INTERNATIONAL STANDARD

ISO 3439

Second edition
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Subland twist drills with cylindrical shanks for holes prior to tapping screw threads

Forets étagés à queue cylindrique pour avant-trous de taraudage

Reference number
ISO 3439:2003(E)

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Foreword

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ISO 3439 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 2, *High speed steel cutting tools and their attachments*.

This second edition cancels and replaces the first edition (ISO 3439:1975), which has been technically revised, in particular in order to align with ISO 273:1979.

Subland twist drills with cylindrical shanks for holes prior to tapping screw threads

1 Scope

This International Standard lays down the dimensions of subland twist drills with cylindrical shanks for holes prior to tapping screw threads.

The drills have been designed to produce holes prior to tapping metric threads (coarse pitch series) over a selected range of M3 to M14.

This International Standard complements ISO 2306.

Subland twist drills with Morse taper shanks for holes prior to tapping screw threads are dealt with in ISO 3438.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

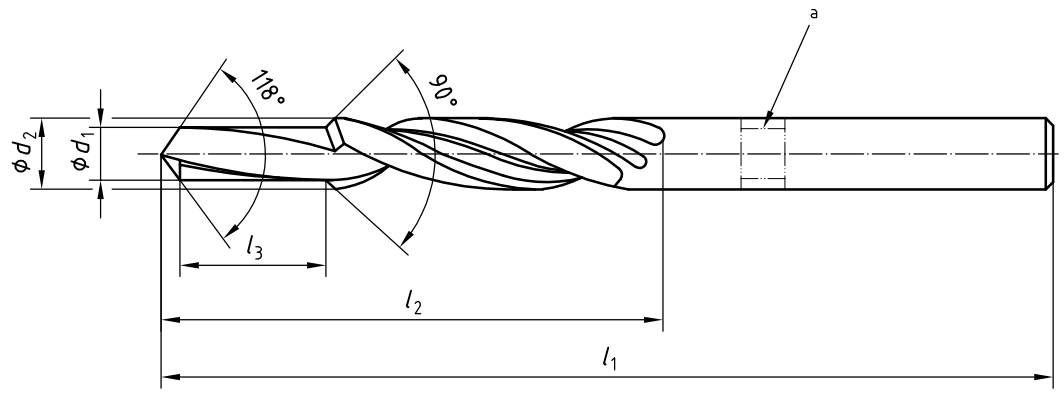
ISO 2306, *Drills for use prior to tapping screw threads*

ISO 2768-1, *General tolerances — Part 1: Tolerances for linear and angular dimensions without individual tolerance indications*

3 Dimensions

See Figure 1 and Table 1.

Unless otherwise stated, these drills are right-hand cutting.



[a] Optional recess.

Figure 1 — Subland twist drill with cylindrical shank

Table 1 — Dimensions of Subland twist drills with cylindrical shanks for holes prior to tapping metric screw threads

Dimensions in millimetres

d_2 h8	d_1 h8	l_1[a]	l_2[a]	l_3[a]	**Thread**
3,4	2,5	70	39	8,8	M3 × 0,5
4,5	3,3	80	47	11,4	M4 × 0,7
5,5	4,2	93	57	13,6	M5 × 0,8
6,6	5	101	63	16,5	M6 × 1
9	6,8	125	81	21	M8 × 1,25
11	8,5	142	94	25,5	M10 × 1,5
13,5	10,2	160	108	30	M12 × 1,75
15,5	12	178	120	34,5	M14 × 2

[a] The tolerance on overall length l_1 and flute lengths l_2 and l_3 shall be the “very coarse” class as given in ISO 2768-1.

Bibliography

[1] ISO 273:1979, *Fasteners — Clearance holes for bolts and screws*

[2] ISO 3438:2003, *Subland twist drills with Morse taper shanks for holes prior to tapping screw threads*

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