



## High Speed Steel PARALLEL SHANK TWIST DRILLS Long Series

Specifications Conform to :  
 IS 5102 - 1969  
 ISO 494 - 1975  
 DIN 340 - 1978  
 BS328 : Part 1 : 1986  
 Dimensions in mm / Inch



Diameters h8		Flute Length	Overall Length
mm	Inches		
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

Diameters h8		Flute Length	Overall Length
mm	Inches		
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 parallel shank jobber series twist drill, the increase in length being in the flute length.

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

**ADDISON** High Speed Steel  
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Diameters h8		Flute Length	Overall Length
mm	Inches		
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

Diameters h8		Flute Length	Overall Length
mm	Inches		
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

Diameters h8		Flute Length	Overall Length
mm	Inches		
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

Diameters h8		Flute Length	Overall Length
mm	Inches		
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



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Diameters h8		Flute Length <sup>h</sup>	Overall Length <sup>h</sup>
mm	Inches		
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

Diameters h8		Flute Length <sup>h</sup>	Overall Length <sup>h</sup>
mm	Inches		
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