



**High Speed Steel
SUBLAND TWIST DRILLS
WITH MORSE TAPER SHANK**
for holes prior to tapping Screws threads

Specifications Conform to :
IS 12687 : 1989
Dimensions in mm



Big Dia h ₁	Small Dia h ₂	Step Length	Flute Length	Overall Length	Morse Taper No.	Suitable for Screw Threads
9.00	6.80	21.00	81.00	162	1	M8 x 1.25
11.00	8.50	25.50	94.00	175	1	M10 x 1.50
14.00	10.20	30.00	108.00	189	1	M12 x 1.75
16.00	12.00	34.50	120.00	218	2	M14 x 2.00
18.00	14.00	38.50	130.00	228	2	M16 x 2.00
20.00	15.50	43.50	140.00	238	2	M18 x 2.50
22.00	17.50	47.50	150.00	248	2	M20 x 2.50
24.00	19.50	51.50	160.00	281	3	M22 x 2.50
26.00	21.00	56.50	165.00	286	3	M24 x 3.00
30.00	24.00	62.50	175.00	296	3	M27 x 3.00
33.00	26.50	70.00	185.00	334	4	M30 x 3.50

Note : For fine pitch threads, subland twist drills shall be manufactured to the same dimensions of 'Big Diameter', 'Small End Diameter', 'Overall Length', 'Step Length' and 'Flute Length' and Morse Taper Number as given in the above table. But can be ordered as special tool with 'Big Diameter' and 'Small End Diameter' specified according to IS : 10952 - 1984.

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



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

for Clearance holes and counterbores for slotted cheese head screws

Specifications Conform to:
IS 12690 : 1989
Dimensions in mm



Big Dia h ₁	Small Dia h ₂	Step Length	Flute Length	Overall Length	Morse Taper No.	Suitable for Slotted Cheese head screws
11.00	6.60	15.00	94.00	175	1	M6 x 1.00
15.00	9.00	19.00	114.00	212	2	M8 x 1.25
18.00	11.00	23.00	130.00	228	2	M10 x 1.50
20.00	13.50	27.00	140.00	238	2	M12 x 1.75
24.00	15.50	31.00	160.00	281	3	M14 x 2.00
26.00	17.50	35.00	165.00	286	3	M16 x 2.00
30.00	20.00	39.00	175.00	296	3	M18 x 2.50
33.00	22.00	43.00	185.00	334	4	M20 x 2.50

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