

**Garant****HSS-E centre drill for tapping holes A with flat, uncoated, for threads: M16****Order data**

Order number	111313 M16
GTIN	4062406102005
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  $\varnothing D_c$ : 14 mm

$\varnothing D_1$  1st step with chamfer  $\pm 0.05$ : 17 mm

$\varnothing D_2$  2nd step: 25 mm

Step height  $L_1$  1st step: 33 mm

Step height  $L_2$  2nd step: 41.3 mm

for workpiece  $\varnothing$ : 250 – 290 mm

**Technical description**

Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.25 mm/rev.
Shank $\varnothing D_s$	25 mm
Number of cutting edges $Z$	2
Nominal $\varnothing D_c$	14 mm
Overall length $L$	132 mm
$s - 0.1$	23.4 mm
for workpiece $\varnothing$	250 – 290 mm
Step height $L_2$ 2nd step	41.3 mm

## Data sheet

Step height L <sub>1</sub> 1st step	33 mm
Ø D <sub>2</sub> 2nd step	25 mm
Ø D <sub>1</sub> 1st step with chamfer ±0.05	17 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

## Data sheet

Oil	suitable
wet maximum	suitable