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**INTERNATIONAL STANDARD**



**2541**

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INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

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## **Centre drills for centre holes with radius form – Type R**

First edition – 1972-12-15

**ITeH STANDARD PREVIEW**  
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**Descriptors :** tools, drills, centre drills, dimensions.

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## FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO Member Bodies). The work of developing International Standards is carried out through ISO Technical Committees. Every Member Body interested in a subject for which a Technical Committee has been set up 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.

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 2541 was drawn up by Technical Committee ISO/TC 29, *Small tools*.

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

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

No Member Body expressed disapproval of the document.

# Centre drills for centre holes with radius form – Type R

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### 0 INTRODUCTION

This International Standard relates to centre drills and deals only with centre drills for centre holes with radius form – Type R. It is a continuation of ISO/R 866, *Centre drills for centre holes without protecting chamfers – Type A*, and ISO 2540, *Centre drills for centre holes with protecting chamfer – Type B*.

### 1 SCOPE AND FIELD OF APPLICATION

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

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

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 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  $d_1$  (column 2 of Table 1).

*Example* : R 2,5/6,3

### 3 DIMENSIONS

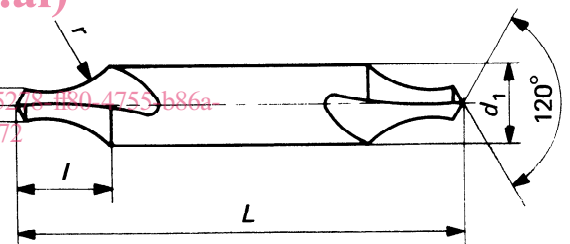


FIGURE 1 – Centre drills – Type R

TABLE 1

Dimensions in millimetres

$d^*$ k12	$d_1$ h9	$L$		$l$	$r$	
		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

\* Sizes in brackets should be avoided whenever possible.

ANNEX

DIMENSIONS FOR CENTRE HOLE – TYPE R

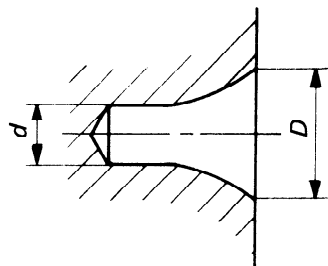


FIGURE 2

TABLE 2

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Dimensions in millimetres

$d^*$ 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

\* Sizes in brackets should be avoided whenever possible.

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