ASME B94.11M-1993

(REVISION OF ANSI B94.11-1979)

Twist Drills

AN AMERICAN NATIONAL STANDARD

The American Society of
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This Standard will be revised when the Society approves the issuance of a new edition. There will be no addenda or written interpretations of the requirements of this Standard issued to this Edition.

FOREWORD

(This Foreword is not a part of ASME B94.11M-1993.)

The U.S.A. Standard Twist Drills-Straight Shank (USASI B5-12-1940) Standardized Drill Nomenclature and Major Dimensions, Technical Committee No. 7 on Twist Drills was established in 1946 and a revision dated March 22, 1950 was issued.

The committee was reactivated in 1956 and a revision dated December 15, 1958 was issued.

The committee was again reactivated in 1964 and a redesignated USAS B94.11-1967 was issued on May 4, 1967.

The above standard was reaffirmed in 1972 as ANSI B94.11-1967 (R1972).

Technical Committee No. 7 was again reactivated in March 1978 for the purpose of reviewing ANSI B94.11-1967 (R1972) and considered a proposed Inch and Metric Standard submitted by the Metal Cutting Tool Institute and industry that reflects current U.S. drill usage. The proposal added metric sizes in jobbers series, screw machine series, taper length series, and taper shank series that were reflective of current industry practices and usage patterns. Metric sizes were not included for core drills, and combined drills and countersinks. In addition the entire standard was dual-dimensioned because of the metric additions. The suggestions were reviewed and a draft was approved by the Technical Committee on November 15, 1978 for submission to sectional committee B94 and sponsor organizations of ANSI. The revision was approved by the American National Standards Institute on August 29, 1979 and redesignated ANSI B94.11M-1979.

Following the resignation and retirement of all but one of the members of the Technical Committee No. 7, new members were recruited so that revisions suggested by members of the United States Cutting Tool Institute could be considered. A draft of the results of the committee's deliberations was approved by the commitee on February 28, 1991. In addition to dealing with the USCTI suggestions, the committee also corrected many numerical and editorial errors. Other changes, designed to make this document easier to use, were also recommended. The recommended revision was approved by the American National Standards Institute on September 29, 1993 and was redesignated ASME B94.11M-1993.

ASME STANDARDS COMMITTEE B94
Standardization of Cutting Tools, Holders, Drivers and Bushings

(The following is the roster of the Committee at the time of approval of this Standard.)

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