

Garant**Countersink, form D 60°, uncoated, Ø DC: 80mm****Order data**

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| Order number | 150860 80 |
| GTIN | 4045197087454 |
| Item class | 11M |

Description**Version:**

The chip flutes are ground from solid up to size 31.5. 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.

Note:

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

Technical description

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|---|--------------|
| External Ø | 80 mm |
| Feed f in steel < 500 N/mm ² | 0.35 mm/rev. |
| smallest countersink Ø for holes from | 25 mm |
| Overall length L | 200 mm |
| Morse taper MT | 4 |
| Number of cutting edges Z | 3 |
| Coating | uncoated |
| Countersink tip angle | 60 degrees |

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|-----------------|-------------------------------|
| Tool material | HSS |
| Standard | DIN 334 |
| Shank | Morse taper |
| Through-coolant | no |
| Colour ring | without |
| Type of product | Stepped drill and countersink |

User data

| | Suitability | V _c | ISO code |
|-------------------------------|---|----------------|----------|
| Aluminium (short chipping) | suitable | 33 m/min | N |
| Steel < 500 N/mm ² | suitable | 28 m/min | P |
| Steel < 750 N/mm ² | suitable | 27 m/min | P |
| CuZn | suitable | 65 m/min | N |
| wet maximum | suitable | | |
| dry | suitable only under restricted conditions | | |