
**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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Foreword

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Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 3438 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 3438:1975), which has been technically revised, in particular in order to align with ISO 273:1979.

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1 Scope

This International Standard lays down the dimensions of subland twist drills with Morse taper 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 M8 to M50.

This International Standard complements ISO 2306.

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

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 296, *Machine tools — Self-holding tapers for tool shanks*

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*

ISO 10899:1996, *High-speed steel two-flute twist drills — Technical specifications*