INTERNATIONAL STANDARD ISO 2540

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

Centre drills for centre holes with protecting chamfer — Type B

First edition — 1973-04-15

UDC 621.951.4

Ref. No. ISO 2540-1973 (E)

Descriptors : tools, drill bits, centre drills, dimensions.

Price based on 2 pages

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

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

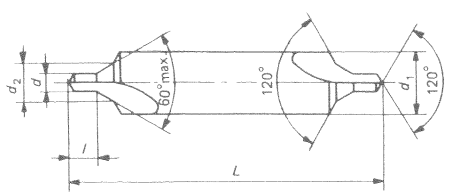

FIGURE 1 — **Centre drill — Type B**

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

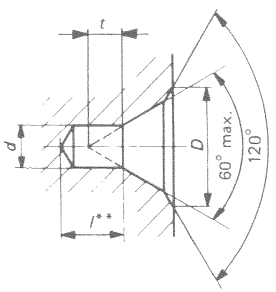

FIGURE 2 — **Method 1**

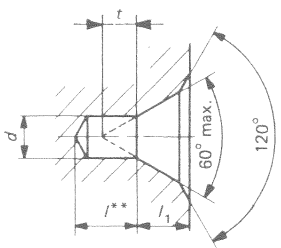

FIGURE 3 — **Method 2**

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

d^* nominal	Method 1 D nominal	Method 2 l_1 nominal	t 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.