

INSTRUCTION FOR HSS TWIST DRILL



1 PRODUCTION TECHNICS

	Roll Forged
	Roll&Edge Ground
	Fully Ground

2 SURFACE FINISHING

	Black Finished
	Black & bright
	Bright Finished
	Tin Coated
	Rainbow Color
	Bronze Oxide
	Black&Gold
	Amber

3 MATERIAL

HSS-M2/W9341/W4341/W4241	Roll Forged/Edge Ground
HSS-M35/M2/W9341/W4341/W4241	Fully Ground

4 CUTTING EDGE

	118° General Angle
	118° /135° Split Point

5 REDUCED SHANK

	1/4 shank (6.5mm)
	3/8 shank (10.0mm)
	1/2 shank (13.0mm)

HSS STRAIGHT SHANK TWIST DRILL

DIN338



NOTE: SPLIT POINT AVAILABLE FROM 3MM ON.

DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)
1.0	1/32	12	34	4.0	5/32	43	75	7.5	19/64	69	109	11.0	27/64, 7/16	94	142	14.5	9/16	114	169	18.0	45/64	130	191
1.5	3/64	18	40	4.5	11/64	47	80	8.0	5/16	75	117	11.5	29/64	94	142	15.0	37/64	114	169	18.5	23/32	135	198
2.0	1/16, 5/64	24	49	5.0	3/16	52	86	8.5	21/64	75	117	12.0	15/32	101	151	15.5	19/32, 39/64	120	178	19.0	47/64	135	198
2.5	3/32	30	57	5.5	13/64, 7/32	57	93	9.0	11/32, 23/64	81	125	12.5	31/64	101	151	16.0	5/8	120	178	19.5	3/4, 49/64	140	205
3.0	7/64	33	61	6.0	15/64	57	93	9.5	3/8	81	125	13.0	1/2	101	151	16.5	41/64	125	184	20.0	25/32	140	205
3.2	1/8	36	65	6.5	1/4, 17/64	63	101	10.0	25/64	87	133	13.5	33/64, 17/32	108	160	17.0	21/32	125	184				
3.5	9/64	39	70	7.0	9/32	69	109	10.5	13/32	87	133	14.0	35/64	108	160	17.5	43/64, 11/16	130	191				

DIN340



NOTE: SPLIT POINT AVAILABLE FROM 3MM ON.

DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)
1.0	1/32	33	56	3.2	1/8	69	106	5.5	13/64, 7/32	91	139	8.0	5/16	109	165	10.5	13/32	121	184	13.0	1/2	134	205
1.5	3/64	45	70	3.5	9/64	73	110	6.0	15/64	91	139	8.5	21/64	109	165	11.0	27/64, 7/16	128	195				
2.0	1/16, 5/64	56	85	4.0	5/32	78	119	6.5	1/4, 17/64	97	148	9.0	11/32, 23/64	115	175	11.5	29/64	128	195				
2.5	3/32	62	95	4.5	11/64	82	126	7.0	9/32	102	156	9.5	3/8	115	175	12.0	15/32	134	205				
3.0	7/64	63	100	5.0	3/16	87	132	7.5	19/64	102	156	10.0	25/64	121	184	12.5	31/64	134	205				

DIN1897



NOTE: SPLIT POINT AVAILABLE FROM 3MM ON.

DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)	DIA (MM)	INCH (")	L2 (MM)	L1 (MM)
1.0	1/32	6	26	3.2	1/8	18	49	5.5	13/64, 7/32	28	66	8.0	5/16	37	79	10.5	13/32	43	89	13.0	1/2	51	102
1.5	3/64	9	32	3.5	9/64	20	52	6.0	15/64	28	66	8.5	21/64	37	79	11.0	27/64, 7/16	47	95				
2.0	1/16, 5/64	12	38	4.0	5/32	22	55	6.5	1/4, 17/64	31	70	9.0	11/32, 23/64	40	84	11.5	29/64	47	95				
2.5	3/32	14	43	4.5	11/64	24	58	7.0	9/32	34	74	9.5	3/8	40	84	12.0	15/32	51	102				
3.0	7/64	16	46	5.0	3/16	26	62	7.5	19/64	34	74	10.0	25/64	43	89	12.5	31/64	51	102				

DIN1869



DIA (MM)	L2 (MM)	L1 (MM)	DIA (MM)	L2 (MM)	L1 (MM)	DIA (MM)	L2 (MM)	L1 (MM)	DIA (MM)	L2 (MM)	L1 (MM)	DIA (MM)	L2 (MM)	L1 (MM)	DIA (MM)	L2 (MM)	L1 (MM)	DIA (MM)	L2 (MM)	L1 (MM)
3.0	130	190	8.0	210	190	13.0	260	375	8.0	265	390	13.0	330	480	6.5	150	215	11.5	195	280
3.5	145	210	8.5	210	210	3.5	180	265	8.5	265	390	2.0	85	125	7.0	155	225			
4.0	150	220	9.0	220	220	4.0	190	280	9.0	280	410	2.5	95	140	7.5	155	225			
4.5	160	235	9.5	220	235	4.5	200	295	9.5	280	410	3.0	100	150	8.0	165	240	12.0	205	295
5.0	170	245	10.0	235	245	5.0	210	315	10.0	295	430	3.5	115	165	8.5	165	240			
5.5	180	260	10.5	235	260	5.5	225	330	10.5	295	430	4.0	120	175	9.0	175	250			
6.0	180	260	11.0	250	260	6.0	225	330	11.0	310	455	4.5	125	185	9.5	175	250	12.5	205	295
6.5	190	275	11.5	250	275	6.5	235	350	11.5	310	455	5.0	135	195	10.0	185	265			
7.0	200	290	12.0	260	290	7.0	250	370	12.0	330	480	5.5	140	205	10.5	185	265			
7.5	200	290	12.5	260	290	7.5	250	370	12.5	330	480	6.0	140	205	11.0	195	280	13.0	205	295