

ISO 6149-1 Straight Thread Port Counterboring Tools — Small Spotface

ISO 6149-1 female straight thread port counterboring tools are available with small spotface for M8 to M48 port sizes. Counterbores are 4-fluted*, carbide-tipped.

Shank Dia. (in.)	Shank Length (in.)	Overall Length (in.)	Recommended Pilot Drill or Bore Size (in.)	Use with Thread Size	Part No.
1/2	2	4 1/8	0.272	M8x1*	R1449B
1/2	2	4 1/8	0.348	M10x1*	R1450B
1/2	2	4 1/8	0.406	M12x1.5	R 1451B-S
1/2	2	4 1/8	0.484	M14x1.5	R 1452B-S
1/2	2	4 1/8	0.563	M16x1.5	R 1453B-S
1/2	2	4 1/8	0.641	M18x1.5	R 1454B-S
1/2	2	4 1/8	0.797	M22x1.5	R 1455B-S
3/4	2 1/2	5	0.969	M27x2.....	R 1456B-S
3/4	2 1/2	5	1.210	M33x2.....	R 1457B-S
3/4	2 1/2	5	1.565	M42x2.....	R 1458B-S
3/4	2 1/2	5	1.801	M48x2	R1459B

* M8 and M10 are 3-fluted



Fig. S89 — ISO 6149-1 Straight Thread Port Counterboring Tool — Small Spotface

ISO 6149-1 Straight Thread Port Counterboring Tools with ID Groove

ISO 6149-1 female straight thread port counterboring tools are available with identification groove for M8 to M48 port sizes. Counterbores are 4-fluted*, carbide-tipped.

Shank Dia. (in.)	Shank Length (in.)	Overall Length (in.)	Recommended Pilot Drill or Bore Size (in.)	Use with Thread Size	Part No.
1/2	2	4 1/8	0.348	M10x1*	R1450A
1/2	2	4 1/8	0.406	M12x1.5	R1451A
1/2	2	4 1/8	0.484	M14x1.5	R1452A
1/2	2	4 1/8	0.563	M16x1.5	R1453A
1/2	2	4 1/8	0.641	M18x1.5	R1454A
1/2	2	4 1/8	0.797	M22x1.5	R1455A
3/4	2 1/2	5	0.969	M27x2.....	R1456A
3/4	2 1/2	5	1.210	M33x2.....	R1457A

* M10 are 3-fluted



Fig. S90 — ISO 6149-1 Straight Thread Port Counterboring Tool with ID Groove

* See [Appendix](#) for recommended use of port tools.

Dimensions and pressures for reference only, subject to change.