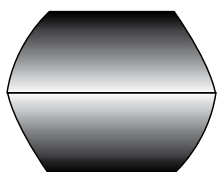


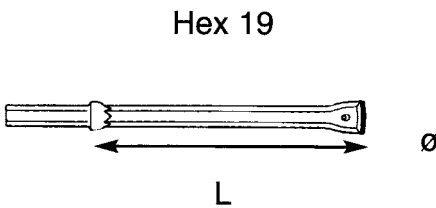
# INTEGRAL DRILL STEELS



**MONARK AS**

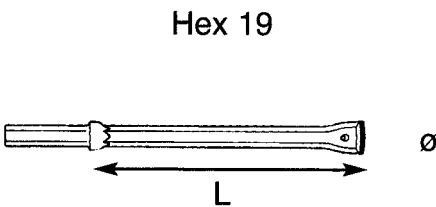
## 19 mm Hexagon

### Shank 19 mm x 108 mm



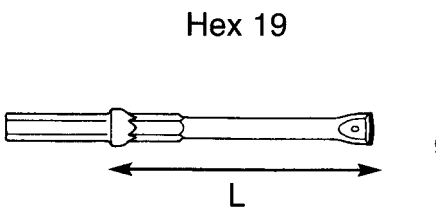
Series	Length (L)		Diameter (Ø)		Part Number
	mm	ft in	mm	in	
21	400	1 – 4	29	1 5/32	724 0429
	800	2 – 7	28	1 1/8	724 0828
	1200	3 – 11	27	1 1/16	724 1227
	1600	5 – 3	27	1 1/16	724 1627
	2400	7 – 11	26	1 1/32	724 2426
	3200	10 – 6	25	1	724 3225
	4000	13 – 1	24	0 15/16	724 4024
22	400	1 – 4	26	1 1/32	724 0426
	800	2 – 7	25	1	724 0825
	1200	3 – 11	24	0 15/16	724 1224

### Shank 22 mm x 108 mm



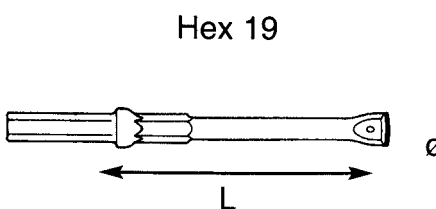
400	1 – 4	29	1 5/32	728 0429	
	800	2 – 7	28	1 1/8	728 0828
	1200	3 – 11	27	1 1/16	728 1227
	1600	5 – 3	27	1 1/16	728 1627
	2400	7 – 11	26	1 1/32	728 2426
	3200	10 – 6	25	1	728 3225
	4000	13 – 1	24	0 15/16	728 4024
400	1 – 4	26	1 1/32	728 0426	
	800	2 – 7	25	1	728 0825
	1200	3 – 11	24	0 15/16	728 1224

### Plug Hole Drills Shank 19 mm x 108 mm



200	0 – 7 7/8	17	0 21/32	721 2017
250	0 – 9 27/32	17	0 21/32	721 2517
300	0 – 11 13/16	17	0 21/32	721 3017
200	0 – 7 7/8	20	0 25/32	721 2020
250	0 – 9 27/32	20	0 25/32	721 2520
300	0 – 11 13/16	20	0 25/32	721 3020
200	0 – 7 7/8	22	0 7/8	721 2022
240	0 – 9 27/32	22	0 7/8	721 2522
300	0 – 11 13/16	22	0 7/8	721 3022

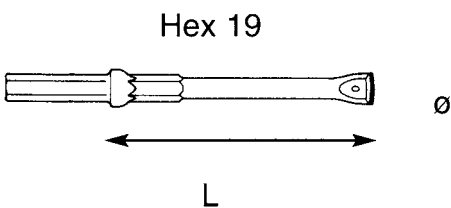
### Plug Hole Drills Shank 19 mm x 82,5 mm



200	0 – 7 7/8	17	0 21/32	722 2017
250	0 – 9 27/32	17	0 21/32	722 2517
300	0 – 11 13/16	17	0 21/32	722 3017
200	0 – 7 7/8	20	0 25/32	722 2020
250	0 – 9 27/32	20	0 25/32	722 2520
300	0 – 11 13/16	20	0 25/32	722 3020
200	0 – 7 7/8	22	0 7/8	722 2022
250	0 – 9 27/32	22	0 7/8	722 2522
300	0 – 11 13/16	22	0 7/8	722 3022

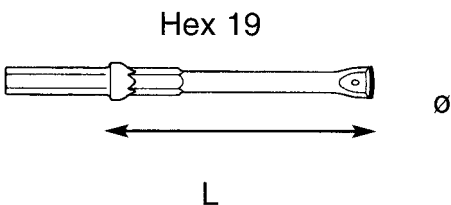
## 19 mm Hexagon Contd.

