

A-A-2518  
December 7, 1987

COMMERCIAL ITEM DESCRIPTION

DRILL, TWIST (CARBIDE TIP)

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

This commercial item description covers twist drills with carbide tips intended for use in drilling cast iron and other nonferrous materials.

Salient characteristics:

**Design.** Drills shall be of the straight shank, jobbers length type with two helical flutes for heavy duty use in drilling cast iron and other nonferrous materials.

**Material.** Industrial Grade C-2 Carbide tipped cutting edges brazed or welded on high speed steel twist drills.

Included angle of point. 118  $\pm$ 5 degrees.

**Sizes and dimensions.** Sizes and dimensions (in inches) shall be as required for jobbers length drills in accordance with ANSI B94.11M-1979 for the National Stock Number (NSN) specified.

National Stock Number (NSN)	Drill Size (Diameter)	Flute Length	Overall Length
5133-00-222-9466	1/2 (Ø.5000)	4-1/2	6
5133-00-222-9467	3/8 (Ø.3750)	3-5/8	5
5133-00-222-9468	7/16 (Ø.4375)	4-1/16	5-1/2
5133-00-222-9469	1/4 (Ø.2500)	2-3/4	4
5133-00-222-9470	5/16 (Ø.3125)	3-3/16	4-1/2
5133-00-222-9471	3/16 (Ø.1875)	2-5/16	3-1/2
5133-00-894-5612	7/32 (Ø.2188)	2-1/2	3-3/4
5133-00-894-5615	11/32 (Ø.3438)	3-7/16	4-3/4
5133-00-948-8867	NO. 10 (Ø.1935)	2-7/16	3-5/8
5133-00-948-8868	NO. 21 (Ø.1590)	2-1/8	3-1/4
5133-01-050-9904	27/64 (Ø.4219)	3-15/16	5-3/8

**Marking.** The shank of each drill shall be marked in a legible and permanent manner with the drill size, manufacturer's name or recognizable trademark, and country of origin.

**Workmanship.** Drills shall be straight, and free of any defects which may adversely affect safety, serviceability, or durability.

**Quality assurance provisions.** Sampling for inspection shall be in accordance with MIL-STD-105, Sampling Procedures and Tables for Inspection by Attributes, except where otherwise indicated herein. The lot size shall consist of all drills with the same NSN offered for acceptance at one time. A sample unit shall be one drill.

A. Examination for design, dimensions and workmanship. The inspection level shall be S-2 with an acceptable quality level (AQL) of 4.0 percent defective.

B. Material. Material shall be verified by manufacturer's certification.

C. Packaging Inspection. An examination shall be made to determine compliance with all preservation, packaging, packing, labeling, and marking requirements as specified in the contract or purchase order. The inspection level shall be S-2 with an AQL of 2.5 defects per hundred units.

DISTRIBUTION STATEMENT A; Approved for public release; distribution is unlimited.

A-A-2519

Regulatory requirements. In accordance with the section 23.403 of the Federal Acquisition Regulations, the Government's policy is to acquire items composed of the highest percentage of recovered materials practicable, consistent with maintaining a satisfactory level of competition without adversely affecting performance requirements or exposing suppliers' employees to undue hazards from the recovered materials.

Preservation, packaging, packing, labeling, and marking. The preservation, packaging, packing, labeling, and marking shall be as specified in the contract or order. (For use by GSA; optional for other agencies) DoD may use Commercial Packaging, Standard ASTM D3951.

Notes:

Copies of ANSI Standards can be obtained from American National Standards Institute, Incorporated, 1430 Broadway, New York, NY 10018.  
ASTM standards are available from the American Society for Testing and Materials, 1916 Race Street, Philadelphia, Pennsylvania 19103.  
Copies of Military Standards are available from the Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

MILITARY INTERESTS

PREPARING ACTIVITY:

Military Coordinating Activity:

GSA-FSS

Army - GL

Custodians:

Army - GL  
Air Force - 99

Review Activities:

Air Force - 84

User Activities:

Army - AR, ME  
Navy - MC