



Modular counterbore, Size / counterbore Ø: 1/22mm



Order data

Order number	156730 1/22
GTIN	4033591012493
Item class	16C

Description

Version:

Very good machining and ideal chip evacuation due to spiral flutes. **Easy to regrind.** Counterbore is protected against turning in the holder.

Application:

For counterboring screw heads to DIN or **by means of an appropriate combination of counterbore and pilot to produce stepped holes or non-standard counterbores.**

Note:

Counterbores available on request also in HSS with optional TIN coating and brazed-on carbide tips with form "T" ISO inserts.

Technical description

Counterbore Ø	22 mm
Number of cutting edges Z	3
Shank Ø	14 mm
Cutter length	22 mm
Countersink angle	180 degrees
Coating	uncoated
Tool material	HSS
Standard	Manufacturer's standard

Through-coolant	yes
Type of product	Cutter insert for countersinking

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	40 m/min	N
Aluminium (short chipping)	suitable	60 m/min	N
Alu > 10% Si	suitable only under restricted conditions	20 m/min	N
Steel < 500 N/mm ²	suitable	25 m/min	P
Steel < 750 N/mm ²	suitable	20 m/min	P
Steel < 900 N/mm ²	suitable	15 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	10 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	5 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	5 m/min	M
wet maximum	suitable		