


HIGH SPEED STEEL METRIC TAPER SHANK DRILLS

ICS USA

GENERAL PURPOSE

118° POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA
TSD-M	 OXIDE FINISH	Taper Shank Drills have a tapered conical shank to fit directly into the tapered holes of drill press spindles, driving sleeves or sockets. They are designed for general purpose drilling in ferrous or non-ferrous metals.	M2	118° Point Std. Spiral Std. Web

Metric Sizes (Regular Shank) 2.00mm To 21.00mm Dia.

HSS					HSS					HSS				
SIZE mm	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	OXIDE FINISH 118° PT TSD-M	SIZE mm	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	OXIDE FINISH 118° PT TSD-M	SIZE mm	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	OXIDE FINISH 118° PT TSD-M
#1 MT SHANK					#1 MT SHANK					#1 MT SHANK				
2.00	.0787	15/16	4-1/8		6.75	.2657	2-23/32	5-29/32		11.80	.4646	3-11/16	6-7/8	34.90
2.25	.0886	1-1/16	4-1/4		6.80	.2677			17.66	12.00	.4724	3-31/32	7-5/32	33.34
2.50	.0984	1-3/16	4-3/8		6.90	.2717				12.20	.4830			39.82
2.75	.1083	1-5/16	4-1/2		7.00	.2756			16.90	12.50	.4921			33.34
3.00	.1181			18.70	7.20	.2835			17.82	12.75	.5020			
3.25	.1280	1-7/16	4-5/8		7.25	.2854				12.80	.5039			40.84
3.30	.1299				7.40	.2913				13.00	.5118			41.68
3.50	.1378	1-17/32	4-3/4	18.70	7.50	.2953			16.90	13.25	.5217	4-1/4	7-7/16	
3.70	.1457				7.70	.3031	2-15/16	6-1/8		13.50	.5315			41.68
3.75	.1476				7.75	.3051				13.75	.5413			
3.80	.1496	1-11/16	4-27/32	19.58	7.80	.3075			18.74	14.00	.5512			41.68
3.90	.1535				8.00	.3150			22.90	#2 MT SHANK				
4.00	.1575			18.70	8.20	.3228			24.30	14.25	.5610	4-1/2	8-3/8	46.56
4.10	.1614				8.25	.3248				14.50	.5709			45.84
4.20	.1654			19.58	8.40	.3307				14.75	.5807			51.78
4.25	.1673				8.50	.3346			25.00	15.00	.5906			45.84
4.30	.1693	1-27/32	5-1/32		8.60	.3386	3-3/16	6-3/8		15.25	.6004	4-3/4	8-5/8	48.68
4.40	.1732				8.75	.3445				15.50	.6102			50.00
4.50	.1772			15.30	8.80	.3465			27.30	15.75	.6201			50.00
4.60	.1811				9.00	.3543			25.00	16.00	.6299			50.00
4.70	.1850				9.25	.3642				16.25	.6398	4-7/8	8-3/4	48.68
4.75	.1870				9.30	.3661				16.50	.6496			54.18
4.80	.1890	2-1/16	5-1/4		9.50	.3740			25.00	16.75	.6594			61.70
4.90	.1929				9.75	.3839	3-7/16	6-5/8		17.00	.6693			58.34
5.00	.1968			15.26	9.80	.3858			26.62	17.25	.6791	5-1/8	9	61.64
5.10	.2008				10.00	.3937			25.00	17.50	.6890			58.34
5.20	.2047			15.30	10.10	.3976				17.75	.6988			
5.25	.2067				10.20	.4016			27.34	18.00	.7087			62.50
5.30	.2087				10.25	.4035				18.25	.7185	5-1/4	9-1/8	
5.40	.2126	2-1/4	5-7/16		10.30	.4055			29.18	18.50	.7283			66.68
5.50	.2165				10.50	.4134				18.75	.7382			
5.60	.2205				10.75	.4232	3-11/16	6-7/8		19.00	.7480			70.84
5.75	.2264				10.80	.4252			29.0	19.25	.7579	5-1/2	9-3/8	
5.80	.2283			15.26	11.00	.4331			29.18	19.50	.7677			75.00
6.00	.2362			15.92	11.20	.4409			32.16	19.75	.7776			
6.10	.2402	2-1/2	5-11/16		11.25	.4429				20.00	.7874			79.18
6.20	.2441			16.90	11.40	.4480				20.25	.7922	5-3/4	9-5/8	
6.25	.2461				11.50	.4528			29.18	20.50	.8071			79.18
6.50	.2559			16.90	11.70	.4606				20.75	.8169			
6.60	.2598				11.75	.4626				21.00	.8268			83.34

Please inquire for price and delivery for sizes listed without pricing.