

Garant

DIN counterbore for tapping drill holes, uncoated, Counterbore \varnothing D1 x pin \varnothing D2: 15X6,8mm



Order data

Order number	156220 15X6,8
GTIN	4045197087942
Item class	11M

Description

Version:

Three edged, spiral fluted counterbore with fixed pilot for tapping drill holes.

Application:

For counterboring socket head screws DIN 912, 6912, 7984 and slotted cheese head screws ISO 1207 (DIN 84).

The pilot diameter matches the tapping hole diameter.

Technical description

Counterbore \varnothing	15 mm
Pin \varnothing	6,8 mm
Pre-drill \varnothing	6.8 mm
for screw size	M8
Number of cutting edges Z	3
Feed f in steel < 500 N/mm ²	0.12 mm/rev.
Shank \varnothing D _s	12.5 mm
Overall length L	100 mm
Step height L ₁ 1st step with chamfer	22 mm
Point angle	180 degrees
Coating	uncoated

Tool material	HSS
Standard	DIN 373
Shank	Parallel shank to h9
Through-coolant	no
Type of product	Counterbore

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
Steel < 900 N/mm ²	suitable only under restricted conditions	27 m/min	P
wet maximum	suitable		