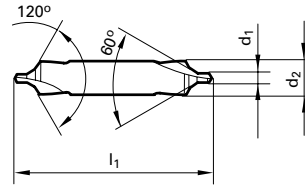


Tool material **HSS**
Surface

Center Drills

- | | | | |
|----------|-----------------|---|---|
| P | Steel | ● | web thinning $\geq \varnothing 2.000$
• relieved cone
• for center holes acc. to DIN 332 sheet 1 (issue 09.1960x retracted), Form B
• with protective 120° countersink |
| M | Stainless steel | ○ | |
| K | Cast iron | ● | |
| N | Aluminum | ● | |
| S | Titanium alloys | ○ | |
| H | Hardened steel | | |
- =Optimal
○=Limited



Speeds and feeds information on pg. 505

Diameter (d1)		d2 mm	l1 mm	EDP #
inch	mm			
0.0394	1.00	6.30	40.00	9002850010000
0.0630	1.60	8.00	50.00	9002850016000
0.0787	2.00	10.00	56.00	9002850020000
0.0984	2.50	11.20	63.00	9002850025000
0.1240	3.15	14.00	71.00	9002850031500
0.1575	4.00	16.00	80.00	9002850040000
0.1969	5.00	20.00	90.00	9002850050000
0.2480	6.30	25.00	100.00	9002850063000

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