

**Garant****HSS-E centre drill for tapping holes A, uncoated, for threads: M3****Order data**

Order number	111310 M3
GTIN	4062406101473
Item class	11A

**Description****Version:**

Stepped centre drill for tapping holes to Form A.

For **combined production** of centring, entry chamfer and tapping hole **all in a single operation**.

Nominal  $\varnothing D_c$ : 2.5 mm

$\varnothing D_1$  1st step with chamfer  $\pm 0.05$ : 3.2 mm

$\varnothing D_2$  2nd step: 6 mm

Step height  $L_1$  1st step: 8 mm

Step height  $L_2$  2nd step: 9 mm

for workpiece  $\varnothing$ : 30 – 40 mm

**Technical description**

Nominal $\varnothing D_c$	2.5 mm
Overall length L	55 mm
Shank $\varnothing D_s$	6 mm
Number of cutting edges Z	2
Feed f in steel $< 900 \text{ N/mm}^2$	0.03 mm/rev.
for workpiece $\varnothing$	30 – 40 mm
Step height $L_2$ 2nd step	9 mm
Step height $L_1$ 1st step	8 mm
$\varnothing D_2$ 2nd step	6 mm

Ø D <sub>1</sub> 1st step with chamfer ±0.05	3.2 mm
Coating	uncoated
Tool material	HSS E
Standard	DIN 332/2
Type	A
Tolerance nominal Ø	0 / -0.05
Countersink angle	60°
Cutting direction	right-hand
Shank	Parallel shank to h7
Through-coolant	no
Colour ring	without
Type of product	convex

### User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	65 m/min	N
Aluminium (short chipping)	suitable	65 m/min	N
Alu > 10% Si	suitable	60 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	28 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	9 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	7 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	7 m/min	M
GG(G)	suitable	28 m/min	K
CuZn	suitable	35 m/min	N
Oil	suitable		
wet maximum	suitable		

