

# SPOTTING & CENTERING D23 DRILLS

For general purpose drilling applications

## 2 Helical Flutes





For spotting and centering

### D23

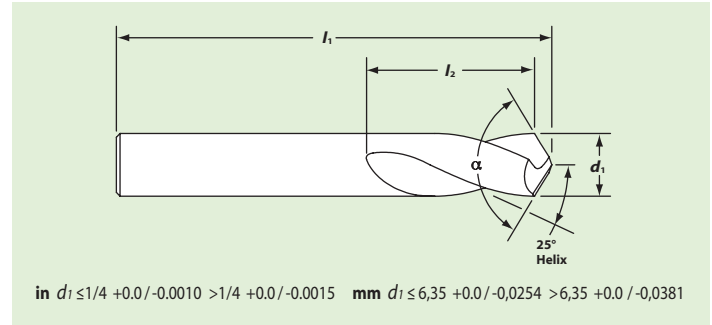
Solid carbide



- Used to create true and accurate starting locations
- Spotting drills do not have body clearance
- Available with 90° or 120° point angle

	Carbon & tool steels $\leq 48$ HRC	✓
	Stainless steels	✓
	Cast irons	✓
	Aluminum and non-ferrous	✓

✓ Good ✓✓ Very Good



Spot drills have a narrow chisel edge and a small web to assure accurate starting locations. Spot drills are used to improve the accuracy of secondary drill operations but can be used as a chamfering tool if the spot drill diameter is larger than the final hole size. Spot drills are not designed to drill past the depth of the point angle and have no land or body clearance.

#### Inch • Metric

	$d_1$		$I_2$	$I_1$	$\alpha = 90^\circ$	List Price	$\alpha = 120^\circ$	List Price	
	Cutter Dia	Dec							Flute Length
	Inch	Metric	Equiv						
		3	.118 1	10	50	40680	12.29	40829	12.29
1/8			.1250	9/16	1-1/2	40201	12.29	40789	12.29
3/16			.1875	3/4	2	40204	14.02	40790	14.02
		5	.1969	19	63	40681	15.49	40830	15.49
		6	.2362	25	63	40682	20.84	40831	20.84
		6	.2362	25	152	40683	29.03	40832	29.03
1/4			.2500	1	2-1/2	40207	20.84	40791	20.84
1/4			.2500	1	6	40210	29.03	40792	29.03
5/16			.3125	1	2-1/2	40213	26.99	40793	26.99
5/16			.3125	1	6	40216	39.53	40794	39.53
		8	.3150	25	63	40684	26.99	40833	26.99
		8	.3150	25	152	40685	39.53	40834	39.53
3/8			.3750	1	2-1/2	40219	31.66	40795	31.66
3/8			.3750	1	6	40222	51.98	40796	51.98
		10	.3937	25	70	40686	34.44	40835	34.44
		10	.3937	25	152	40687	55.76	40836	55.76
		12	.4724	31	76	40688	53.60	40837	53.60
		12	.4724	31	152	40689	82.69	40838	82.69
1/2			.5000	1-1/2	3	40225	53.60	40797	53.60
1/2			.5000	1-1/2	6	40228	82.69	40798	82.69
5/8			.6250	1-1/2	6	40231	140.75	40799	140.75
		16	.6299	38	152	40690	140.75	40839	140.75
3/4			.7500	1-1/2	6	40234	207.64	40800	207.64
		20	.7874	38	152	40691	207.64	40840	207.64