Garant
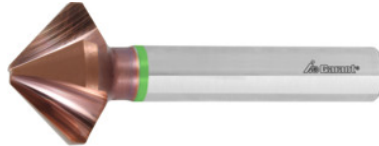
High-precision countersink with unequal spacing and 3 drive flats 90°, TiAlN, External ∅ Dc: 12,4mm

Order data

Order number	150132 12,4
GTIN	4045197741967
Item class	11M

Description

Version:

All countersinks have 3 cutting edges. Special geometry with extremely unequal spacing and matching cutting edge preparation. Radially relief ground. Flutes ground from solid. Newly developed **special TiAlN coating** for long service life.

High-precision countersink, produced with tight manufacturing tolerances similar to DIN 335-C. Three **drive flats on the shank** for use in a 3-jaw chuck.

Advantage:

Very smooth cutting throughout the entire countersinking operation. Chatter-free running for perfect results and **optimum tool service life.**

Application:

High-precision countersinks for production of exactly round 90° countersunk surfaces.

Technical description

Feed f in steel < 500 N/mm^2	0.13 mm/rev.
smallest countersink ∅ for holes from	2.8 mm
External ∅	12.4 mm
for countersunk screws DIN 7991	M6
Shank tolerance	h9
Shank ∅ D_s	8 mm

Overall length L	56 mm
Number of cutting edges Z	3
Coating	TiAlN
Countersink tip angle	90 degrees
Tool material	HSS
Spacing of the countersink cutting edges	unequal spacing
Standard	DIN 335 C
Shank	Shank with h9 and three drive flats
Through-coolant	no
Colour ring	green
Type of product	Stepped drill and countersink

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	75 m/min	N
Aluminium (short chipping)	suitable	75 m/min	N
Alu > 10% Si	suitable	50 m/min	N
Steel < 500 N/mm²	suitable	65 m/min	P
Steel < 750 N/mm²	suitable	50 m/min	P
Steel < 900 N/mm²	suitable	30 m/min	P
Steel < 1100 N/mm²	suitable	18 m/min	P
Steel < 1400 N/mm²	suitable	8 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	8 m/min	H
INOX < 900 N/mm²	suitable	16 m/min	M
INOX > 900 N/mm²	suitable	10 m/min	M
Ti > 850 N/mm²	suitable only under restricted conditions	12 m/min	S
GG(G)	suitable	25 m/min	K

CuZn	suitable	60 m/min	N
Graphite, GRP, CRP	suitable only under restricted conditions		
Uni	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		