TWIST DRILLS

Specifications conform to
IS 5103 : 2002
ISO 235/1 : 1980
BS 328 Part 1 : 1993
DIN 345 : 1978

Range of Application:
For general purpose use.