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GB/T 17112-2022

Spot drills

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foreword

This document is in accordance with the provisions of GB/T 1.1-2020 "Guidelines for Standardization Work Part 1.Structure and Drafting Rules of Standardization Documents"

drafted.

This document replaces GB/T 17112-1997 "Centering Drill". Compared with GB/T 17112-1997, the main technical changes are as follows.

--- Added materials in the technical requirements (see Chapter 5);

--- Increased the normal circular runout of the cutting edge (see Chapter 5);

--- The marking of materials has been added to the marking (see Chapter 6);

--- Increase Chapter 7 "Marking and Packaging" (see Chapter 7).

The revision of this document adopts ISO 10898.2016 "Center Drill".

This document has the following structural adjustments compared to ISO 10898.2016.

--- Added Chapter 3 Terms and Definitions;

--- Added Chapter 7 signs and packaging.

The technical differences between this document and ISO 10898.2016 and their reasons are as follows.

--- In Table 2, "the maximum runout of the groove to the shank" is changed to "the radial runout of the outer circle of the working part to the axis of the shank" and "cutting edge"

Normal circular runout to the axis of the handle", which is in line with the actual domestic situation;

---In the technical requirements, the requirements for materials and heat treatment are added to facilitate the use of this document;

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---In the marking, the marking order of each element has been changed, and the marking of materials has been added;

--- Added "sign and packaging" to facilitate the use of this document.

Please note that some content of this document may be patented. The issuing agency of this document assumes no responsibility for identifying patents.

1 Scope

This document specifies the dimensions and technical requirements for high-speed steel and carbide pilot drills with apex angles of 90° and 120°.

This document applies to the manufacture of center drills.

See Appendix A for the relationship between this document and ISO 13399 (all parts) notations.

2 Normative references

The contents of the following documents constitute essential provisions of this document through normative references in the text. Among them, dated citations

documents, only the version corresponding to that date applies to this document; for undated references, the latest edition (including all amendments) applies to

this document.

GB/T 1800.2-2020 Product Geometric Specifications (GPS) Linear Dimensional Tolerance ISO Code System Part 2.Standard

Tolerance zone code and limit deviation table of holes and shafts (ISO 286-2.2010, MOD)

GB/T 2075 Classification and use of hard cutting materials for machining

2007, ISO 513.2004, IDT)

3 Terms and Definitions

There are no terms and definitions that need to be defined in this document.

4 Types and Dimensions

The type of center drill is shown in Figure 1, and the size is shown in Table 1.Spot drills without land and back taper.

Index number description.

d---diameter;

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L---total length;

l ---Slot length.

Figure 1 Center drill

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