### Plug Hole Drills Shank 22 mm x 108 mm



Series	Length (L)		Diameter (ø)		Part Number
	mm	ft in	mm	in	
Series 19	200	0 – 7 7/8	17	0 21/32	711 2017
	250	0 – 9 27/32	17	0 21/32	711 2517
	300	0 – 11 13/16	17	0 21/32	711 3017
	200	0 – 7 7/8	20	0 25/32	711 2020
	250	0 – 9 27/32	20	0 25/32	711 2520
	300	0 – 11 13/16	20	0 25/32	711 3020
	200	0 – 7 7/8	22	0 7/8	711 2022
	250	0 – 9 27/32	22	0 7/8	711 2522
	300	0 – 11 13/16	22	0 7/8	711 3022

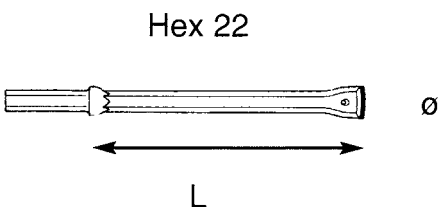
### Plug Hole Drills Shank 22 mm x 82,5 mm



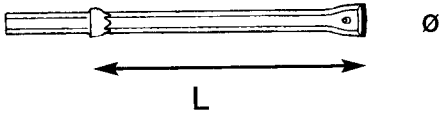
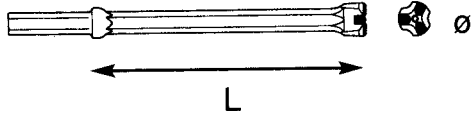
Series 19	200	0 – 7 7/8	17	0 21/32	712 2017
	250	0 – 9 27/32	17	0 21/32	712 2517
	300	0 – 11 13/16	17	0 21/32	712 3017
	200	0 – 7 7/8	20	0 25/32	712 2020
	250	0 – 9 27/32	20	0 25/32	712 2520
	300	0 – 11 13/16	20	0 25/32	712 3020
	200	0 – 7 7/8	22	0 7/8	712 2022
	250	0 – 9 27/32	22	0 7/8	712 2522
	300	0 – 11 13/16	22	0 7/8	712 3022

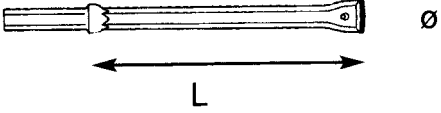
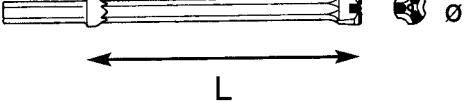
## 22 mm Hexagon

### Shank 22 mm x 108 mm



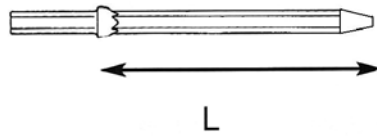
Series	Length (L)		Diameter (ø)		Part Number
	mm	ft in	mm	in	
Series 11	800	2 – 7	34	1 11/32	714 0834
	1600	5 – 3	33	1 5/16	714 1633
	2400	7 – 11	32	1 1/4	714 2432
	3200	10 – 6	31	1 7/32	714 3231
	4000	13 – 1	30	1 3/16	714 4030
	4800	15 – 9	29	1 5/32	714 4829
	5600	18 – 4	28	1 1/8	714 5628
	6400	21 – 0	27	1 1/16	714 6427
	7200	23 – 1 1/2	26	1 1/32	714 7226
	Series 12	800	2 – 7	40	1 19/32
1600		5 – 3	39	1 17/32	714 1639
2400		7 – 11	38	1 1/2	714 2438
3200		10 – 6	37	1 15/32	714 3237
4000		13 – 1	36	1 7/16	714 4036
4800		15 – 9	35	1 3/8	714 4835
5600		18 – 4	34	1 11/32	714 5634
6400		21 – 0	33	1 5/16	714 6433
7200		23 – 1 1/2	32	1 1/4	714 7232
8000		26 – 3	31	1 7/32	714 8031
8800		28 – 10 1/2	30	1 3/16	714 8830
9600		31 – 6	29	1 5/32	714 9629

22 mm Hexagon Contd.	Series	Length (L)		Diameter (Ø)		Part Number
		mm	ft in	mm	in	
<b>Shank 22 mm x 108 mm</b> Hex 22 	13	400	1 – 4	34	0 11/32	714 0434
		800	2 – 7	33	0 5/16	714 0833
		1200	3 – 11	32	0 1/4	714 1232
		1600	5 – 3	31	0 7/32	714 1631
		2000	6 – 7	30	0 3/16	714 2030
<b>3-Wing “Uppercut”</b> <b>Shank 22 mm x 108 mm</b> Hex 22 		3200	10 – 6	38	1 1/2	761 3238
		4000	13 – 1	38	1 1/2	761 4038
		4800	15 – 9	35	1 1/2	761 4035

