


# HIGH SPEED STEEL TAPER LENGTH DRILLS

**ICS USA**

**GENERAL PURPOSE**

**118° POINT**

Taper length drills are general purpose drills with increased cutting length. They are manufactured with straight shanks of the same diameter as that of the flute diameter. Taper length drills derive their name from having the same flute length as taper shank drills. In Europe these drills are known as Long Series Drills or Long Jobber Drills.

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA
<b>TLD</b>	 OXIDE FINISH	For general purpose drilling where a longer than jobber length drill is required.	M2	118° Point Std. Spiral Std. Web

## Fractional Sizes (Straight Shank) 1/16 To 2" Dia.

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS
				OXIDE FINISH 118° PT TLD
1/16	.0625	1-3/4	3	\$2.70
5/64	.0781	2	3-3/4	2.94
3/32	.0938	2-1/4	4-1/4	3.60
7/64	.1094	2-1/2	4-5/8	4.48
1/8	.1250	2-3/4	5-1/8	4.60
9/64	.1406	3	5-3/8	6.04
5/32	.1562	3	5-3/8	5.50
11/64	.1719	3-3/8	5-3/4	6.46
3/16	.1875	3-3/8	5-3/4	5.58
13/64	.2031	3-5/8	6	7.46
7/32	.2188	3-5/8	6	7.98
15/64	.2344	3-3/4	6-1/8	7.98
1/4	.2500	3-3/4	6-1/8	6.56
17/64	.2656	3-7/8	6-1/4	8.36
9/32	.2812	3-7/8	6-1/4	7.98
19/64	.2969	4	6-3/8	9.12
5/16	.3125	4	6-3/8	7.98
21/64	.3281	4-1/8	6-1/2	9.38
11/32	.3438	4-1/8	6-1/2	9.12
23/64	.3594	4-1/4	6-3/4	10.76
3/8	.3750	4-1/4	6-3/4	10.76
25/64	.3906	4-3/8	7	11.30
13/32	.4062	4-3/8	7	11.30
27/64	.4219	4-5/8	7-1/4	12.40
7/16	.4375	4-5/8	7-1/4	12.60
29/64	.4531	4-3/4	7-1/2	13.98
15/32	.4688	4-3/4	7-1/2	14.84
31/64	.4844	4-3/4	7-3/4	16.24
1/2	.5000	4-3/4	7-3/4	15.68
33/64	.5156	4-3/4	8	26.00
17/32	.5312	4-3/4	8	27.42
35/64	.5469	4-7/8	8-1/4	28.80
9/16	.5625	4-7/8	8-1/4	28.80
37/64	.5781	4-7/8	8-1/4	33.50
19/32	.5938	4-7/8	8-3/4	33.50
39/64	.6094	4-7/8	8-3/4	34.66
5/8	.6250	4-7/8	8-3/4	34.66
41/64	.6406	5-1/8	9	39.66
21/32	.6562	5-1/8	9	39.66
43/64	.6719	5-3/8	9-1/4	46.66
11/16	.6875	5-3/8	9-1/4	47.22

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS
				OXIDE FINISH 118° PT TLD
45/64	.7031	5-5/8	9 -1/2	\$49.14
23/32	.7188	5-5/8	9 -1/2	49.14
47/64	.7344	5-7/8	9 -3/4	52.64
3/4	.7500	5-7/8	9 -3/4	25.64
49/64	.7656	6	9 -7/8	57.46
25/32	.7812	6	9 -7/8	57.46
51/64	.7969	6-1/8	10	61.82
13/16	.8125	6-1/8	10	61.82
53/64	.8281	6-1/8	10	64.96
27/32	.8438	6-1/8	10	64.96
55/64	.8594	6-1/8	10	68.32
7/8	.8750	6-1/8	10	62.72
57/64	.8906	6-1/8	10	71.20
29/32	.9062	6-1/8	10	71.20
59/64	.9219	6-1/8	10 -3/4	77.46
15/16	.9375	6-1/8	10 -3/4	77.46
61/64	.9531	6-3/8	11	85.46
31/32	.9688	6-3/8	11	85.46
63/64	.9844	6-3/8	11	89.08
1	1.0000	6-3/8	11	89.08
1-1/32	1.0312	6-1/2	11 -1/8	106.66
1-1/16	1.0625	6-5/8	11 -1/4	110.30
1-3/32	1.0938	6-7/8	11 -1/2	118.34
1-1/8	1.1250	7-1/8	11 -3/4	122.82
1-5/32	1.1562	7-1/4	11 -7/8	133.68
1-3/16	1.1875	7-3/8	12	143.92
1-7/32	1.2188	7-1/2	12 -1/8	148.20
1-1/4	1.2500	7-7/8	12 -1/2	154.16
1-5/16	1.3125	8-5/8	14 -1/4	183.96
1-3/8	1.3750	8-7/8	14 -1/2	197.28
1-7/16	1.4375	9-1/8	14 -3/4	214.98
1-1/2	1.5000	9-3/8	15	241.02
1-9/16	1.5625	9-5/8	15 -1/4	269.68
1-5/8	1.6250	9-7/8	15 -5/8	304.50
1-11/16	1.6875	10	15 -3/4	345.40
1-3/4	1.7500	10-1/2	16 -1/4	366.92
1-13/16	1.8125	10-1/2	16 -1/4	437.46
1-7/8	1.8750	10-3/4	16 -1/2	495.78
1-15/16	1.9375	10-3/4	16 -5/8	495.78
2	2.0000	10-3/4	16 -5/8	495.78

**PACKAGING**

1/16 To 1/4 - 12 Drills/Envelope  
 17/64 To 3/8 - 6 Drills/Tube  
 25/64 To 2" - 1 Drill/Tube