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**INTERNATIONAL STANDARD**



**4208**

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

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**Detachable pilots for use with counterbores and  
90° countersinks — Dimensions**

*Pilotes amovibles pour outils à lamer et outils à chanfreiner à 90° — Dimensions*

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**Descriptors** : tools, countersinks, counterboring cutters, tool pilots, specifications, dimensions, dimensional tolerances.

## 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 4208 was developed by Technical Committee ISO/TC 29, *Small tools*, and was circulated to the member bodies in April 1976.

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

Australia	India	Romania
Austria	Ireland	South Africa, Rep. of
Belgium	Israel	Spain
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Chile	Japan	U.S.S.R.
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Germany	Netherlands	
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The member body of the following country expressed disapproval of the document on technical grounds :

U.S.A.

# Detachable pilots for use with counterbores and 90° countersinks – Dimensions

## 1 SCOPE AND FIELD OF APPLICATION

This International Standard specifies the dimensions of detachable pilots for use with counterbores and 90° countersinks with Morse taper shanks. They can also be used for other types of cutters.

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

## 2 REFERENCES

ISO 4204, 90° countersinks with Morse taper shanks and detachable pilots.

ISO 4207, Counterbores with Morse taper shanks and detachable pilots.

## 3 DIMENSIONS

The dimensions of detachable pilots for use with counterbores and 90° countersinks are given in the table, which specifies dimensions in metric units only, these being regarded as the only recommended dimensions in the future.

## 4 TOLERANCES

The tolerances relating to detachable pilots are as follows :

Pilot diameter  $d_1$  : e8

Shank diameter  $d_2$  : f7

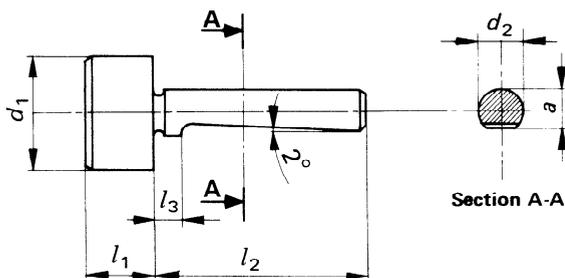


TABLE – Dimensions of detachable pilots

Values in millimetres

$d_2$ f7	$d_1$ (e8)		$a$ 0 -0,1	$l_1$	$l_2$	$l_3$
	over	up to				
4	5	6,3	3,6	5	20	3
	6,3	8		6		
	8	10		7		
	10	12,5		8		4
	12,5	14		10		
5	6,3	8	4,6	6	23	3
	8	10		7		
	10	12,5		8		
	12,5	16		10		4
	16	18		12		
6	8	10	5,5	7	28	4
	10	12,5		8		
	12,5	16		10		
	16	20		12		
	20	22,4		15		5
8	10	12,5	7,5	8	32	4
	12,5	16		10		
	16	20		12		
	20	25		15		5
	25	28		18		
10	12,5	16	9,1	10	40	5
	16	20		12		
	20	25		15		
	25	31,5		18		6
	31,5	35,5		22		
12	16	20	11,3	12	50	5
	20	25		15		
	25	31,5		18		
	31,5	40		22		6
	40	45		27		
16	20	25	15,2	15	60	6
	25	31,5		18		
	31,5	40		22		
	40	50		27		
	50	56		30		