



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

Specifications Conform to:  
 IS 5100 - 1969  
 ISO 235 - 1980  
 DIN 1897 - 1984  
 BS328 : Part 1 : 1986  
 Dimensions in mm / Inch



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Diameters h8		Flute Length	Overall Length
mm	Inches		
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

Diameters h8		Flute Length	Overall Length
mm	Inches		
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

Diameters h8		Flute Length	Overall Length
mm	Inches		
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

Diameters h8		Flute Length	Overall Length
mm	Inches		
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

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.



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Diameters h8		Flute Length	Overall Length
mm	Inches		
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

Diameters h8		Flute Length	Overall Length
mm	Inches		
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