
INTERNATIONAL STANDARD



3438

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

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

Forets étagés à queue cône Morse pour avant-trous de taraudage

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[ISO 3438:1975](#)

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Descriptors : tools, twist drills, Morse taper shanks, dimensions.

Price based on 1 page

FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO Member Bodies). The work of developing International Standards is carried out through ISO Technical Committees. Every Member Body interested in a subject for which a Technical Committee has been set up has the right to be represented on that Committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the Technical Committees are circulated to the Member Bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 3438 was drawn up by Technical Committee ISO/TC 29, *Small tools*, and circulated to the Member Bodies in May 1974.

It has been approved by the Member Bodies of the following countries :

Australia	Hungary	ISO 3438:1975
Austria	India	South Africa, Rep. of
Belgium	Ireland	Switzerland
Brazil	Israel	Thailand
Canada	Italy	Turkey
Chile	Japan	United Kingdom
Czechoslovakia	Korea, Rep. of	U.S.A.
Egypt, Arab Rep. of	Netherlands	U.S.S.R.
France	Poland	Yugoslavia
Germany	Romania	

The Member Body of the following country expressed disapproval of the document on technical grounds :

Sweden

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

1 SCOPE AND FIELD OF APPLICATION

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

It gives only metric dimensions, which are the only recommended dimensions in the future for subland twist drills.

The drills have been designed to produce holes prior to tapping metric threads (coarse pitch series) over a selected range of M 8 to M 30.

Unless otherwise stated, these drills will be right-hand cutting.

This International Standard supplements ISO 2306.

Subland twist drills with parallel shanks for holes prior to tapping screw threads are dealt with in ISO 3439.

2 REFERENCES

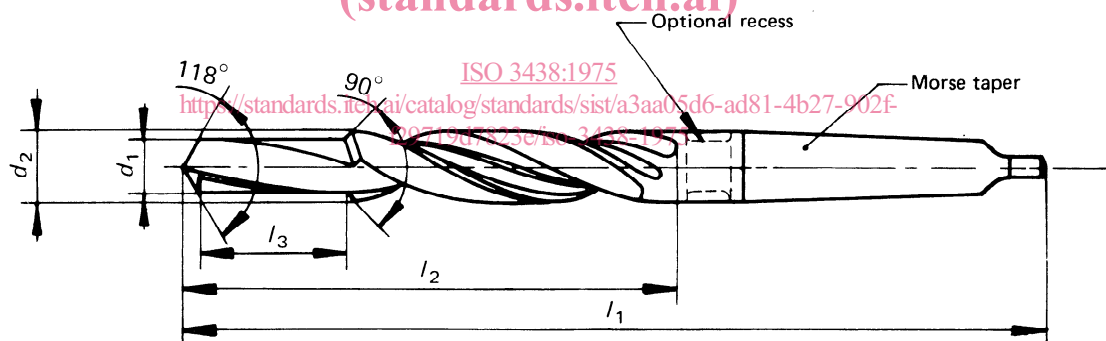
ISO/R 286, *ISO system of limits and fits – Part 1 : General, tolerances and deviations.*

ISO 296, *Machine tools – Self-holding tapers for tool shanks.*

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

ISO 3439, *Subland twist drills with parallel shanks for holes prior to tapping screw threads.*

3 DIMENSIONS



Dimensions in millimetres

d_2 h8	d_1 h9	l_1	l_2	l_3	Morse taper No.	Thread	
						Nominal diameter	Pitch
9	6,8	162	81	21	1	M 8	1,25
11	8,5	175	94	25,5		M 10	1,5
14	10,2	189	108	30		M 12	1,75
16	12,0	218	120	34,5	2	M 14	2
18	14,0	228	130	38,5		M 16	2
20	15,5	238	140	43,5		M 18	2,5
22	17,5	248	150	47,5		M 20	2,5
24	19,5	281	160	51,5	3	M 22	2,5
26	21,0	286	165	56,5		M 24	3
30	24,0	296	175	62,5		M 27	3
33	26,5	334	185	70	4	M 30	3,5

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