

Drill Rods

0 - 1



- Oil hardening
- 36" length
- Ground and polished

HEAT TREATMENT

Preheat: 1200°F until thoroughly soaked. Harden at 1475°F. Hold 20 minutes per inch of greatest cross-section after tool reaches furnace temperature (minimum holding time – 20 minutes). Quench in warm oil to 150°F. Temper immediately 2 hours per inch of greatest cross-section at temperatures shown to achieve the desired hardness.

NOTE: Water hardened or air hardened available upon request

STANDARD TOLERANCES

SIZE RANGE (inches)	Tolerance
2.000 to 0.500	±0.001
0.499 to 0.125	±0.0005
0.124 and smaller	±0.0003

PRODUCT

ANSI O1 ground and polished drill rod

TYPICAL ANALYSIS

C .95, MN 1.20, Si .35, Cr .50, W .50

TEMPERING

Tempering Temp. °F	Hardness Rockwell C
None	65
300	63
350	61
400	60.5
450	59
500	58
600	56
800	48-49

Inch

Size	Decimal Equivalent (Inch)	Weight per 36" (lbs)	Code	Size	Decimal Equivalent (Inch)	Weight per 36" (lbs)	Code	Size	Decimal Equivalent (Inch)	Weight per 36" (lbs)	Code
2	2.000	32.04	219597	47/64	0.734	4.31	219638	M	0.295	0.699	219680
1-15/16	1.937	30.06	219598	23/32	0.718	4.12	219639	L	0.290	0.675	219681
1-7/8	1.875	28.14	219599	45/64	0.703	3.93	219640	9/32	0.282	0.639	219682
1-13/16	1.812	26.31	219600	11/16	0.687	3.75	219641	K	0.281	0.636	219683
1-3/4	1.750	24.51	219601	43/64	0.671	3.56	219642	J	0.277	0.615	219684
1-11/16	1.687	22.80	219602	21/32	0.656	3.43	219643	I	0.272	0.594	219685
1-5/8	1.625	21.15	219603	41/64	0.640	3.31	219644	H	0.266	0.564	219686
1-9/16	1.562	19.56	219783	5/8	0.625	3.12	219645	17/64	0.265	0.561	219687
1-1/2	1.500	18.00	219604	39/64	0.609	3.00	219646	G	0.261	0.543	219688
1-15/32	1.468	17.25	219605	19/32	0.593	2.81	219647	F	0.257	0.522	219689
1-7/16	1.437	16.53	219606	37/64	0.578	2.67	219648	E	0.250	0.501	219690
1-13/32	1.406	15.82	219607	9/16	0.562	2.53	219649	1/4	0.250	0.501	219690
1-3/8	1.375	15.14	219608	35/64	0.546	2.39	219650	D	0.246	0.483	219691
1-11/32	1.343	14.44	219609	17/32	0.531	2.25	219651	C	0.242	0.462	219692
1-5/16	1.312	13.80	219610	33/64	0.515	2.12	219652	B	0.238	0.450	219693
1-9/32	1.281	13.12	219611	1/2	0.500	2.000	219653	15/64	0.235	0.441	219694
1-1/4	1.250	12.50	219612	31/64	0.484	1.870	219654	A	0.234	0.441	219695
1-7/32	1.218	11.89	219613	15/32	0.468	1.740	219655	1	0.227	0.414	219696
1-3/16	1.187	11.31	219614	29/64	0.453	1.620	219656	2	0.221	0.387	219697
1-5/32	1.156	10.69	219615	7/16	0.437	1.530	219657	7/32	0.218	0.387	219698
1-1/8	1.125	10.12	219616	27/64	0.421	1.410	219658	3	0.212	0.363	219699
1-3/32	1.093	9.58	219617	Z	0.413	1.370	219659	4	0.207	0.345	219700
1-1/16	1.062	9.03	219618	13/32	0.406	1.310	219660	5	0.204	0.327	219701
1-1/32	1.013	8.49	219619	Y	0.404	1.280	219661	13/64	0.203	0.327	219702
1-1/64	1.015	8.26	219620	X	0.397	1.260	219662	6	0.201	0.321	219703
1	1.000	7.99	219621	25/64	0.390	1.220	219663	7	0.199	0.318	219704
63/64	0.984	7.74	219622	W	0.386	1.200	219664	8	0.197	0.312	219705
31/32	0.968	7.59	219623	V	0.377	1.140	219665	9	0.194	0.297	219706
61/64	0.953	7.24	219624	3/8	0.375	1.120	219666	10	0.191	0.288	219707
15/16	0.937	6.99	219625	U	0.368	1.060	219667	11	0.188	0.282	219708
59/64	0.921	6.78	219626	23/64	0.359	1.030	219668	3/16	0.187	0.282	219709
29/32	0.906	6.56	219627	T	0.358	1.020	219669	12	0.185	0.276	219710
57/64	0.890	6.35	219628	S	0.348	0.975	219670	13	0.182	0.267	219711
7/8	0.875	6.12	219629	11/32	0.343	0.939	219671	14	0.180	0.261	219712
55/64	0.859	5.91	219630	R	0.339	0.924	219672	15	0.178	0.255	219713
27/32	0.843	5.68	219631	Q	0.332	0.882	219673	16	0.175	0.246	219714
53/64	0.828	5.48	219632	21/64	0.328	0.861	219674	17	0.172	0.237	219715
13/16	0.812	5.25	219633	P	0.323	0.831	219675	11/64	0.171	0.234	219716
51/64	0.796	5.12	219634	O	0.316	0.813	219676	18	0.168	0.228	219717
25/32	0.781	4.87	219635	5/16	0.312	0.780	219677	19	0.164	0.216	219718
49/64	0.765	4.68	219636	N	0.302	0.726	219678	20	0.161	0.207	219719
3/4	0.750	4.50	219637	19/64	0.296	0.702	219679	21	0.157	0.198	219720