

# INTERNATIONAL STANDARD

**ISO**  
**3292**

Second edition  
1995-12-15

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## Extra-long parallel shank twist drills

*Forets extra-longs à queue cylindrique*

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Reference number  
ISO 3292:1995(E)

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established 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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 3292 was prepared by Technical Committee ISO/TC 29, *Small tools*, Subcommittee SC 2, *Drills, reamers, milling cutters and milling machine accessories*.

This second edition cancels and replaces the first edition (ISO 3292:1975) which has been technically revised.

Annex A of this International Standard is for information only.

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Case Postale 56 • CH-1211 Genève 20 • Switzerland

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# Extra-long parallel shank twist drills

## 1 Scope

This International Standard specifies the dimensions of extra-long parallel shank twist drills in the range 2 mm to 14 mm diameter with an overall length range of 125 mm to 400 mm.

It gives a list of preferred diameters.

## 2 Normative reference

The following standard contains provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the edition indicated was valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent edition of the standard indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 10899: —<sup>1)</sup>, *High speed steel two-flute twist drills — Technical specifications*.

## 3 Dimensions

See figure 1 and table 1.

## 4 Technical specifications

Unless otherwise specified, technical requirements shall comply with ISO 10899.

## 5 Designation

Extra-long parallel shank twist drills in accordance with this International Standard shall be designated by:

- a) "twist drill";
- b) reference to this International Standard;
- c) drill diameter,  $d$ , in millimetres;
- d) overall length,  $l$ , in millimetres.

### EXAMPLE

An extra-long parallel shank twist drill of diameter  $d = 10$  mm and overall length  $l = 250$  mm shall be designated as follows:

**Twist drill ISO 3292 - 10 - 250**

1) To be published.

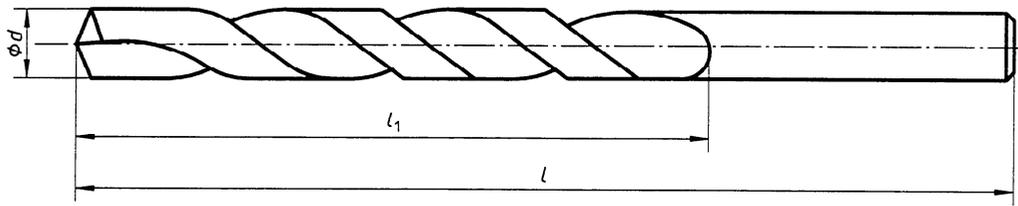


Figure 1 — Extra-long parallel shank twist drills

Table 1 — Extra-long parallel shank twist drills — Preferred sizes

Dimensions in millimetres

Preferred diameters $d$ h8	Overall length $l$					
	125	160	200	250	315	400
	Flute length $l_1$					
	80	100	150	200	250	300
2	x	x				
2,5	x	x				
3		x	x			
3,5		x	x	x		
4		x	x	x	x	
4,5		x	x	x	x	
5			x	x	x	x
5,5			x	x	x	x
6			x	x	x	x
6,5			x	x	x	x
7			x	x	x	x
7,5			x	x	x	x
8				x	x	x
8,5				x	x	x
9				x	x	x
9,5				x	x	x
10				x	x	x
10,5				x	x	x
11				x	x	x
11,5				x	x	x
12				x	x	x
12,5				x	x	x
13				x	x	x
13,5				x	x	x
14				x	x	x
Ranges of diameters	2 $\nabla$ $d$ $\nabla$ 2,65	2 $\nabla$ $d$ $\nabla$ 4,75	2,65 , $d$ $\nabla$ 7,5	3,35 , $d$ $\nabla$ 14	3,75 , $d$ $\nabla$ 14	4,75 , $d$ $\nabla$ 14

**Annex A**  
(informative)

**Bibliography**

- [1] ISO 235:1980, *Parallel shank jobber and stub series drills and Morse taper shank drills.*
- [2] ISO 494:1975, *Parallel shank twist drills — Long series.*
- [3] ISO 3291:1995, *Extra-long Morse taper shank twist drills.*

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