
INTERNATIONAL STANDARD



4206

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Counterbores with parallel shanks and solid pilots

Outils à lamer, à queue cylindrique et pilote fixe

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Descriptors : tools, cutting tools, power-operated tools, counterboring cutters, parallel shanks, tool pilots, specifications, dimensions.

FOREWORD

ISO (the International Organization for Standardization) is a worldwide federation of national standards institutes (ISO member bodies). The work of developing International Standards is carried out through ISO technical committees. Every member body interested in a subject for which a technical committee has been set up 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.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council.

International Standard ISO 4206 was drawn up by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in January 1976.

It has been approved by the member bodies of the following countries :

Australia	Israel	Spain
Austria	Italy	Sweden
Belgium	Japan	Switzerland
Brazil	Korea, Rep. of	Turkey
Bulgaria	Mexico	United Kingdom
France	Netherlands	U.S.A.
Germany	Poland	U.S.S.R.
Hungary	Romania	
India	South Africa, Rep. of	

No member body expressed disapproval of the document.

Counterbores with parallel shanks and solid pilots

1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions of counterbores with parallel shanks and solid pilots for general use.

The illustration is diagrammatic only and is not intended to indicate details of design.

2 REFERENCE

ISO 4205, *Countersinks, 90°, with parallel shanks and solid pilots.*

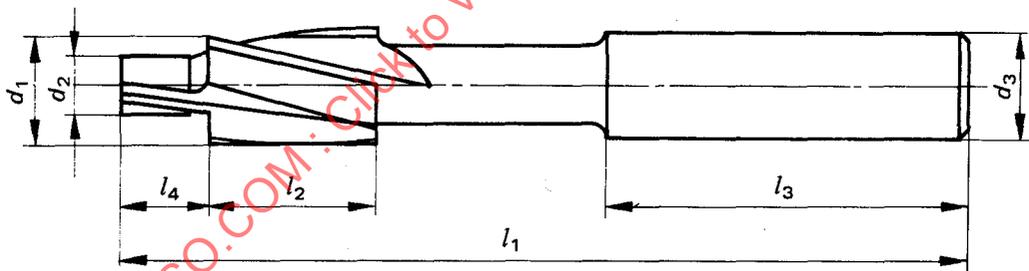
3 DIMENSIONS

Dimensions for counterbores with parallel shanks and solid pilots are given in the table. It specifies dimensions in metric units only, these being regarded as the only recommended dimensions in the future.

4 TOLERANCES

The tolerances relating to the counterbores, parallel shanks and solid pilots are as follows :

- cutting diameter d_1 : z9
- pilot diameter d_2 : e8
- shank diameter d_3 : h9.



The illustration shows a counterbore with cutting diameter d_1 greater than 5 mm.

Dimensions in millimetres

Cutting diameter d_1 (z9)		Pilot diameter d_2 e8	d_3 h9	l_1	l_2	l_3 ≈	l_4
over	to						
2 ¹⁾	3,15	To be specified to suit pilot hole diameter, when ordering (Minimum possible diameter is $d_2 = 1/3 d_1$)	= d_1	45	7	-	≈ d_2
3,15	5			56	10		
5	8		5	71	14	31,5	
8	12,5		8	80	18	35,5	
12,5	20		12,5	100	22	40	

1) Includes 2 mm.