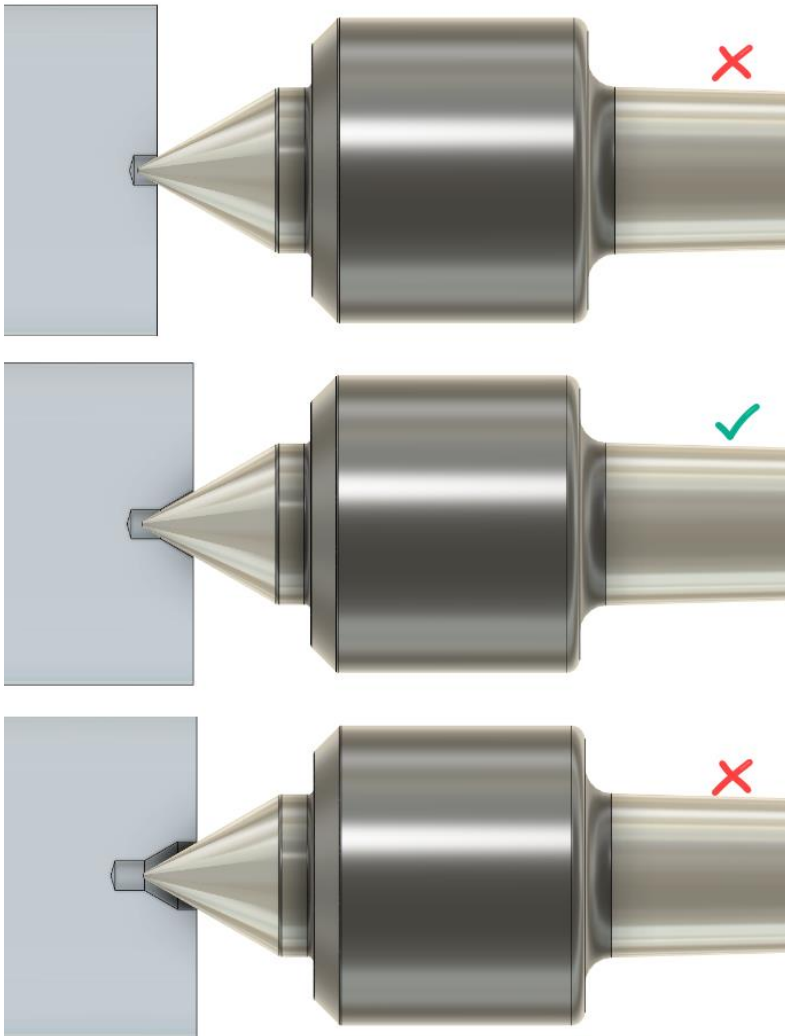


Technical Details

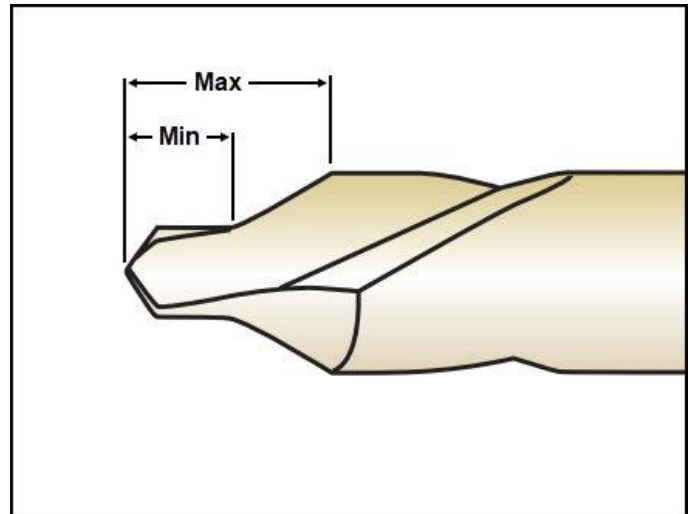


CENTER DRILL DEPTH



Incorrect drill depths being too shallow or too deep will lead to improper work holding. Which may cause imbalance in the work piece, incorrect dimensions or poor finishes.

Use the table below to find the recommended depth range of your center drill.



Haas Part #	Center Drill Size	[D2] Shank Diameter	[D1] Drill Diameter	Maximum Drill Depth	Minimum Drill Depth
03-0420	#1	1/8" \ 0.125 in	3/64" \ 0.0469 in	0.115 in	0.083 in
03-0421	#2	3/16" \ 0.1875 in	1/16" \ 0.0625 in	0.171 in	0.098 in
03-0422	#3	1/4" \ 0.25 in	3/32" \ 0.0938 in	0.245 in	0.145 in
03-0423	#4	5/16" \ 0.3125 in	1/8" \ 0.125 in	0.303 in	0.176 in
03-0424	#5	7/16" \ 0.4375 in	3/16" \ 0.1875 in	0.451 in	0.270 in
03-0425	#6	1/2" \ 0.5 in	7/32" \ 0.2188 in	0.510 in	0.301 in