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# INTERNATIONAL STANDARD 4206

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

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## Counterbores with parallel shanks and solid pilots

*Outils à lamer, à queue cylindrique et pilote fixe*

First edition — 1977-02-01

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[ISO 4206:1977](#)

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**Descriptors** : tools, cutting tools, power-operated tools, counterboring cutters, parallel shanks, tool pilots, specifications, dimensions.

## 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 4206 was drawn up by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in January 1976.

It has been approved by the member bodies of the following countries :

Australia	Israel	Spain
Austria	Italy	Sweden
Belgium	Japan	Switzerland
Brazil	Korea, Rep. of	Turkey
Bulgaria	Mexico	United Kingdom
France	Netherlands	U.S.A.
Germany	Poland	U.S.S.R.
Hungary	Romania	
India	South Africa, Rep. of	

No member body expressed disapproval of the document.

# Counterbores with parallel shanks and solid pilots

## 1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions of counterbores with parallel shanks and solid pilots for general use.

The illustration is diagrammatic only and is not intended to indicate details of design.

## 2 REFERENCE

ISO 4205, *Countersinks, 90° with parallel shanks and solid pilots.*

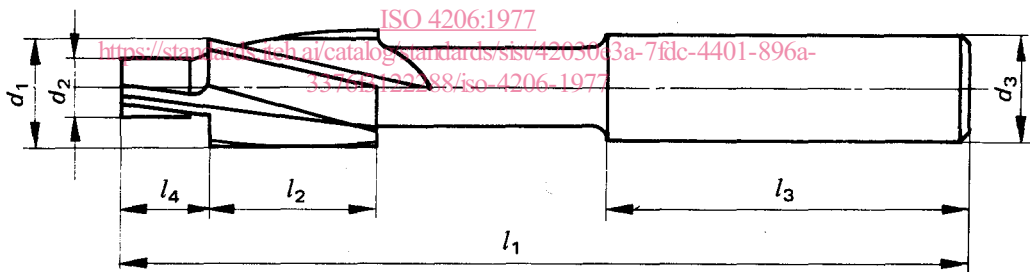
## 3 DIMENSIONS

Dimensions for counterbores with parallel shanks and solid pilots are given in the table. It specifies dimensions in metric units only, these being regarded as the only recommended dimensions in the future.

## 4 TOLERANCES

The tolerances relating to the counterbores, parallel shanks and solid pilots are as follows :

- cutting diameter  $d_1$  : z9
- pilot diameter  $d_2$  : e8
- shank diameter  $d_3$  : h9.



The illustration shows a counterbore with cutting diameter  $d_1$  greater than 5 mm.

Dimensions in millimetres

Cutting diameter $d_1$ (z9)		Pilot diameter $d_2$ e8	$d_3$ h9	$l_1$	$l_2$	$l_3$ ≈	$l_4$
over	to						
2 <sup>1)</sup>	3,15	To be specified to suit pilot hole diameter, when ordering (Minimum possible diameter is $d_2 = 1/3 d_1$ )	= $d_1$	45	7	-	≈ $d_2$
3,15	5			56	10		
5	8		5	71	14	31,5	
8	12,5		8	80	18	35,5	
12,5	20		12,5	100	22	40	

1) Includes 2 mm.

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