



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



### Order data

|              |               |
|--------------|---------------|
| Order number | 150395 25     |
| GTIN         | 4045197086907 |
| Item class   | 12M           |

### Description

#### Version:

Countersinks radially relief ground. Chip flutes are ground from solid up to size 31. Chip angle varies with the countersink Ø for optimum chip formation. Countersink point and circumference are relief ground and cut easily.

Economy countersink version.

#### Note:

For countersink bits with shank 6.3 mm (1/4 inch) see Group 67.

For suitable reducing adapters for tools with MT shanks see **No. 343000-343530**.

### Technical description

|   |             |
|---|-------------|
| External Ø                              | 25 mm       |
| smallest countersink Ø for holes from   | 3.8 mm      |
| for countersunk screws DIN 7991         | M12         |
| Feed f in steel < 500 N/mm <sup>2</sup> | 0.2 mm/rev. |
| Pre-drill Ø                             | 3.8 mm      |
| Overall length L                        | 106 mm      |
| Morse taper MT                          | 2           |
| Number of cutting edges Z               | 3           |
| Coating                                 | uncoated    |
| Countersink tip angle                   | 90 degrees  |

|                 |                               |
|-----------------|-------------------------------|
| Tool material   | HSS                           |
| Standard        | DIN 335 D                     |
| Shank           | Morse taper                   |
| Through-coolant | no                            |
| Colour ring     | without                       |
| Type of product | Stepped drill and countersink |

### User data

|                               | Suitability                               | V <sub>c</sub> | ISO code |
|-------------------------------|---|----------------|----------|
| Alu plastics                  | suitable                                  | 70 m/min       | N        |
| Aluminium (short chipping)    | suitable                                  | 33 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup> | suitable                                  | 28 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable                                  | 27 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup> | suitable only under restricted conditions | 27 m/min       | P        |
| wet maximum                   | suitable                                  |                |          |
| dry                           | suitable only under restricted conditions |                |          |