

# 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) 1/4" to 1" Dia.

SIZE	DEC. EQUIV.	MORSE TAPER NO.	12" OVERALL		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	FLUTE LENGTH	OXIDE FINISH 118° POINT
			TSD-12		TSD-15		TSD-18		TSD-24		TSD-30	
1/4	.2500	1	9	68.46	12	80.56	15	105.26	-	-	-	-
17/64	.2656	1	9	72.32	12	82.32	15	110.54	-	-	-	-
9/32	.2812	1	9	72.32	12	86.14	15	110.54	-	-	-	-
19/64	.2969	1	9	73.86	12	86.14	15	112.86	-	-	-	-
5/16	.3125	1	9	73.86	12	86.14	15	123.48	-	-	-	-
21/64	.3281	1	9	81.68	12	97.62	15	123.48	-	-	-	-
11/32	.3438	1	9	81.68	12	97.62	15	129.96	-	-	-	-
23/64	.3594	1	9	86.38	12	103.50	15	129.96	-	-	-	-
3/8	.3750	1	9	86.38	12	103.50	15	135.54	21	169.88	-	-
25/64	.3906	1	9	89.50	12	107.44	15	135.54	21	169.88	-	-
13/32	.4062	1	9	89.50	12	107.44	15	135.54	21	169.88	-	-
27/64	.4219	1	9	92.68	12	111.38	15	138.60	21	169.88	-	-
7/16	.4375	1	9	92.68	12	111.38	15	138.60	21	174.94	-	-
29/64	.4531	1	9	97.32	12	117.60	15	138.60	21	174.94	-	-
15/32	.4688	1	9	97.32	12	117.60	15	138.60	21	174.94	-	-
31/64	.4844	2	8	107.50	11	120.78	14	131.50	20	174.94	-	-
1/2	.5000	2	8	107.50	11	120.78	14	131.50	20	174.94	-	-
33/64	.5156	2	8	107.50	11	120.78	14	131.50	20	174.94	-	-
17/32	.5312	2	8	107.50	11	120.78	14	131.50	20	174.94	-	-
35/64	.5469	2	8	109.04	11	122.44	14	133.48	20	174.94	-	-
9/16	.5625	2	8	109.04	11	122.44	14	133.48	20	174.94	-	-
37/64	.5781	2	8	110.44	11	124.08	14	135.14	20	185.00	-	-
19/32	.5938	2	8	110.44	11	124.08	14	135.14	20	185.00	-	-
39/64	.6094	2	8	117.60	11	132.56	14	144.66	20	189.92	-	-
5/8	.6250	2	8	117.60	11	132.56	14	144.66	20	189.92	-	-
41/64	.6406	2	8	125.84	11	142.00	14	155.48	20	216.80	-	-
21/32	.6562	2	8	125.84	11	142.00	14	155.48	20	216.80	-	-
43/64	.6719	2	8	137.54	11	155.48	14	170.42	20	222.98	-	-
11/16	.6875	2	8	137.54	11	155.48	14	170.42	20	222.98	-	-
45/64	.7031	2	8	146.32	11	160.82	14	183.36	20	237.46	-	-
23/32	.7188	2	8	146.32	11	160.82	14	183.36	20	250.00	-	-
47/64	.7344	2	8	152.12	11	172.28	14	189.18	20	245.36	-	-
3/4	.7500	2	8	152.12	11	172.28	14	189.18	20	245.36	26	323.40
49/64	.7656	2	8	160.52	11	181.70	14	189.18	20	255.44	-	-
25/32	.7812	2	8	160.52	11	181.70	14	199.44	20	255.44	-	-
51/64	.7969	3	7	160.52	10	173.24	13	212.70	19	287.70	-	-
13/16	.8125	3	7	160.52	10	173.24	13	212.70	19	287.70	25	378.68
53/64	.8281	3	7	160.52	10	174.64	13	213.94	19	320.00	-	-
27/32	.8438	3	7	160.52	10	174.64	13	213.94	19	320.00	-	-
55/64	.8594	3	7	160.52	10	180.82	13	221.58	19	352.80	-	-
7/8	.8750	3	7	160.52	10	180.82	13	221.58	19	352.80	25	431.60
57/64	.8906	3	7	160.52	10	186.92	13	229.32	19	352.80	-	-
29/32	.9062	3	7	160.52	10	186.92	13	229.32	19	352.80	-	-
59/64	.9219	3	7	164.06	10	189.92	13	233.14	19	352.80	-	-
15/16	.9375	3	7	164.06	10	189.92	13	233.14	19	352.80	25	468.06
61/64	.9531	3	-	-	10	192.86	13	236.96	19	392.62	-	-
31/32	.9688	3	7	167.00	10	192.86	13	236.96	19	392.62	-	-
63/64	.9844	3	-	-	10	203.74	13	250.50	19	392.62	-	-
1	1.0000	3	7	175.22	10	203.74	13	250.50	19	392.62	25	755.00

PACKAGING: (All Sizes - 1Drill/Tube)

(Sizes continued on next page)