AMERICAN NATIONAL STANDARD

Spade Drill Blades and Spade Drill Holders

ANSI B94.49 - 1975

REAFFIRMED 2005

FOR CURRENT COMMITTEE PERSONNEL
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SECRETARIAT
THE AMERICAN SOCIETY OF MECHANICAL ENGINEERS

PUBLISHED BY
THE AMERICAN SOCIETY OF MECHANICAL ENGINEERS

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FOREWORD

Flat type drills have been used to produce holes since the dawn of recorded history. In recent times a flat drill commonly called a spade drill, has been used for producing larger size holes. Generally above 26mm diameter.

The type of spade drill presently in use was first introduced commercially in 1945 and was called a "Z" type. In 1947 a three hole blade, called "X" type, and a single bolt hole, called "Y" type, spade drills were introduced. During 1948 a second concern introduced a two bolt hole design along with a single bolt hole design that was not completely compatible with the other single hole blade.

This situation did not create a problem as long as there were very few producers of spade drills. During the next two decades the use of spade drills increased along with the number of suppliers. A Department of Commerce report in 1965 stated that there were 42 suppliers of spade drills. There was much confusion among users regarding interchangeability between the different types and between the same types of spade drill blades and holders from the various suppliers.

Technical Committee 18 was established during the 1970 Annual Meeting of the American National Standards Institute Committee B94 to develop an American Standard for Spade Drill Blades and Spade Drill Holders. The first meeting of TC-18 was held in April 1971. Because the two hole, three hole, "Z", and other types of spade drills were not universally used it was decided that only the single bolt hole spade drill blade and holder would be considered for this standard.

The draft of the completed standard for Spade Drill Blades and Spade Drill Holders was submitted to the Secretariat, The American Society of Mechanical Engineers, for review in June 1974.

This document was adopted as an American National Standard on September 10, 1975.