

Garant
Countersink Form C 60°, TiN, External Ø Dc: 25mm

Order data

Order number	150840 25
GTIN	4045197087324
Item class	11M

Description
Version:

The chip flutes are ground from solid. Countersink point and circumference are relief ground and cut easily. This results in easy and **chatter-free cutting** for deep countersinking, as well as for deburring or countersinking.

Application:

For chatter-free countersinking and deburring.

Especially suitable for chamfering tapped holes and for countersinking in jig and tool making.

Technical description

smallest countersink Ø for holes from	6.3 mm
Feed f in steel < 500 N/mm ²	0.2 mm/rev.
External Ø	25 mm
Shank Ø D _s	10 mm
Overall length L	71 mm
Number of cutting edges Z	3
Coating	TiN
Countersink tip angle	60 degrees
Tool material	HSS

Standard	DIN 334
Shank	Plain shank with h9
Through-coolant	no
Colour ring	green
Type of product	Stepped drill and countersink

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	85 m/min	N
Aluminium (short chipping)	suitable	40 m/min	N
Alu > 10% Si	suitable only under restricted conditions	25 m/min	N
Steel < 500 N/mm ²	suitable	34 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	32 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	32 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	9 m/min	M
Uni	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		