



HIGH SPEED STEEL TAPER SHANK DRILLS

ICS USA

GENERAL PURPOSE

118° POINT

ITEM NO.	ILLUSTRATION	CUTTING APPLICATION	STEEL SPECS	TECHNICAL DATA
TSD-R	 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
TSD-T	 GOLD TITANIUM COATED	Titanium Nitride Coated Taper Shank Drills are designed for high production drilling of ferrous and non-ferrous metals. Titanium Nitride Coating enhances chip flow, finished hole quality and extends life of drill up to 700%.	M2	118° Point Std. Spiral Std. Web

Fractional Sizes (Regular MT Shanks) 1/8" to 1-1/2" Dia.

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS	
				OXIDE FINISH 118° PT	TIN COATED GOLD FINISH 118° PT
				TSD-R	TSD-T
#1 MT SHANK					
1/8	.1250	1-7/8	5-1/8	14.02	-
9/64	.1406	2-1/8	5-3/8	14.02	-
5/32	.1562	2-1/8	5-3/8	14.02	-
11/64	.1719	2-1/8	5-3/4	14.02	-
3/16	.1875	2-1/2	5-3/4	11.48	-
13/64	.2031	2-3/4	6	12.24	-
7/32	.2188	2-3/4	6	12.24	-
15/64	.2344	2-7/8	6-1/8	13.52	-
1/4	.2500	2-7/8	6-1/8	13.08	-
17/64	.2656	3	6-1/4	13.52	-
9/32	.2812	3	6-1/4	17.58	-
19/64	.2969	3-1/8	6-3/8	17.58	-
5/16	.3125	3-1/8	6-3/8	14.22	-
21/64	.3281	3-1/4	6-1/2	19.18	-
11/32	.3438	3-1/4	6-1/2	20.36	-
23/64	.3594	3-1/2	6-3/4	22.24	-
3/8	.3750	3-1/2	6-3/4	22.24	-
25/64	.3906	3-5/8	7	23.16	-
13/32	.4062	3-5/8	7	22.24	-
27/64	.4219	3-7/8	7-1/4	23.70	-
7/16	.4375	3-7/8	7-1/4	24.26	-
29/64	.4531	4-1/8	7-1/2	26.46	-
15/32	.4688	4-1/8	7-1/2	27.64	-
#2 MT SHANK					
31/64	.4844	4-3/8	8-1/4	30.66	70.86
1/2	.5000	4-3/8	8-1/4	29.12	69.68
33/64	.5156	4-5/8	8-1/2	33.42	73.08
17/32	.5312	4-5/8	8-1/2	32.86	72.56
35/64	.5469	4-7/8	8-3/4	36.46	75.68
9/16	.5625	4-7/8	8-3/4	35.62	75.02
37/64	.5781	4-7/8	8-3/4	38.66	77.56
19/32	.5937	4-7/8	8-3/4	38.12	77.00
39/64	.6094	4-7/8	8-3/4	40.32	79.02
5/8	.6250	4-7/8	8-3/4	38.82	77.86
41/64	.6406	5-1/8	9	44.46	82.48
21/32	.6562	5-1/8	9	43.06	81.28
43/64	.6719	5-3/8	9-1/4	47.94	85.20
11/16	.6875	5-3/8	9-1/4	45.40	83.16
45/64	.7031	5-5/8	9-1/2	49.72	86.92
23/32	.7187	5-5/8	9-1/2	48.08	85.44
47/64	.7344	5-7/8	9-3/4	53.18	89.44
3/4	.7500	5-7/8	9-3/4	53.18	89.44
49/64	.7656	6	9-7/8	62.68	97.74
25/32	.7812	6	9-7/8	62.68	97.46

SIZE	DEC. EQUIV.	FLUTE LENGTH	OVERALL LENGTH	HSS	
				OXIDE FINISH 118° PT	TIN COATED GOLD FINISH 118° PT
				TSD-R	TSD-T
#3 MT SHANK					
51/64	.7969	6-1/8	10-3/4	67.40	125.30
13/16	.8125	6-1/8	10-3/4	63.82	121.80
53/64	.8281	6-1/8	10-3/4	71.12	127.72
27/32	.8437	6-1/8	10-3/4	68.88	125.82
55/64	.8594	6-1/8	10-3/4	73.58	129.84
7/8	.8750	6-1/8	10-3/4	71.12	127.72
57/64	.8906	6-1/8	10-3/4	75.24	131.22
29/32	.9062	6-1/8	10-3/4	75.24	132.62
59/64	.9219	6-1/8	10-3/4	76.68	133.40
15/16	.9375	6-1/8	10-3/4	71.12	129.30
61/64	.9531	6-3/8	11	78.06	135.20
31/32	.9687	6-3/8	11	78.06	134.76
63/64	.9844	6-3/8	11	82.24	139.40
1	1.0000	6-3/8	11	79.38	136.56
1-1/64	1.0156	6-1/2	11-1/8	90.56	147.00
1-1/32	1.0312	6-1/2	11-1/8	89.22	144.10
1-3/64	1.0469	6-5/8	11-1/4	96.18	151.02
1-1/16	1.0625	6-5/8	11-1/4	91.98	147.00
#4 MT SHANK					
1-5/64	1.0781	6-7/8	12-1/2	108.36	171.36
1-3/32	1.0937	6-7/8	12-1/2	105.92	167.84
1-7/64	1.1094	7-1/8	12-3/4	115.60	175.16
1-1/8	1.1250	7-1/8	12-3/4	112.88	172.44
1-9/64	1.1406	7-1/4	12-7/8	122.56	181.18
1-5/32	1.1562	7-1/4	12-7/8	117.08	176.04
1-11/64	1.1719	7-3/8	13	124.08	182.34
1-3/16	1.1875	7-3/8	13	122.62	181.18
1-13/64	1.2031	7-1/2	13-1/8	129.24	189.86
1-7/32	1.2187	7-1/2	13-1/8	131.00	188.16
1-15/64	1.2344	7-7/8	13-1/2	144.96	200.30
1-1/4	1.2500	7-7/8	13-1/2	137.96	194.46
1-17/64	1.2656	8-1/2	14-1/8	164.50	294.48
1-9/32	1.2812	8-1/2	14-1/8	161.12	293.30
1-19/64	1.2969	8-5/8	14-1/4	175.58	303.84
1-5/16	1.3125	8-5/8	14-1/4	167.24	295.52
1-21/64	1.3281	8-3/4	14-3/8	183.96	309.00
1-11/32	1.3437	8-3/4	14-3/8	175.58	303.84
1-23/64	1.3594	8-7/8	14-1/2	186.74	312.46
1-3/8	1.3750	8-7/8	14-1/2	181.10	306.12
1-25/64	1.3906	9	14-5/8	192.64	318.34
1-13/32	1.4062	9	14-5/8	192.62	318.34
1-27/64	1.4219	9-1/8	14-3/4	197.88	322.82
1-7/16	1.4375	9-1/8	14-3/4	194.70	318.80
1-29/64	1.4531	9-1/4	14-7/8	209.06	331.80
1-15/32	1.4687	9-1/4	14-7/8	206.24	329.98
1-31/64	1.4844	9-3/8	15	214.62	336.50
1-1/2	1.5000	9-3/8	15	208.16	331.20