

Garant**HSS-E centre drill for tapping holes A with flat, uncoated, for threads: M12****Order data**

Order number	111313 M12
GTIN	4062406101992
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**.

With additional flats on the shank.

Nominal $\varnothing D_c$: 10.2 mm

$\varnothing D_1$ 1st step with chamfer ± 0.05 : 13 mm

$\varnothing D_2$ 2nd step: 20 mm

Step height L_1 1st step: 28 mm

Step height L_2 2nd step: 34.5 mm

for workpiece \varnothing : 210 – 250 mm

Technical description

Number of cutting edges Z	2
Feed f in steel < 900 N/mm ²	0.2 mm/rev.
Shank $\varnothing D_s$	20 mm
s – 0.1	18.45 mm
Overall length L	105 mm
Nominal $\varnothing D_c$	10.2 mm
for workpiece \varnothing	210 – 250 mm
Step height L_2 2nd step	34.5 mm

Data sheet

Step height L ₁ 1st step	28 mm
Ø D ₂ 2nd step	20 mm
Ø D ₁ 1st step with chamfer ±0.05	13 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 _c	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 ²	suitable	28 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	30 m/min	P
Steel < 1100 N/mm ²	suitable	9 m/min	P
Steel < 1400 N/mm ²	suitable	7 m/min	P
INOX < 900 N/mm ²	suitable	7 m/min	M
GG(G)	suitable	28 m/min	K
CuZn	suitable	35 m/min	N

Data sheet

Oil	suitable
wet maximum	suitable