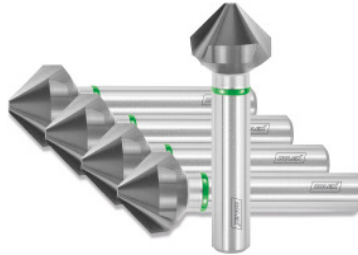




## HOLEX Pro Steel high-precision countersink with unequal spacing 90°, TiAlN, External Ø Dc: 12,4mm



### Order data

Order number	GG1582 12,4
GTIN	4067263134312
Item class	GGN

### Description

#### Version:

Same as No. 150182

All countersinks have 3 cutting edges, radially relieved.

Flutes are ground from solid.

- Exact machining results in manual and machine use.
- Chatter-free running through extremely unequal spacing of the cutting edges for high-quality surfaces.
- Optimum tool life thanks to TiAlN high-performance coating.
- High process reliability due to optimised chip evacuation.
- Attractive cost/benefit ratio.

#### Application:

High-precision countersink for chatter-free 90° countersinking.

### Technical description

External Ø	12.4 mm
Number of cutting edges Z	3
Shank tolerance	h9
for countersunk screws DIN 7991	M6

smallest countersink $\varnothing$ for holes from	2.8 mm
Feed f in steel < 500 N/mm <sup>2</sup>	0.12 mm/rev.
Overall length L	56 mm
Shank $\varnothing$ D <sub>s</sub>	8 mm
Coating	TiAlN
Countersink tip angle	90 degrees
Tool material	HSS
Spacing of the countersink cutting edges	unequal spacing
Standard	DIN 335 C
Shank	Plain shank with h9
Through-coolant	no
Colour ring	green
Series	Pro Steel
Type of product	Stepped drill and countersink

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	75 m/min	N
Aluminium (short chipping)	suitable	70 m/min	N
Steel < 750 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	15 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	8 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	18 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	15 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	12 m/min	S

GG(G)	suitable	20 m/min	K
CuZn	suitable	20 m/min	N
Uni	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		

## Accessories

HOLEX Pro Steel high-precision countersink with unequal spacing 90° External Ø Dc 12,4 mm

150182 12,4