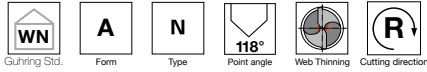


Center drills, 60° angle

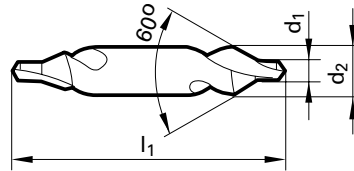
Series no. **280**



Tool material **HSS**

Surface

- | | | | |
|----------|-----------------|---|---------------------------------------------------|
| P | Steel | ● | web thinning $\geq \varnothing 2.000$ |
| M | Stainless steel | ○ | relieved cone |
| K | Cast iron | ● | extra length center drills |
| N | Aluminum | ● | without protective countersink |
| S | Titanium alloys | ○ | for center holes acc. to DIN 332, sheet 1, form A |
| H | Hardened steel | ● | for deep centering positions |
- =Optimal
○=Limited



Speeds and feeds information on pg. 503

| Diameter (d1) | | d2 mm | l1 mm | EDP # |
|---------------|------|----------|----------|---------------|
| inch | mm | | | |
| 0.0394 | 1.00 | 4.00 | 120.00 | 9002800010000 |
| 0.0630 | 1.60 | 5.00 | 120.00 | 9002800016000 |
| 0.0787 | 2.00 | 6.30 | 120.00 | 9002800020000 |
| 0.0984 | 2.50 | 8.00 | 120.00 | 9002800025000 |
| 0.1240 | 3.15 | 10.00 | 120.00 | 9002800031500 |

| Diameter (d1) | | d2 mm | l1 mm | EDP # |
|---------------|----|----------|----------|-------|
| inch | mm | | | |
| | | | | |
| | | | | |
| | | | | |