

**Garant**
**Countersink solid carbide 60°, uncoated, External Ø Dc: 25mm**

**Order data**

Order number	150855 25
GTIN	4045197087386
Item class	11M

**Description**
**Version:**

Very **sturdy design, special geometry** for **heavy-duty use**, with **chatter-free countersinking and deburring**.

**Tool material:**

Size 8 – of solid carbide.

Size. 10 – 25 – solid carbide head with brazed shank. Design similar to DIN 344-C.

**Technical description**

External Ø	25 mm
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.2 mm/rev.
Shank tolerance	h9
smallest countersink Ø for holes from	6.3 mm
Shank Ø D <sub>s</sub>	10 mm
Overall length L	71 mm
Number of cutting edges Z	3
Coating	uncoated
Countersink tip angle	60 degrees
Tool material	Solid carbide
Standard	Manufacturer's standard

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
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	65 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	18 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	8 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	8 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	16 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	10 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	16 m/min	S
GG(G)	suitable only under restricted conditions	25 m/min	K
wet maximum	suitable		