

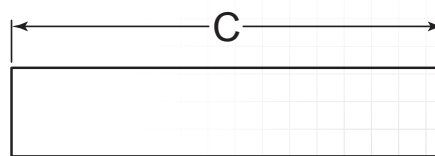
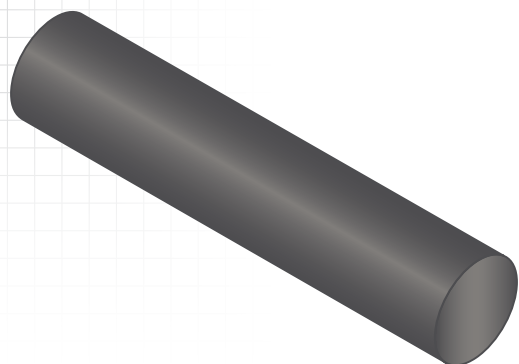
DRILL ROD – METRIC

DESCRIPTION

Drill rod is round, unhardened (but tough) tool steel that is precision ground to tight tolerances that is machined to produce a wide variety of tools. It may then be hardened by heat treating then drawn back to the desired hardness.

HOW TO IDENTIFY

1. Measure diameter (A).
2. Measure length (C).
3. Build the part number from the chart on the next page.



PREFIX MATERIAL/FINISH

DRMA = A2* (AIR-HARDENING STEEL)
 DRMO = O1* (OIL-HARDENING STEEL)
 DRMW = W1* (WATER-HARDENING STEEL)
 Material/finish combinations may not be available in all sizes.



DRMO SERIES LENGTHS:

DRMO-### = 914.40 mm (3')
 DRMO-###-2 = 2000.00 mm (6.56')
 DRMO-###-4 = 3657.60 mm (12')
 All other materials available in 914.40 mm lengths only.

DRILL ROD TOLERANCES

MATERIAL		DIAMETER (A)	
(Prefix)	(Material/Finish)	(Size Range)	(Tolerance)
DRMA	A2* (Air-hardening Steel)	2 – 3 mm	+0/-0.025 mm
		>3 – 6 mm	+0/-0.030 mm
		>6 – 10 mm	+0/-0.036 mm
		>10 – 18 mm	+0/-0.043 mm
		>18 – 25 mm	+0/-0.052 mm
DRMO	O1* (Oil-hardening Steel)	1 – 3 mm	+0/-0.025 mm
		>3 – 6 mm	+0/-0.030 mm
		>6 – 10 mm	+0/-0.036 mm
		>10 – 18 mm	+0/-0.043 mm
		>18 – 30 mm	+0/-0.052 mm
		>30 – 50 mm	+0/-0.062 mm
DRMW	W1* (Water-hardening Steel)	1 – 3 mm	+0/-0.025 mm
		>3 – 6 mm	+0/-0.030 mm
		>6 – 10 mm	+0/-0.036 mm
		>10 – 18 mm	+0/-0.043 mm
		>18 – 30 mm	+0/-0.052 mm
		>30 – 50 mm	+0/-0.062 mm

LENGTH (C) TOLERANCES

LENGTH		TOL.
(Suffix)	(Length)	(Tolerance)
(None)	914.40 mm (3')	+3.175/-0 mm
-2 (DRMO Only)	2000.00 mm (6.56')	+3.175/-0 mm
-4 (DRMO Only)	3657.6 mm (12')	±152.4 mm

Nonstandard lengths up to 12' are available.
 Lengths over 3' may be subject to a packaging charge.

DRILL ROD CAN BE
 PRODUCED IN MANY
 DIAMETER AND LENGTH
 COMBINATIONS



BE SURE TO MARK AIR-, WATER-, AND OIL-HARDENING
 TOOL STEEL SCRAPS TO PREVENT MACHINING ERRORS AND
 HEAT TREATING WITH THE WRONG QUENCHING PROCESS

DRILL ROD – METRIC

HOW TO BUILD A PART NUMBER

DRMO-006-2

ITEM PREFIX

DRMO-

TO ORDER CHOOSE
YOUR MATERIAL,

CODE	MATERIAL
DRMA-	A2* (Air-hardening Steel)
* DRMO-	O1* (Oil-hardening Steel)
DRMW-	W1* (Water-hardening Steel)

(A)
DIAMETER

1 mm to 50 mm

006

CHOOSE YOUR
DIAMETER,

CODE	DIAMETER
001	1.00 mm
0013	1.30 mm
0014	1.40 mm
0015	1.50 mm
0016	1.60 mm
0017	1.70 mm
0018	1.80 mm
002	2.00 mm
0022	2.20 mm
0025	2.50 mm
0026	2.60 mm
0028	2.80 mm
003	3.00 mm
0035	3.50 mm
004	4.00 mm
0045	4.50 mm

CODE	DIAMETER
005	5.00 mm
006	6.00 mm
007	7.00 mm
008	8.00 mm
009	9.00 mm
010	10.00 mm
011	11.00 mm
012	12.00 mm
013	13.00 mm
014	14.00 mm
015	15.00 mm
016	16.00 mm
017	17.00 mm
018	18.00 mm
019	19.00 mm
020	20.00 mm

CODE	DIAMETER
021	21.00 mm
022	22.00 mm
023	23.00 mm
024	24.00 mm
025	25.00 mm
027	27.00 mm
030	30.00 mm
032	32.00 mm
033	33.00 mm
035	35.00 mm
036	36.00 mm
040	40.00 mm
045	45.00 mm
050	50.00 mm

(C)
LENGTH

-2

CHOOSE YOUR
LENGTH.

CODE	LENGTH
(None)	914.40 mm (3')
* -2 (DRMO Only)	2000.00 mm (6.56')
* -4 (DRMO Only)	3657.6 mm (12')

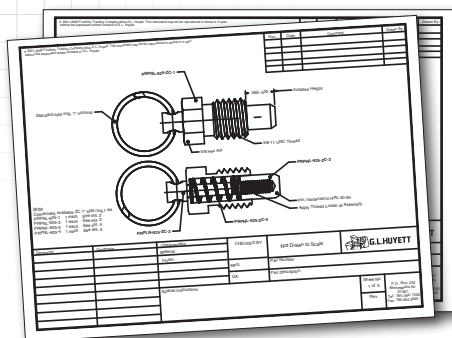
Nonstandard lengths up to 12' are available. Lengths over 3' may be subject to a packaging charge.



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