

A-A-478  
September 26, 1979

## COMMERCIAL ITEM DESCRIPTION

## DRILL, TWIST, DOUBLE END

The General Services Administration has authorized the use of this commercial item description.

This commercial item description covers double end twist drills assigned NSNs as listed below.

Salient characteristics:

Double-ended (both ends pointed) design.  
 Suitable for drilling holes in 1/4 inch thick stainless steel or alloy steels with a Rockwell C hardness of less than 45.  
 Drill point angle 135 degrees, plus or minus 5 degrees.  
 Split point (except 1/16 inch size).  
 Material M1, M2, M7 or M10 high speed steel.  
 Flute hardness Rockwell C 63 - 66.  
 Corrosion resistant surface or black oxide treated on all surfaces except the points.  
 Except for the 1/16 inch size, permanently and legibly marked with manufacturer's identification, drill size, and "HS", "HSS", or "High Speed".  
 Overall length tolerance plus or minus 1/4 inch.  
 Six drills to a package.  
 Furnished under the following National Stock Numbers (NSNs) and sizes as specified:



<u>NSN</u>	<u>Dimensions</u>
5133-00-241-5919	1/16 inch diameter, 1-5/8 inches overall length
5133-00-241-5914	3/32 inch diameter, 1-3/4 inches overall length
5133-00-241-5868	Size 41 diameter, 1-13/16 inches overall length
5133-00-507-6222	Size 40 diameter, 1-13/16 inches overall length
5133-00-133-4240	1/8 inch diameter, 1-7/8 inches overall length
5133-00-132-0379	Size 30 diameter, 1-15/16 inches overall length
5133-00-133-4242	Size 27 diameter, 2 inches overall length
5133-00-241-5771	5/32 inch diameter, 2-1/16 inches overall length
5133-00-133-4254	Size 21 diameter, 2-1/8 inches overall length
5133-00-290-3925	Size 20 diameter, 2-1/8 inches overall length
5133-00-133-4255	Size 17 diameter, 2-1/8 inches overall length
5133-00-241-5823	3/16 inch diameter, 2-3/16 inches overall length
5133-00-290-3918	Size 11 diameter, 2-1/4 inches overall length
5133-00-133-4258	Size 10 diameter, 2-1/4 inches overall length
5133-00-133-4278	Size 7 diameter, 2-3/4 inches overall length
5133-00-290-3923	1/4 inch diameter, 2-1/2 inches overall length
5133-00-290-3883	Size F diameter, 2-5/8 inches overall length

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Workmanship. The drills shall be free from fins, burrs, rust, imperfections and any other defects which may impair serviceability, durability, or appearance.

Certification. The contractor shall certify that the product offered meets the salient characteristics of this description, and that the product conforms to the producer's own drawings, specifications, standards and quality assurance practices and is the same product offered for sale in the commercial marketplace. The Government reserves the right to require proof of such conformance prior to first delivery and thereafter as may be otherwise provided for under the provisions of the contract.

Recovered materials. The manufacturer shall utilize recovered materials to the maximum extent practicable.

Preservation, packaging, packing, and marking. Each package of six drills shall be preserved and packaged in accordance with normal commercial practice and packed to assure acceptance by common carrier and provide product protection against loss and damage during multiple shipments, handling, and storage. The shipping container shall be in compliance with National Motor Freight Classification and Uniform Freight Classification. Marking shall be in accordance with the contract or order.