

ADDISON High Speed Steel
CENTRE DRILLS - Type 'A'

Specifications Conform to :
IS 6708 - 1977
ISO 866 - 1975
DIN 333 - 1986
Dimensions in mm



Pilot Dia k12	Body Dia h9	Overall Length		Pilot Length	
		Maximum	Minimum	Maximum	Minimum
1.00	3.15	33.50	29.50	1.90	1.30
1.25	3.15	33.50	29.50	2.20	1.60
1.60	4.00	37.50	33.50	2.80	2.00
2.00	5.00	42.00	38.00	3.30	2.50
2.50	6.30	47.00	43.00	4.10	3.10
3.15	8.00	52.00	48.00	4.90	3.90
4.00	10.00	59.00	53.00	6.20	5.00
5.00	12.50	66.00	60.00	7.50	6.30
6.30	16.00	74.00	68.00	9.20	8.00
8.00	20.00	83.00	77.00	11.50	10.10
10.00	25.00	103.00	97.00	14.20	12.80

Type - 'A' Centre Drill for centre holes without protecting chamfer.

ADDISON High Speed Steel
CENTRE DRILLS - Type 'B'

Specifications Conform to :
IS 6709 - 1977
ISO 2540 - 1972
DIN 333 - 1986
Dimensions in mm



Pilot Dia k12	Body Dia h9	Overall Length		Pilot Length	
		Maximum	Minimum	Maximum	Minimum
1.60	6.30	47.00	43.00	2.80	2.00
2.00	8.00	52.00	48.00	3.30	2.50
2.50	10.00	59.00	53.00	4.10	3.10
3.15	11.20	63.00	57.00	4.90	3.90
4.00	14.00	70.00	64.00	6.20	5.00
5.00	18.00	78.00	72.00	7.50	6.30
6.30	20.00	83.00	77.00	9.20	8.00
8.00	25.00	103.00	97.00	11.50	10.10

Type - 'B' Centre Drills for centre holes with protecting chamfers.

ADDISON High Speed Steel
CENTRE DRILLS

Specifications Conform to :
BS 328 : Part 2 : 1950
Dimensions in inch



B.S.No.	Body Dia	Pilot Dia	Pilot Length		OAL	Tolerance on Overall Length
			Max	Min		
1	1/8	3/64	5/64	1/16	1.1/2	± 1/32
2	3/16	1/16	3/32	5/64	1.3/4	± 1/32
3	1/4	3/32	5/32	1/8	2	± 1/16
4	5/16	1/8	3/16	5/32	2.1/4	± 1/16
5	7/16	3/16	9/32	1/4	2.1/2	± 3/32
6	5/8	1/4	3/8	5/16	3	± 3/32
7	3/4	5/16	15/32	13/32	3.1/2	± 3/32



**High Speed Steel
CENTRE DRILLS - Type 'R'**

Specifications Conform to :
 IS 6710 - 1977
 ISO 2541 - 1972
 DIN 333 - 1986
 Dimensions in mm



Pilot Dia k12	Body Dia h9	Overall Length		Pilot Length	Radius	
		Maximum	Minimum		Maximum	Minimum
1.00	3.15	33.50	29.50	3.00	3.15	2.50
1.25	3.15	33.50	29.50	3.35	4.00	3.15
1.60	4.00	37.50	33.50	4.25	5.00	4.00
2.00	5.00	42.00	38.00	5.30	6.30	5.00
2.50	6.30	47.00	43.00	6.70	8.00	6.30
3.15	8.00	52.00	48.00	8.50	10.00	8.00
4.00	10.00	59.00	53.00	10.60	12.50	10.00
5.00	12.50	66.00	60.00	13.20	16.00	12.50
6.30	16.00	74.00	68.00	17.00	20.00	16.00
8.00	20.00	83.00	77.00	21.20	25.00	20.00
10.00	25.00	103.00	97.00	26.50	31.50	25.00

Type - 'R' Centre Drills for centre holes with radius form.