# INTERNATIONAL STANDARD

**ISO 10898**

First edition
1992-02-01

## Spot drills

*Forets à pointer*



Reference number
ISO 10898:1992(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 10898 was prepared by Technical Committee ISO/TC 29, *Small tools*, Sub-Committee SC 2, *Drills and reamers*.





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# Spot drills

## 1 Scope

This International Standard specifies the dimensions and technical specifications of spot drills of high-speed steel and hardmetal with point angle of 90° or 120°.

## 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 286-2:1988, *ISO system of limits and fits — Part 2: Tables of standard tolerance grades and limit deviations for holes and shafts.*

## 3 Dimensions

See figure 1 and table 1.

## 4 Technical specifications

### 4.1 Conception

Spot drills in accordance with this International Standard shall be made without lands and back taper.

### 4.2 Permissible division deviation on flutes

See table 2.

### 4.3 Maximum runout of the fluted part with respect to the shank

See table 2.



## 5 Designation

Spot drills in accordance with this International Standard shall be designated by:

a) "Spot drill";

b) reference to this International Standard;

c) its point angle;

d) its diameter, $d$, in millimetres.

EXAMPLE

A spot drill of diameter $d = 10$ mm and point angle 90° is designated as follows:

**Spot drill ISO 10898 - 90° - 10**

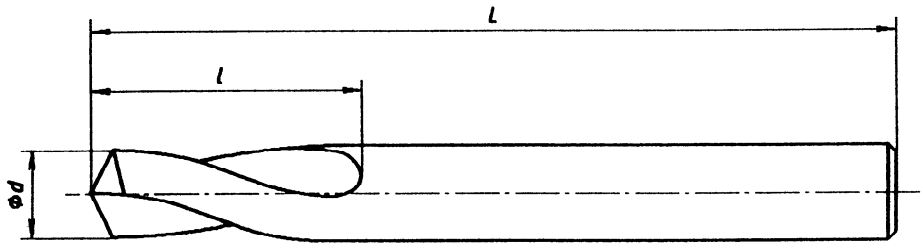


**Figure 1**

**Table 1**

Dimensions in millimetres

| $d$ h8[1)] | 4 | 6 | 8 | 10 | 12 | 16 | 20 |
|---|---|---|---|---|---|---|---|
| $L$ | 52 | 66 | 79 | 89 | 102 | 115 | 131 |
| $l$ | 12 | 20 | 25 | 25 | 30 | 35 | 40 |

1) See ISO 286-2.



**Table 2**

Dimensions in millimetres

| $d$ | Permissible division deviation on flutes | Maximum runout of the fluted part with respect to the shank |
|---|---|---|
| 4; 6 | 0,03 | 0,03 |
| 8; 10 | 0,04 | 0,04 |
| 12; 16; 20 | 0,05 | 0,05 |

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**Descriptors**: tools, cutting tools, drills, spot drills, specifications, dimensions, designation.

Price based on 2 pages