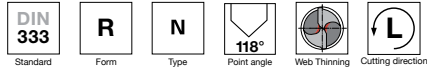


Center drills, 60° angle

Series no.

584



Tool material

HSS

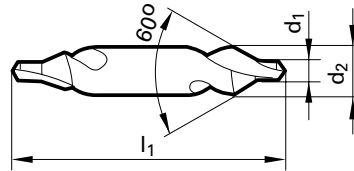
Surface



Center Drills

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

●=Optimal
○=Limited



Speeds and feeds information on pg. 505

Diameter (d1)		d2 mm	l1 mm	EDP #
inch	mm			
0.0315*	0.80*	3.15	25.00	9005840008000
0.0394	1.00	3.15	31.50	9005840010000
0.0492	1.25	3.15	31.50	9005840012500
0.0630	1.60	4.00	35.50	9005840016000
0.0787	2.00	5.00	40.00	9005840020000
0.0984	2.50	6.30	45.00	9005840025000
0.1240	3.15	8.00	50.00	9005840031500
0.1575	4.00	10.00	56.00	9005840040000
0.1969	5.00	12.50	63.00	9005840050000

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