
INTERNATIONAL STANDARD



3439

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

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

Forets étagés à queue cylindrique pour avant-trous de taraudage

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iTeh STANDARD PREVIEW
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[ISO 3439:1975](https://standards.iteh.ai/catalog/standards/sist/9e5a40ba-5f3-476c-9399-d478ae3b2f84/iso-3439-1975)

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Descriptors : tools, twist drills, parallel shanks, dimension.

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 3439 was drawn up by Technical Committee ISO/TC 29, *Small tools*, and circulated to the Member Bodies in May 1974.

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

Australia	Ireland	South Africa, Rep. of
Austria	Israel	Switzerland
Belgium	Italy	Thailand
Brazil	Japan	Turkey
Chile	Korea, Rep. of	United Kingdom
Czechoslovakia	Mexico	U.S.A.
France	Netherlands	U.S.S.R.
Germany	Norway	Yugoslavia
Hungary	Poland	
India	Romania	

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

Sweden

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

It gives only metric dimensions, which are the only recommended dimensions in the future for these types of drills.

The drills have been designed to produce holes prior to tapping metric threads (coarse pitch series) over a selected range of M 3 to M 14.

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

This International Standard supplements ISO 2306.

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

2 REFERENCES

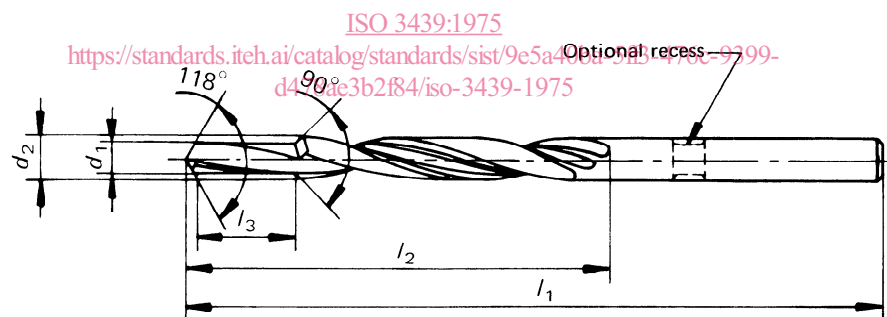
ISO/R 286, *ISO system of limits and fits – Part 1 : General, tolerances and deviations.*

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

ISO 3438, *Subland twist drills with Morse taper shanks for holes prior to tapping screw threads.*

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3 DIMENSIONS



Dimensions in millimetres

d_2 h8	d_1 h9	l_1	l_2	l_3	Thread	
					Nominal diameter	Pitch
3,4	2,5	70	39	8,8	M 3	0,5
4,5	3,3	80	47	11,4	M 4	0,7
5,5	4,2	93	57	13,6	M 5	0,8
6,6	5,0	101	63	16,5	M 6	1,0
9,0	6,8	125	81	21,0	M 8	1,25
11,0	8,5	142	94	25,5	M 10	1,5
14,0	10,2	160	108	30,0	M 12	1,75
16,0	12,0	178	120	34,5	M 14	2,0

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