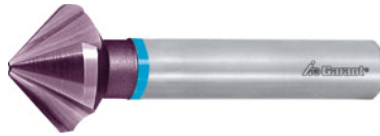


Garant
High-precision countersink 90°, TiCN, External Ø Dc: 15mm

Order data

Order number	150379 15
GTIN	4045197444783
Item class	11M

Description
Version:

All countersinks have 3 cutting edges, radially relieved.

Flutes are ground from solid.

High-precision countersink, produced with tight manufacturing tolerances similar to DIN 335-C.

Technical description

External Ø	15 mm
Feed f in stainless steel < 900 N/mm ²	0.12 mm/rev.
Pre-drill Ø	3.2 mm
for countersunk screws ISO 2009, 2010, 7046, 7047	M8
smallest countersink Ø for holes from	3.2 mm
Shank tolerance	h9
Shank Ø D _s	10 mm
Overall length L	60 mm
Number of cutting edges Z	3
Coating	TiCN
Countersink tip angle	90 degrees
Tool material	HSS E

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

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	38 m/min	N
Alu > 10% Si	suitable only under restricted conditions	30 m/min	N
Steel < 500 N/mm ²	suitable only under restricted conditions	34 m/min	P
Steel < 750 N/mm ²	suitable	32 m/min	P
Steel < 900 N/mm ²	suitable	32 m/min	P
Steel < 1100 N/mm ²	suitable	10 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	5 m/min	P
INOX < 900 N/mm ²	suitable	9 m/min	M
INOX > 900 N/mm ²	suitable	9 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	8 m/min	S
GG(G)	suitable only under restricted conditions	14 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
wet maximum	suitable		
wet minimum	suitable		
dry	suitable only under restricted conditions		

