



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



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Diameters 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

Diameters 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

Diameters 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

Diameters 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	253	3
23.50	59/64	155	253	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

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

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

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Diameters 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

Diameters 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

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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	3.1/18	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

ADDISON High Speed Steel TAPER SHANK TWIST DRILLS

Specifications Conform to: ASME B94.11M - 1993
Dimensions in mm / Inch

ADDISON High Speed Steel TAPER SHANK TWIST DRILLS

Specifications Conform to: ASME B94.11M - 1993
Dimensions in mm / Inch



Diameter h8		REGULAR SHANK		
Fraction	mm	Flute Length	Overall Length	Morse Taper No.
1/8	3.00	48	130	1
-	3.20	54	137	1
9/64	3.50	54	137	1
5/32	3.80	54	137	1
-	4.00	64	146	1
11/64	4.20	64	146	1
3/16	4.50	64	146	1
-	4.80	70	152	1
-	5.00	70	152	1
13/64	5.20	70	152	1
7/32	5.50	70	152	1
-	5.80	73	156	1
15/64	6.00	73	156	1
1/4	6.20	73	156	1
-	6.50	76	159	1
17/64	6.80	76	159	1
9/32	7.00	76	159	1
-	7.20	79	162	1
19/64	7.50	79	162	1
5/16	7.80	79	162	1
-	8.00	83	165	1

Diameter h8		REGULAR SHANK		
Fraction	mm	Flute Length	Overall Length	Morse Taper No.
21/64	8.20	83	165	1
11/32	8.50	83	165	1
-	8.80	89	171	1
-	9.00	89	171	1
23/64	9.20	89	171	1
3/8	9.50	89	171	1
-	9.80	92	178	1
25/64	10.00	92	178	1
13/32	10.20	92	178	1
-	10.50	98	184	1
27/64	10.80	98	184	1
7/16	11.00	98	184	1
-	11.20	105	190	1
29/64	11.50	105	190	1
15/32	11.80	105	190	1
-	12.00	111	210	2
31/64	12.20	111	210	2
1/2	12.50	111	210	2
-	12.80	117	216	2
33/64	13.00	117	216	2
-	13.20	117	216	2

Diameter h8		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 h8		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	165	283	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	3
1.13/64,1.7/32	30.50	190	353	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



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Diameter h8		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
	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 h8		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	324	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