

Garant

DIN counterbore for tapping drill holes, uncoated, Counterbore \varnothing D1 x pin \varnothing D2: 18X8,5mm


Order data

Order number	156220 18X8,5
GTIN	4045197087959
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

Pre-drill \varnothing	8.5 mm
Counterbore \varnothing	18 mm
Pin \varnothing	8,5 mm
Number of cutting edges Z	3
Feed f in steel < 500 N/mm ²	0.14 mm/rev.
for screw size	M10
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		