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Centre drills for centre holes with protecting chamfer — Type B

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FOREWORD

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Draft International Standards adopted by the Technical Committees are circulated to the Member Bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 2540 was drawn up by Technical Committee ISO/TC 29, *Small tools.*

It was approved in February 1972 by the Member Bodies of the following countries :

Austria	Israel	Sweden
Belgium	Italy	Switzerland
Czechoslovakia	Japan	Thailand
Egypt, Arab Rep. of	Netherlands	Turkey
France	Poland	United Kingdom
Germany	Romania	U.S.S.R.
Hungary	South Africa, Rep. of	
India	Spain	

The Member Body of the following country expressed disapproval of the document on technical grounds :

U.S.A.

Printed in Switzerland

Centre drills for centre holes with protecting chamfer — Type B

0 INTRODUCTION

This International Standard relating to centre drills deals only with centre drills for centre holes with protecting chamfer — Type B. It is a continuation of ISO/R 866, *Centre drills for centre holes without protecting chamfers — Type A,* and precedes ISO 2541, *Centre drills for centre holes with radius form — Type R.*

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions of centre drills for centre holes with protecting chamfer — Type B.

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

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

Unless otherwise stated these drills will be right-hand cutting.

This International Standard includes an Annex giving the recommended dimensions for the centre holes, Type B, 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 (in this case, Type B), the pilot diameter d (first column of Table 1) and the shank diameter d_1 (second column of Table 1).

Example : B 2,5/10.

3 DIMENSIONS

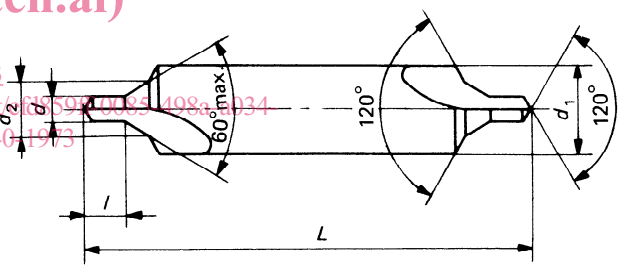

FIGURE 1 — **Centre drill — Type B**

TABLE 1

Dimensions in millimetres

d* k12	d_1 h9	d_2 k12	l max.	l min.	L max.	L min.
1,0	4,0	2,12	1,9	1,3	37,5	33,5
(1,25)	5,0	2,65	2,2	1,6	42	38
1,6	6,3	3,35	2,8	2,0	47	43
2,0	8,0	4,25	3,3	2,5	52	48
2,5	10,0	5,30	4,1	3,1	59	53
3,15	11,2	6,70	4,9	3,9	63	57
4,0	14,0	8,50	6,2	5,0	70	64
(5,0)	18,0	10,60	7,5	6,3	78	72
6,3	20,0	13,20	9,2	8,0	83	77
(8,0)	25,0	17,00	11,5	10,1	103	97
10,0	31,5	21,20	14,2	12,8	128	122

* Sizes in brackets should be avoided whenever possible.

ANNEX

DIMENSIONS FOR CENTRE HOLES, TYPE B, AND CHOICE OF THE DIMENSIONING METHOD

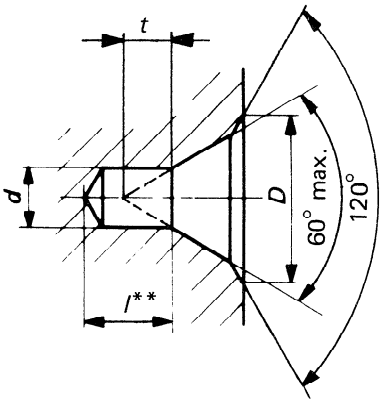

FIGURE 2 – **Method 1**

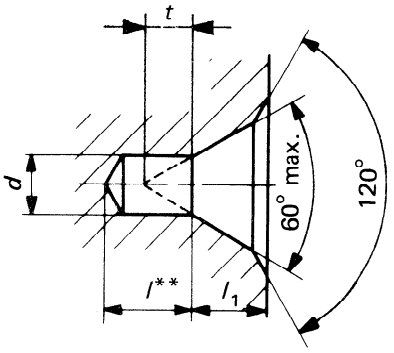

FIGURE 3 – **Method 2**

The two methods of dimensioning are practically equivalent. Member Bodies will choose one or the other for inclusion in their national standards.

TABLE 2

Dimensions in millimetres

	Method 1	**Method 2**	
*d**	*D*	l_1	*t*
nominal	nominal	nominal	ref.
1,0	3,15	1,27	0,9
(1,25)	4	1,60	1,1
1,6	5	1,99	1,4
2,0	6,3	2,54	1,8
2,5	8	3,20	2,2
3,15	10	4,03	2,8
4,0	12,5	5,05	3,5
(5,0)	16	6,41	4,4
6,3	18	7,36	5,5
(8,0)	22,4	9,35	7,0
10,0	28	11,66	8,7

* Sizes in brackets should be avoided whenever possible.

** Dimension *l* depends on the length *l* of the centre drill. It should not, even in the case of drilling with re-sharpened centre drills, be less than the reference value given in Table 2.