

High Speed Steel
SUBLAND TWIST DRILLS
WITH PARALLEL SHANK

Specifications Conform to :
 IS 12692 : 1989
 Dimensions in mm

For Clearance holes and countersinks for countersunk head screws

High Speed Steel
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Specifications Conform to :
 IS 12691 : 1989
 Dimensions in mm

For Clearance holes and countersinks for countersunk head screws



For Medium Series Type - A Countersinks

| Body Dia h ₈ | Small Dia h ₉ | Step Length | Flute Length | Overall Length | Suitable for Countersunk Head Screws |
|----------------------------|-----------------------------|----------------|-----------------|-------------------|--|
| 13.00 | 6.60 | 15.00 | 101.00 | 151.00 | M6 x 1 |
| 17.20 | 9.00 | 19.00 | 130.00 | 191.00 | M8 x 1.25 |

| Body Dia h ₈ | Small Dia h ₉ | Step Length | Flute Length | Overall Length | Suitable for screw threads |
|----------------------------|-----------------------------|----------------|-----------------|-------------------|-------------------------------|
| 9.00 | 6.80 | 21.00 | 81.00 | 125.00 | M8 x 1.25 |
| 11.00 | 8.50 | 25.50 | 94.00 | 142.00 | M10 x 1.50 |
| 14.00 | 10.20 | 30.00 | 108.00 | 160.00 | M12 x 1.75 |
| 15.50 | 12.00 | 34.50 | 120.00 | 178.00 | M14 x 2.0 |

For Fine Series Type - A Countersinks

| Body Dia h ₈ | Small Dia h ₉ | Step Length | Flute Length | Overall Length | Suitable for Countersunk Head Screws |
|----------------------------|-----------------------------|----------------|-----------------|-------------------|--|
| 11.50 | 6.40 | 15.00 | 94.00 | 142.00 | M6 x 0.75 |
| 15.00 | 8.40 | 19.00 | 114.00 | 169.00 | M8 x 0.75 |
| 19.00 | 10.50 | 23.00 | 135.00 | 198.00 | M10 x 0.75 |

Tool Type 'N' Subland Drills shall be supplied Unless otherwise Specified.

Note : For fine pitch threads, subland twist drills shall be manufactured to the same dimensions of 'd', 'L', 'L1' and 'L2'. They can be ordered as special tools and diameter 'd1' must be specified in such cases as given in IS : 10952 - 1984
 Tool Type 'N' subland drills shall be supplied unless otherwise specified

ADDISON

**High Speed Steel
SUBLAND TWIST DRILLS
WITH PARALLEL SHANK**

Specifications Conform to :
IS 12689 : 1989
Dimensions in mm

For Clearance holes and counterbores for slotted cheese head screws



| Body Dia h ₈ | Small Dia h ₉ | Step Length | Flute Length | Overall Length | Suitable for Cheese Head Screws |
|----------------------------|-----------------------------|----------------|-----------------|-------------------|---------------------------------------|
| 11.00 | 6.60 | 15.00 | 94.00 | 142.00 | M6 x 1 |
| 15.00 | 9.00 | 19.00 | 114.00 | 169.00 | M8 x 1.25 |
| 18.00 | 11.00 | 23.00 | 130.00 | 191.00 | M10 x 1.50 |

Tool Type 'N' Subland Drills shall be supplied Unless otherwise Specified.

ADDISON

**High Speed Steel
SUBLAND TWIST DRILLS WITH
MORSE TAPER SHANK**

Specifications Conform to :
IS 12688 : 1989
Dimensions in mm

for Clearance holes and countersinks for Countersunk head Screws



| Body Dia h ₈ | Small Dia h ₉ | Step Length | Flute Length | Overall Length | Morse Taper No. | Suitable for Countersunk Head Screws |
|----------------------------|-----------------------------|----------------|-----------------|-------------------|--------------------|--|
| 13.00 | 6.60 | 15.00 | 101.00 | 182.00 | 1 | M6 x 1 |
| 17.20 | 9.00 | 19.00 | 130.00 | 228.00 | 2 | M8 x 1.25 |
| 21.50 | 11.00 | 23.00 | 150.00 | 248.00 | 2 | M10 x 1.50 |
| 25.00 | 13.50 | 27.00 | 160.00 | 281.00 | 3 | M12 x 1.75 |
| 28.00 | 15.50 | 31.00 | 170.00 | 291.00 | 3 | M14 x 2.0 |

Tool Type 'N' subland drills shall be supplied unless otherwise Specified.