

ISO

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION

ISO RECOMMENDATION

R 494

PARALLEL SHANK TWIST DRILLS — LONG SERIES

1st EDITION
August 1966

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Printed in Switzerland

Also issued in French and Russian. Copies to be obtained through the national standards organizations.

BRIEF HISTORY

The ISO Recommendation R 494, *Parallel Shank Twist Drills – Long Series*, was drawn up by Technical Committee ISO/TC 29, *Small Tools*, the Secretariat of which is held by the Association Française de Normalisation (AFNOR).

Work on this question by the Technical Committee began in 1950, taking into account the studies which had been made by the former International Federation of the National Standardizing Associations (ISA), and led in 1962 to the adoption of a Draft ISO Recommendation.

In April 1964, this Draft ISO Recommendation (No. 663) was circulated to all the ISO Member Bodies for enquiry. It was approved, subject to a few modifications of an editorial nature, by the following Member Bodies:

Argentina	France	Poland
Austria	Germany	Portugal
Belgium	Hungary	Spain
Brazil	India	Sweden
Canada	Italy	Switzerland
Chile	Japan	Turkey
Colombia	Korea, Rep. of	United Kingdom
Czechoslovakia	Netherlands	U.S.S.R.
Denmark	New Zealand	Yugoslavia

One Member Body opposed the approval of the Draft: U.S.A.

The Draft ISO Recommendation was then submitted by correspondence to the ISO Council, which decided, in August 1966, to accept it as an ISO RECOMMENDATION.

PARALLEL SHANK TWIST DRILLS — LONG SERIES

INTRODUCTION

1...5... lays down the dimensions of
This ISO Recommendation relates to twist drills and deals with

parallel shank twist drills, long series. see Tables 1.1 to 1.3.

It supplements ISO Recommendation R 235, *Parallel Shank Twist Drills, Jobber and Stub Series, and Morse Taper Shank Twist Drills and core drills.*

Other types of twist drills will be dealt with in further ISO Recommendations as and when current work on them is completed.

IT
This ISO Recommendation comprises three tables giving respectively :

- ☐ a) the recommended dimensions in millimetres;
- ☐ b) the recommended dimensions in inches;
- ☐ c) the corresponding lengths, in millimetres and in inches, set out as functions of diameter steps.

2 — H. INTERCHANGEABILITY

The numerical tables have been drawn up in such a way as to ensure that the standard dimensions in millimetres and inches correspond as closely as possible.

To this end, the complete range of diameters has been subdivided into a number of steps, the limits of which have been derived from the preferred number series for the metric values and converted directly from those for the inch values; the lengths remain the same for the metric and for the inch values, within a given step.

The recommended diameters in the two systems of units of measurement differ, however, and the number of recommended diameters, in a given step, also differs in one system from that in the other.

Finally, the tolerance on the diameter of the cutting portion has been standardized solely on the basis of the metric values of h8, * converted directly into inches for inch drills.

* See ISO Recommendation R 286, ISO System of Limits and Fits — Part 1: General, Tolerances and Deviations.

(Ram)