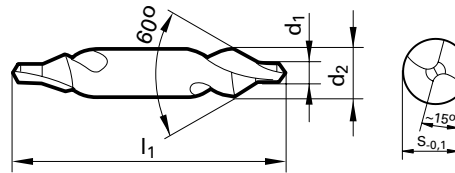


Tool material **HSS**
Surface

- | | | | |
|----------|-----------------|---|---|
| P | Steel | ● | web thinning $\geq \varnothing 2.000$ |
| M | Stainless steel | ○ | relieved cone |
| K | Cast iron | ● | for center holes to DIN 332, part 1, form A |
| N | Aluminum | ● | without protective countersink |
| S | Titanium alloys | ○ | |
| H | Hardened steel | | |
- =Optimal
○=Limited



Speeds and feeds information on pg. 527

Diameter (d1)		d2 mm	l1 mm	S	EDP #
inch	mm				
0.0630	1.60	4.00	35.50	3.25	9005870016000
0.0787	2.00	5.00	40.00	4.20	9005870020000
0.0984	2.50	6.30	45.00	5.35	9005870025000
0.1240	3.15	8.00	50.00	6.95	9005870031500
0.1575	4.00	10.00	56.00	8.40	9005870040000
0.1969	5.00	12.50	63.00	10.95	9005870050000
0.2480	6.30	16.00	71.00	14.00	9005870063000
0.3150	8.00	20.00	80.00	17.90	9005870080000
0.3937	10.00	25.00	100.00	22.50	9005870100000

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

Center Drills