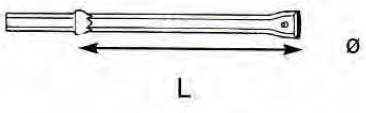
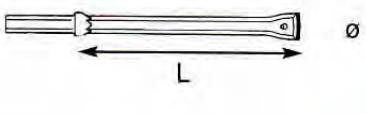
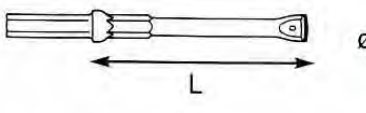
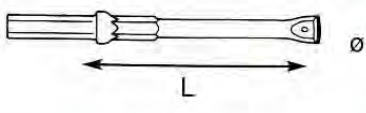
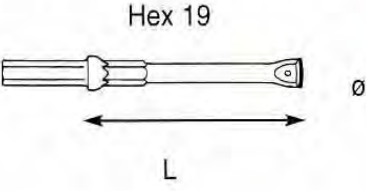
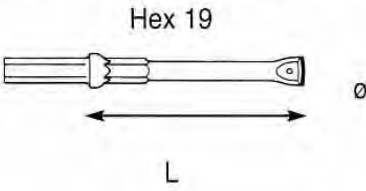
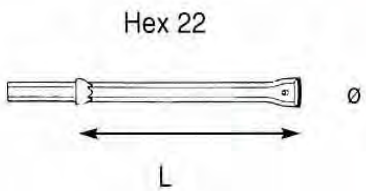


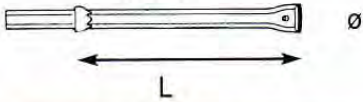
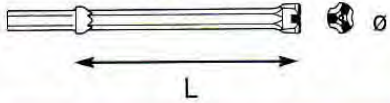
INTEGRAL DRILL STEELS

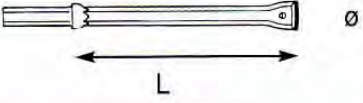
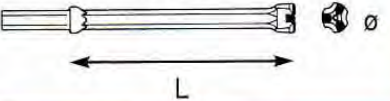


MONARK AS

19 mm Hexagon		Series	Length (L)		Diameter (ø)		Part Number
			mm	ft in	mm	in	
Shank 19 mm x 108 mm		21	400	1-4	29	1 5/32	724 0429
<p>Hex 19</p> 			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
		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
<p>Hex 19</p> 			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
		800	2-7		25	1	728 0825
		1200	3-11		24	0 15/16	728 1224
Plug Hole Drills			200	0-7 7/8	17	0 21/32	721 2017
<p>Shank 19 mm x 108 mm</p> <p>Hex 19</p> 			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
					200	0-7 7/8	17
<p>Plug Hole Drills</p> <p>Shank 19 mm x 82,5 mm</p> <p>Hex 19</p> 		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.		Series	Length (L)		Diameter (ø)		Part Number
			mm	ft in	mm	in	
Plug Hole Drills Shank 22 mm x 108 mm 	Hex 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 	Hex 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		Series	Length (L)		Diameter (ø)		Part Number
			mm	ft in	mm	in	
Shank 22 mm x 108 mm 	Hex 22	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
		12	800	2 - 7	40	1 ¹⁹ / ₃₂	714 0840
			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	
Shank 22 mm x 108 mm 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	
3-Wing "Uppercut" Shank 22 mm x 108 mm 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	

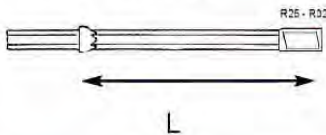
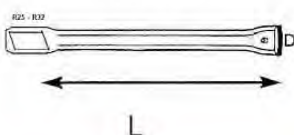
22 mm Hexagon		Series	Length (L)		Diameter (ø)		Part Number
			mm	ft in	mm	in	
Shank 25 mm x 159 mm Hex 25 		1600	5-3	41	1 5/8	737 1641	
		2400	7-11	40	1 19/32	737 2440	
		3200	10-6	39	1 17/32	737 3239	
		4000	13-1	39	1 17/32	737 4039	
		4800	15-9	38	1 1/2	737 4838	
3-Wing "Uppercut" Shank 25 mm x 159 mm 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
Shank 22 mm x 108 mm 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
Shank 22 mm x 108 mm 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
Thread R25 – > R32 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.

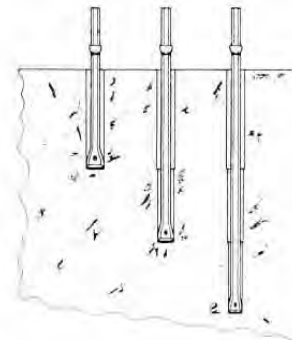
Integral Drill Steels are a fixed length with a shank at one end and a bit at the other, and are able to drill to a depth equivalent to their effective length. The bit may consist of a single chisel shaped tungsten carbide insert or three such inserts.

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.



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