

Tool material

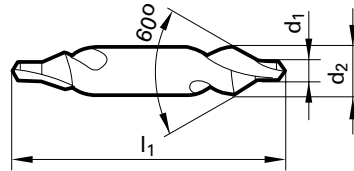
HSS

Surface



| | | | |
|----------|-----------------|---|---|
| P | Steel | ● | web thinning $\geq \varnothing 2.000$ |
| M | Stainless steel | ○ | relieved cone |
| K | Cast iron | ● | increased wear resistance |
| N | Aluminum | ● | correct positioning between lathe centers |
| S | Titanium alloys | ○ | for center holes acc. to DIN 332 part 1, form R |
| H | Hardened steel | | $d1 \leq 0.8 \text{ mm}$: not double ended |

●=Optimal
○=Limited



Speeds and feeds information on pg. 532

| Diameter (d1) | | d2 mm | l1 mm | EDP # |
|---------------|-------|----------|----------|---------------|
| inch | mm | | | |
| 0.0197* | 0.50* | 3.15 | 25.00 | 9006140005000 |
| 0.0315* | 0.80* | 3.15 | 25.00 | 9006140008000 |
| 0.0394 | 1.00 | 3.15 | 31.50 | 9006140010000 |
| 0.0492 | 1.25 | 3.15 | 31.50 | 9006140012500 |
| 0.0630 | 1.60 | 4.00 | 35.50 | 9006140016000 |
| 0.0787 | 2.00 | 5.00 | 40.00 | 9006140020000 |
| 0.0984 | 2.50 | 6.30 | 45.00 | 9006140025000 |
| 0.1240 | 3.15 | 8.00 | 50.00 | 9006140031500 |
| 0.1575 | 4.00 | 10.00 | 56.00 | 9006140040000 |

| Diameter (d1) | | d2 mm | l1 mm | EDP # |
|---------------|-------|----------|----------|---------------|
| inch | mm | | | |
| 0.1969 | 5.00 | 12.50 | 63.00 | 9006140050000 |
| 0.2480 | 6.30 | 16.00 | 71.00 | 9006140063000 |
| 0.3150 | 8.00 | 20.00 | 80.00 | 9006140080000 |
| 0.3937 | 10.00 | 25.00 | 100.00 | 9005810100000 |