



## Countersink 90°, TiN, External Ø Dc: 25mm



### Order data

Order number	150180 25
GTIN	4045197086006
Item class	12M

### Description

#### Version:

**All countersinks have 3 cutting edges**, radially relieved.

Flutes are ground from solid.

Economy version, improved performance due to coating.

#### Application:

High precision countersinks for chatter-free countersinking.

### Technical description

smallest countersink Ø for holes from	3.8 mm
External Ø	25 mm
for countersunk screws DIN 7991	M12
Shank tolerance	h9
Feed f in steel < 500 N/mm <sup>2</sup>	0.2 mm/rev.
Shank Ø D <sub>s</sub>	10 mm
Overall length L	67 mm
Number of cutting edges Z	3
Coating	TiN
Countersink tip angle	90 degrees
Tool material	HSS

Standard	DIN 335 C
Shank	Plain shank with h9
Through-coolant	no
Colour ring	green
Type of product	Stepped drill and countersink

### User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable	38 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	34 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	32 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	32 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	9 m/min	M
CuZn	suitable	80 m/min	N
Uni	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		