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## Cylindrical shank twist drills — Long series

*Forets à queue cylindrique — Série longue*



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## Foreword

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ISO 494 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 494:1975), of which it constitutes a minor revision. In particular, the dimensions in inches have been deleted.

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# Cylindrical shank twist drills — Long series

## 1 Scope

This International Standard specifies the dimensions of cylindrical shank twist drills, having working lengths in the long series.

The cylindrical shank jobber and stub series drills and Morse taper shank drills are given in ISO 235.

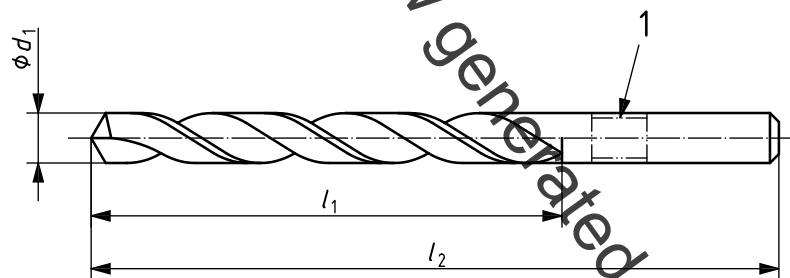
## 2 Dimensions

### 2.1 General

All dimensions and tolerances are given in millimetres.

### 2.2 General dimensions

The dimensions of cylindrical shank twist drills shall be in accordance with the dimensions shown in Figure 1 and given in Table 1.



#### Key

1 recess optional

Figure 1 — Dimensions of cylindrical shank twist drill