

**High Speed Steel
CENTRE DRILL
Type - A**

Pilot Diameter (k12)	Body Diameter (h9)	Overall Length		Pilot Length	
		Max	Min	Max	Min
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



TWIST DRILLS

Dimensions in mm
Specifications conform to
IS 6708 : 2002
ISO 866 : 1975
DIN 333 : 1986

Range of Application:
For producing centre holes form A

TS

TWIST DRILLS



Dimensions in mm
Specifications conform to
IS 6709 : 2002
ISO 2540 : 1972
DIN 333 : 1986

TS

High Speed Steel CENTRE DRILLS Type - B

Pilot Diameter (k12)	Body Diameter (h9)	Overall Length		Pilot Length	
		Max	Min	Max	Min
160	6.30	47.00	43.00	2.80	2.00
200	8.00	52.00	48.00	3.30	2.50
250	10.00	59.00	53.00	4.10	3.10
315	11.20	63.00	57.00	4.90	3.90
400	14.00	70.00	64.00	6.20	5.00
(500)	18.00	78.00	72.00	7.50	6.30
630	20.00	83.00	77.00	9.20	8.00
(800)	25.00	103.00	97.00	11.50	10.10
1000	31.50	128.00	122.00	14.20	12.80

Range of Application:

For producing protected type center hole form **B**

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

Pilot Dia (k12)	Body Dia (h9)	Overall Length		Cutting Edge Length	Radius	
		Max	Min		Max	Min
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	43	6.7	8.0	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



TWIST DRILLS

Dimensions in mm
Specifications conform to
IS 6710 : 2002
ISO 2541 : 1972
DIN 333 : 1986

Range of Application:
For producing radius type centre hole form R

TS

TWIST DRILLS



Dimensions in Inches
Specifications conform to
BS 328 Part 2 : 1990

High Speed Steel CENTRE DRILLS Inch Sizes

B. S. No.	Body Diameter	Pilot Diameter		Pilot Length	Overall Length	
		Max	Min		Size	Tol +
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

TS

Range of Application:
For producing centre holes form A