INTERNATIONAL STANDARD

# ISO 866

Second edition
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# Centre drills for centre holes without protecting chamfers — Type A

*Forets à centrer pour centres sans chanfrein de protection — Type A*



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# Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established 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. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see www.iso.org/directives).

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For an explanation on the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the WTO principles in the Technical Barriers to Trade (TBT), see the following URL: Foreword — Supplementary information.

The committee responsible for this document is ISO/TC 29, *Small tools,* Subcommittee SC 2*, Holding tools, adaptive items and interfaces*.

This second edition cancels and replaces the first edition (ISO 866:1975), which constitutes a minor revision with the addition of Annex B, showing the relationship between the symbols in this International Standard and the symbols in the ISO 13399 series.

# Introduction

This International Standard, relating to centre drills, covers only centre drills for centre holes without a protecting chamfer (Type A). The other types are covered in ISO 2540 (Type B) and ISO 2541 (Type R).

# Centre drills for centre holes without protecting chamfers — Type A

## 1 Scope

This International Standard specifies the dimensions of centre drills for centre holes without protecting chamfers (Type A).

It covers only metric dimensions, which are regarded as the only recommended dimensions in the future for this type of drill.

The flutes may be straight or spiral, depending on the manufacturer's discretion.

Unless otherwise indicated, these drills will be right-hand cutting.

Recommended dimensions for Type A centre holes, which can be obtained by a rational use of the centre drills listed in this International Standard, are given in Annex A.

## 2 Dimensions

Dimensions of the centre drill shall be in accordance with the dimensions shown in Figures 1 and 2 and given in Table 1.

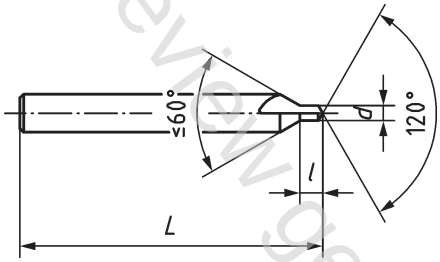


**Figure 1 — Single-ended centre drill — Type A** ($d \leq 0{,}8$ mm)

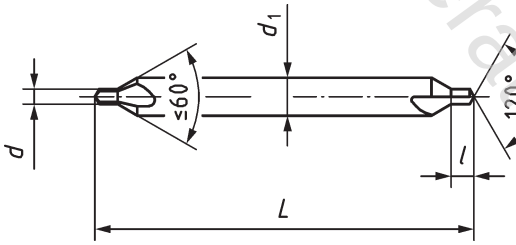


**Figure 2 — Double-ended centre drill — Type A** ($d \geq 1$ mm)



 