

# HIGH SPEED STEEL EXTRA LENGTH TAPER SHANK DRILLS

ICS USA

GENERAL PURPOSE

118° POINT



High Speed Steel Extra Length Taper Shank Drills with a 118° point are designed for drilling very deep holes in ferrous or non-ferrous metals, or drilling in difficult to reach locations. Extra length taper shank drills are preferred for drilling medium to large diameter deep holes as they can require a huge amount of rotational power on the shank for drilling.

## Fractional Sizes (Regular MT Shank) 1-1/16" to 2" Dia.

SIZE	DEC. EQUIV.	MORSE TAPER NO.	15" OVERALL		18" OVERALL		24" OVERALL		30" OVERALL	
			FLUTE LENGTH	OXIDE FINISH 118° POINT	FLUTE LENGTH	OXIDE FINISH 118° POINT	FLUTE LENGTH	OXIDE FINISH 118° POINT	FLUTE LENGTH	OXIDE FINISH 118° POINT
			TSD-15		TSD-18		TSD-24		TSD-30	
1-1/16	1.0625	3	10	210.00	13	271.66	19	432.74	25	512.74
1-1/8	1.1250	4	10	230.16	12	274.86	18	453.02	24	862.02
1-3/16	1.1875	4	10	257.54	12	298.60	18	480.70	24	644.46
1-1/4	1.2500	4	9	282.14	12	318.40	18	497.70	24	1017.24
1-5/16	1.3125	4	-	-	12	355.16	18	500.82	24	787.92
1-3/8	1.3750	4	-	-	12	385.62	18	532.90	24	850.26
1-7/16	1.4375	4	-	-	12	392.68	18	548.60	24	882.00
1-1/2	1.5000	4	-	-	12	416.02	18	671.56	24	926.70
1-5/8	1.6250	5	-	-	10	502.74	17	680.62	23	1033.70
1-3/4	1.7500	5	-	-	10	563.66	17	766.12	23	1111.32
1-7/8	1.8750	5	-	-	10	626.06	17	842.44	23	1170.38
2	2.0000	5	-	-	-	-	17	943.74	23	1366.52

## Metric Sizes (Regular MT Shank) 6.00mm to 50.00mm Dia.

SIZE mm	DEC. EQUIV.	MORSE TAPER NO.	315mm OAL (12")		400mm OAL (15")		500mm OAL (19-1/2")		630mm OAL (25")	
			FLUTE LENGTH	OXIDE FINISH 118° POINT	FLUTE LENGTH	OXIDE FINISH 118° POINT	FLUTE LENGTH	OXIDE FINISH 118° POINT	FLUTE LENGTH	OXIDE FINISH 118° POINT
			TSDM-12		TSDM-15		TSDM-19		TSDM-25	
6.00	.2362	1	8	175.14	-	-	-	-	-	-
6.50	.2559	1	-	-	-	-	-	-	-	-
7.00	.2756	1	-	-	-	-	-	-	-	-
7.50	.2953	1	-	-	-	-	-	-	-	-
8.00	.3150	1	8	93.82	12	106.72	16	163.14	-	-
8.50	.3346	1	8	93.82	12	129.28	-	-	-	-
9.00	.3543	1	8	116.90	-	-	-	-	-	-
9.50	.3740	1	-	-	-	-	-	-	-	-
10.00	.3937	1	8	112.66	12	190.02	16	225.14	-	-
11.00	.4331	1	8	118.16	12	212.36	16	254.28	-	-
12.00	.4724	1	8	102.76	12	169.70	16	219.80	-	-
13.00	.5118	1	8	115.52	12	210.34	16	375.46	-	-
14.00	.5512	1	8	129.78	12	181.70	16	242.84	-	-
15.00	.5906	2	8	145.78	12	196.36	16	273.14	-	-
16.00	.6299	2	8	141.04	12	199.72	16	265.44	-	-
17.00	.6693	2	8	146.76	12	213.40	16	290.42	-	-
18.00	.7087	2	8	146.76	12	207.26	16	342.26	21	400.62
19.00	.7480	2	8	155.56	12	303.30	16	351.18	-	-
20.00	.7874	2	8	168.70	12	220.84	16	304.26	21	416.36
21.00	.8268	2	8	185.48	12	254.92	16	391.62	-	-
22.00	.8661	2	8	185.48	12	267.50	16	331.46	21	452.24
23.00	.9055	2	8	219.52	12	513.62	16	547.72	-	-
24.00	.9499	3	-	-	11	323.96	15	394.32	20	468.20
25.00	.9843	3	-	-	11	285.60	15	362.68	20	474.20
26.00	1.0236	3	-	-	11	356.72	15	415.24	20	598.38
27.00	1.0630	3	-	-	11	390.16	15	574.74	-	-
28.00	1.1024	3	-	-	11	370.58	15	440.32	20	653.40
30.00	1.1811	3	-	-	11	370.82	15	464.42	20	578.98
32.00	1.2598	4	-	-	11	537.92	14	498.70	19	664.50
35.00	1.3780	4	-	-	-	-	14	553.46	19	819.82
38.00	1.4961	4	-	-	-	-	14	741.16	19	883.86
40.00	1.5748	4	-	-	-	-	14	645.92	19	958.02
42.00	1.6535	4	-	-	-	-	14	997.58	19	1199.98
45.00	1.7717	4	-	-	-	-	14	883.54	19	1030.14
48.00	1.8898	4	-	-	-	-	14	1158.78	19	1343.46
50.00	1.9685	4	-	-	-	-	14	952.52	19	1114.70