

इंटरनेट

मानक

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“जानने का अधिकार, जीने का अधिकार”

Mazdoor Kisan Shakti Sangathan

“The Right to Information, The Right to Live”

“पुराने को छोड़ नये के तरफ”

Jawaharlal Nehru

“Step Out From the Old to the New”

IS 6708 (1977): Centre Drills Type A [PGD 32: Cutting tools]



“ज्ञान से एक नये भारत का निर्माण”

Satyanarayan Gangaram Pitroda

“Invent a New India Using Knowledge”



“ज्ञान एक ऐसा खजाना है जो कभी चुराया नहीं जा सकता है”

Bhartrhari—Nitiśatakam

“Knowledge is such a treasure which cannot be stolen”



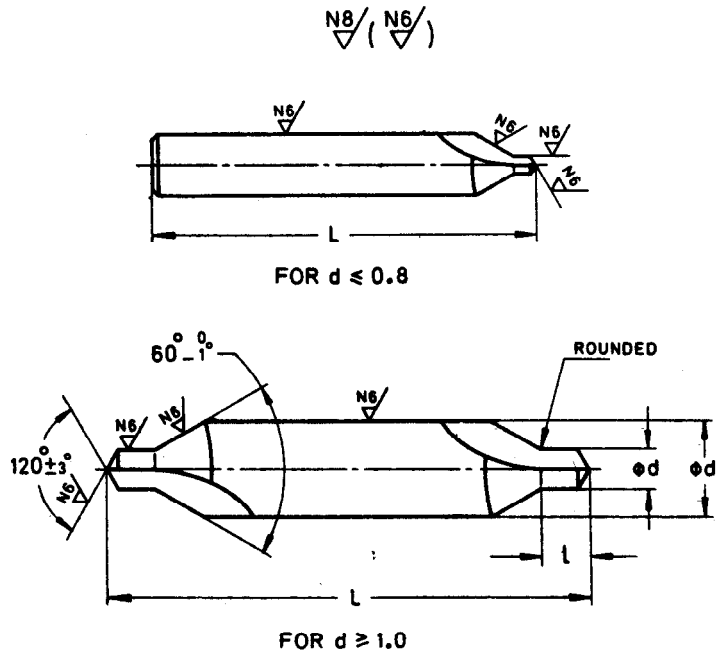
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*Indian Standard*  
**SPECIFICATION FOR  
 CENTRE DRILLS TYPE A**  
*( First Revision )*

**1. Scope** — Covers the dimensions and requirements for centre drills type A, suitable for centre holes without protecting chamfers according to IS : 2473-1975 'Dimensions for centre holes'.

**2. Dimensions**



All dimensions in millimetres.

d	d <sub>1</sub>	L		l	
		Max	Min	Max	Min
k12	h9				
(0.5)	3.15	21	19	1.0	0.8
(0.63)	3.15	21	19	1.2	0.9
(0.8)	3.15	21	19	1.5	1.1
1.0	3.15	33.5	29.5	1.9	1.3
(1.25)	3.15	33.5	29.5	2.2	1.6
1.6	4.0	37.5	33.5	2.8	2.0
2.0	5.0	42	38	3.3	2.5
2.5	6.3	47	43	4.1	3.1
3.15	8.0	52	48	4.9	3.9
4.0	10.0	59	53	6.2	5.0
(5.0)	12.5	66	60	7.5	6.3
6.3	16.0	74	68	9.2	8.0
(8.0)	20.0	83	77	11.5	10.1
10.0	25.0	103	97	14.2	12.8

Note — Non-preferred sizes are given within brackets.

**3. Material** — High speed steel.

**NOTE** — Unless otherwise specified, the high speed steel shall be according to T83W6Mo5Cr4V2 or T70W18Cr4V1 according to IS : 7291-1974 'High speed tool steels', or equivalent, in which case the major constituents shall be specified by the manufacturer.

Adopted 17 January 1977

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Gr 1

**IS : 6708 - 1977**

**4. Hardness** — 760 HV Min  
900 HV Max

**5. General Requirements**

**5.1** The flutes may be straight or spiral at the discretions of the manufacturer.

**5.2** Hand of cutting, unless otherwise specified : Right.

**5.3** The drills shall be manufactured in one piece and shall be free from cracks and burrs.

**5.4** The two cutting edges of the centre drill shall be diametrically opposite.

**5.5** The drill shall be properly sharpened and ready for use.

**6. Sampling** — The sampling and criteria of acceptance shall be in accordance with IS : 7778-1975 'Methods for sampling small tools'.

**7. Designation** — A centre drill type A, without protecting chamfers, having pilot diameter  $d=1.6$  mm and shank diameter  $d_1=4.0$  mm and conforming to this standard shall be designated as:

Centre Drill A 1.6 x 4.0 IS : 6708

**8. Marking** — Shall be marked with type, pilot diameter  $d$ , shank diameter  $d_1$  and manufacturer's name or trade-mark.

**8.1 Certification Marking** — Details available with the Bureau of Indian Standards.

**9. Preservative Coating and Packing**

**9.1** Each centre drill shall be covered with a suitable rust proofing material.

**9.2** Each centre drill or a number of centre drills shall be wrapped in non-absorbent paper protected by a cover bearing the type, pilot diameter and shank diameter of the centre drill and manufacturer's name or trade-mark.

**9.3** One size of centre drills shall be packed in one carton.

**EXPLANATORY NOTE**

This standard was first published in 1972. The present revision has been taken up to keep it in line with the work done at ISO level. This standard is in full conformity with ISO 866-1975 'Centre drills for centre holes without protecting chamfers—Type A' issued by International Organization for Standardization.