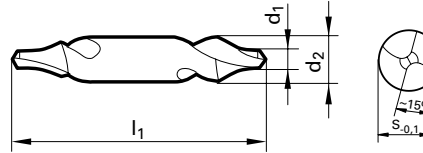


Tool material **HSS**
Surface

Center Drills

- | | | | |
|----------|-----------------|---|--|
| P | Steel | ● | web thinning $\geq \varnothing 2.000$
• relieved cone
• correct positioning between lathe centers
• for center holes to DIN 332, sheet 1 (issue 09.1960x withdrawn), form R |
| M | Stainless steel | ○ | |
| K | Cast iron | ● | |
| N | Aluminum | ● | |
| S | Titanium alloys | ○ | |
| H | Hardened steel | | |
- =Optimal
○=Limited



Speeds and feeds information on pg. 506

Diameter (d1)		d2 mm	l1 mm	S	EDP #
inch	mm				
0.0984	2.50	8.00	50.00	4.20	9002880016000
0.1240	3.15	10.00	56.00	5.35	9002880020000
0.1575	4.00	12.50	63.00	6.85	9002880025000
0.1969	5.00	16.00	71.00	8.40	9002880031500
0.2480	6.30	20.00	80.00	10.65	9002880040000
0.3150	8.00	25.00	100.00	13.65	9002880050000
0.3937	10.00	31.50	125.00	17.40	9002880063000
0.0630	1.60	5.00	40.00	25.00	9002880080000

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