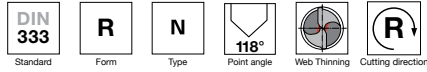


# Center drills, 60° angle

Series no.

**583**



Tool material

**HSS**

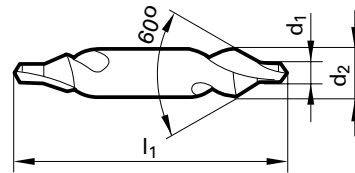
Surface



Center Drills

<b>P</b>	Steel	●	web thinning $\geq \varnothing 2.000$
<b>M</b>	Stainless steel	○	relieved cone
<b>K</b>	Cast iron	●	correct positioning between lathe centers
<b>N</b>	Aluminum	●	for center holes acc. to DIN 332 part 1, form R • $d_1 \leq 0.8 \text{ mm}$ : not double ended
<b>S</b>	Titanium alloys	○	
<b>H</b>	Hardened steel		

●=Optimal  
○=Limited



Speeds and feeds information on pg. 525

Diameter (d1)		d2 mm	l1 mm	EDP #
inch	mm			
0.0197*	0.50*	3.15	25.00	9005830005000
0.0315*	0.80*	3.15	25.00	9005830008000
0.0394	1.00	3.15	31.50	9005830010000
0.0492	1.25	3.15	31.50	9005830012500
0.0630	1.60	4.00	35.50	9005830016000
0.0787	2.00	5.00	40.00	9005830020000
0.0984	2.50	6.30	45.00	9005830025000
0.1240	3.15	8.00	50.00	9005830031500
0.1575	4.00	10.00	56.00	9005830040000

Diameter (d1)		d2 mm	l1 mm	EDP #
inch	mm			
0.1969	5.00	12.50	63.00	9005830050000
0.2480	6.30	16.00	71.00	9005830063000
0.3150	8.00	20.00	80.00	9005830080000