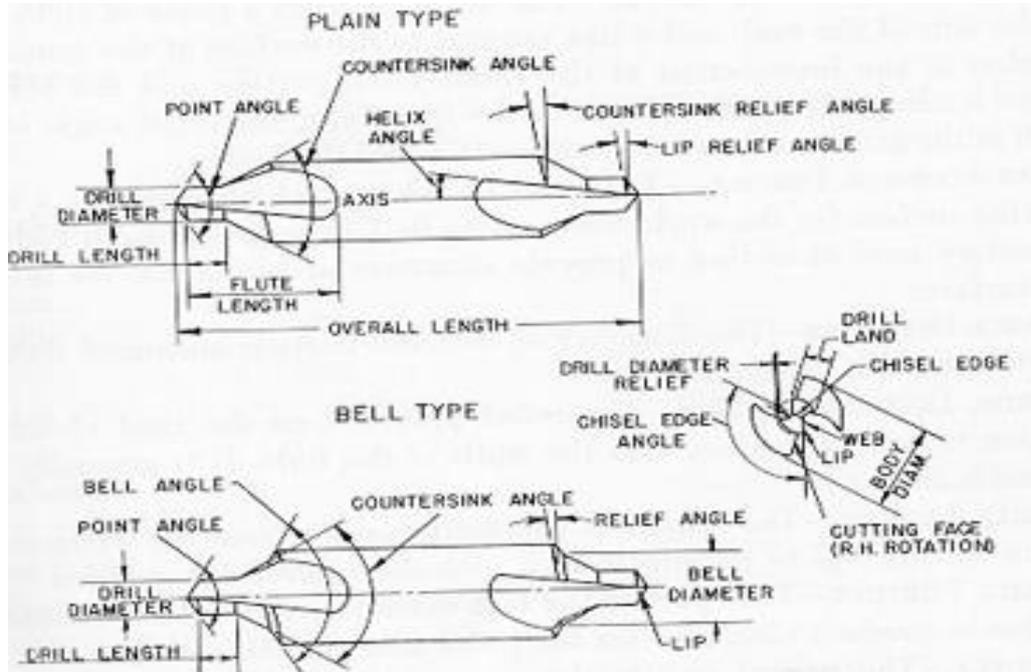


**Centre Drills and Counter Sinks**

## Nomenclature



- **Centre Drills**
  - **Type 'A'**
  - **Type 'B'**
  - **Type 'R'**
- **CounterSinks**
  - **Plain Type**
  - **Bell Type**



Centre Drills – HSS – BS 328 (inches)						
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

Centre Drills – HSS – Type 'A' (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

Centre Drills – HSS – Type 'B' (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

Centre Drills – HSS – Type 'R' (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





Counter Sinks – Plain Type			(inches)
Size	Body Diameter	Drill Diameter	Overall Length
1	1/8	3/64	1.1/4
2	3/16	5/64	1.7/8
3	1/4	7/64	2
4	5/16	1/8	2.1/8
5	7/16	3/16	2.3/4
6	1/2	7/32	3
7	5/8	1/4	3.1/4
8	3/4	5/16	3.1/2

Counter Sinks – Bell Type			(inches)
Size	Body Diameter	Drill Diameter	Overall Length
13	1/4	3/32	2
14	5/16	7/64	2.1/8
15	7/16	5/32	2.3/4
16	1/2	3/16	3
17	5/8	7/32	3.1/4
18	3/4	1/4	3.1/2