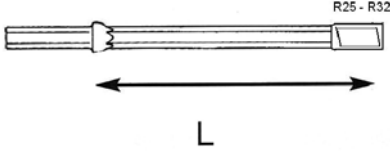
22 mm Hexagon	Series	Length (L)		Diameter (Ø)		Part Number
		mm	ft in	mm	in	
<b>Shank 25 mm x 159 mm</b> Hex 25 		1600	5 – 3	41	1 5/8	737 1641
		2400	7 – 11	40	1 19/32	737 2440
		3200	10 – 6	39	1 17/32	737 3239
		4000	13 – 1	39	1 17/32	737 4039
		4800	15 – 9	38	1 1/2	737 4838
<b>3-Wing “Uppercut”</b> <b>Shank 25 mm x 159 mm</b> Hex 25 		3200	10 – 6	38	1 1/2	767 3238
		4000	13 – 1	37	1 15/32	767 4037
		4800	15 – 9	35	1 3/8	767 4835

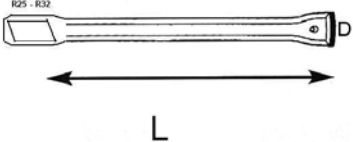
### Tapered rods, Shank rods & Threaded integrals

Below is the most common lengths, but Monark can produce all lengths from 200 to 11200 mm.

22 mm Hexagon	Series	Length (L) mm	Length (L) ft	Part Number
<b>Shank 22 mm x 108 mm</b> Hex 22 		610	2'	714 0610*
		1220	4'	714 1220*
		1830	6'	714 1830*
		1980	6-1/2'	714 1980*
		2440	8'	714 2440*
		3050	10'	714 3050*
		3660	12'	714 3660*
		5485	18'	714 5485*
		6400	21'	714 6400*
		7315	24'	714 7315*

## Shank rods and Threaded integral drill steels, R25 – > R32

22 mm Hexagon	Series	Length (L) mm	Length (L) ft	Part Number
<b>Shank 22 mm x 108 mm</b> Hex 22 		250	0,8'	714 0250-R**
		400	1,3'	714 0400-R**
		1830	6'	714 0800-R**
		1980	6-1/2'	714 1200-R**
		2440	8'	714 1600-R**
		3050	10'	714 2000-R**

22 mm Hexagon	Series	Length (L) mm	Diameter (D)	Part Number
<b>Thread R25 – &gt; R32</b> Hex 22 	–	–	–	R** length & D

## Integral Drill Steel Series

Integral Drill Steels are normally produced from 19 mm (3/4"), 22 mm (7/8") or 25 mm (1") Hexagon Drill Steel, where the dimensions given are measured across the flat of the hexagon.

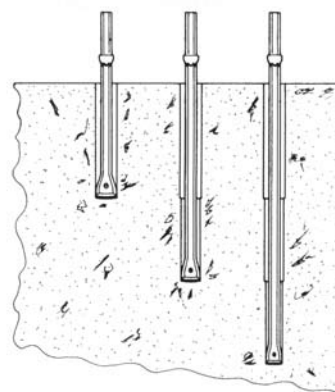
Integral Drill Steels are a fixed length with a shank at one end and a bit at the other, and are able to drill to a depth equivalent to their effective length. The bit may consist of a single chisel shaped tungsten carbide insert or three such inserts.

To drill deep holes, the rods are designed to be used in a series where the length of any rod used is longer than the one used just before it.

To do this, a series of rods must be produced so that the bit diameter is reduced for each increase in length of rod to prevent jamming of the bit in the hole.

The products in this brochure are the most commonly used. For other bit diameters and lengths please contact us.

Monark AS will free of charge replace any product manufactured by our plant, which has been proved by Monark's satisfaction, to have failed due to production or material defects when used under normal conditions and handled in the correct manner.



The staff at Monark AS has a long tradition of producing Integral Drill Steel. The plant was established in 1958 by Vestfold Stålindustri, and they served the Norwegian market with high quality products for many years.

We became a part of the Boart Longyear organization in 1971 and expanded to become a supplier of IDS worldwide with sales in all regions of the world.

After 34 years as a member of the Boart Longyear family, the plant was sold in 2005.

We have constantly been improving our quality over the past 40 years, and we now have one of the best performing Integral drill steels in the world.

Monark AS produce integrals from 200 up to 11200mm with a bit diameter from 13 to 45mm, this makes us to the manufacturer with the widest IDS product ranges.

