

Tool material

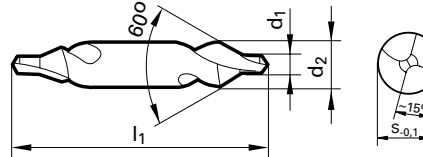
**HSS**

Surface



Center Drills

- |          |                 |   |   |
|----------|-----------------|---|---|
| <b>P</b> | Steel           | ● | web thinning $\geq \varnothing 2.000$<br>• relieved cone<br>• without protective countersink<br>• for center holes acc. to DIN 332 sheet 1 (issue 09.1960x retracted), Form A |
| <b>M</b> | Stainless steel | ○ |   |
| <b>K</b> | Cast iron       | ● |   |
| <b>N</b> | Aluminum        | ● |   |
| <b>S</b> | Titanium alloys | ○ |   |
| <b>H</b> | Hardened steel  |   |   |
- =Optimal  
○=Limited



Speeds and feeds information on pg. 506

| Diameter (d1) |       | d2<br>mm | l1<br>mm | S     | EDP #                |
|---------------|-------|----------|----------|-------|----------------------|
| inch          | mm    |          |          |       |                      |
| 0.0984        | 2.50  | 8.00     | 50.00    | 4.20  | <b>9002870025000</b> |
| 0.1240        | 3.15  | 10.00    | 56.00    | 5.35  | <b>9002870031500</b> |
| 0.1575        | 4.00  | 12.50    | 63.00    | 6.85  | <b>9002870040000</b> |
| 0.1969        | 5.00  | 16.00    | 71.00    | 8.40  | <b>9002870050000</b> |
| 0.2480        | 6.30  | 20.00    | 80.00    | 10.65 | <b>9002870063000</b> |
| 0.3150        | 8.00  | 25.00    | 100.00   | 13.65 | <b>9002870080000</b> |
| 0.3937        | 10.00 | 31.50    | 125.00   | 17.40 | <b>9002870100000</b> |
| 0.0630        | 1.60  | 5.00     | 40.00    | 25.00 | <b>9002870016000</b> |
| 0.0787        | 2.00  | 6.30     | 45.00    | 31.50 | <b>9002870020000</b> |

| Diameter (d1) |    | d2<br>mm | l1<br>mm | S | EDP # |
|---------------|----|----------|----------|---|-------|
| inch          | mm |          |          |   |       |
|               |    |          |          |   |       |
|               |    |          |          |   |       |
|               |    |          |          |   |       |
|               |    |          |          |   |       |
|               |    |          |          |   |       |