INTERNATIONAL STANDARD

ISO 2541

Second edition
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Centre drills for centre holes with radius form — Type R

Forets à centrer pour centres à profil curviligne — Type R

Reference number
ISO 2541:2016(E)

ISO copyright office
Ch. de Blandonnet 8 • CP 401
CH-1214 Vernier, Geneva, Switzerland
Tel. +41 22 749 01 11
Fax +41 22 749 09 47
copyright@iso.org
www.iso.org

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Foreword

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The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

The committee responsible for this document is ISO/TC 29, *Small tools*, Subcommittee SC 2, *Holding tools, adaptive items and interfaces*.

This second edition cancels and replaces the first edition (ISO 2541:1972), of which it constitutes a minor revision, notably with the addition of Annex B, which gives the relationship between the designations of this International Standard and the ISO 13399 series.

Introduction

This International Standard relates to centre drills and deals only with centre drills for centre holes with radius — Type R. It is a continuation of ISO 866 and ISO 2540.

Centre drills for centre holes with radius form — Type R

1 Scope

This International Standard specifies the dimensions of centre drills for centre holes with radius — Type R.

It covers only metric dimensions, regarded as the only recommended dimensions in the future for this type of drills.

The flutes can be straight or spiral at the option of manufacturer.

Unless otherwise stated, these drills are right-hand cutting.

Annex A gives the recommended dimensions for the centre holes, Type R, which can be obtained by a rational use of the centre drills listed in this International Standard.

2 Designation

Centre drills shall be designated by the type (Type R in this case), the pilot diameter, d (first column of Table 1) and the shank diameter, d_1 (second column of Table 1).

EXAMPLE R 2,5/6,3.

3 Dimensions

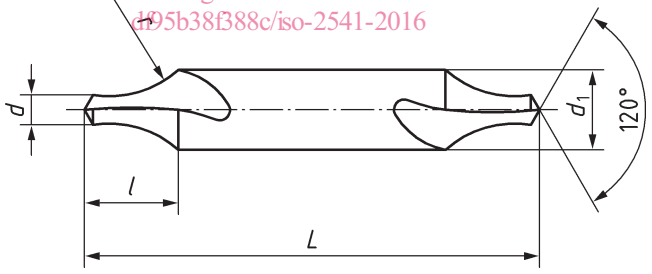

Figure 1 — Centre drills — Type R

Table 1

Dimensions in millimetres

d[a]	d_1	L		l	r	
k12	h9	max.	min.		max.	min.
1,0	3,15	33,5	29,5	3,0	3,15	2,5
(1,25)	3,15	33,5	29,5	3,35	4,0	3,15
1,6	4,0	37,5	33,5	4,25	5,0	4,0
2,0	5,0	42	38	5,3	6,3	5,0
2,5	6,3	47	43	6,7	8,0	6,3
3,15	8,0	52	48	8,5	10,0	8,0
4,0	10,0	59	53	10,6	12,5	10,0
(5,0)	12,5	66	60	13,2	16,0	12,5
6,3	16,0	74	68	17,0	20,0	16,0
(8,0)	20,0	83	77	21,2	25,0	20,0
10,0	25,0	103	97	26,5	31,5	25,0

[a] Sizes in brackets should be avoided whenever possible.

Annex A
(normative)

Dimensions for centre hole — Type R

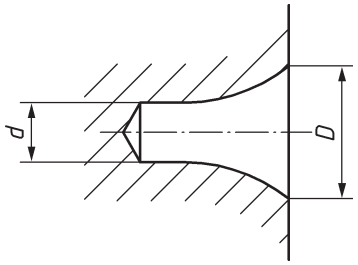

Figure A.1

Table A.1

Dimensions in millimetres

d[a] nominal	D nominal
1,0	2,12
(1,25)	2,65
1,6	3,35
2,0	4,25
2,5	5,3
3,15	6,7
4,0	8,5
(5,0)	10,6
6,3	13,2
(8,0)	17,0
10,0	21,2

[a] Sizes in brackets should be avoided whenever possible.