

Garant
Centre drill HSS-E R with flat, TiAlN, Nominal \varnothing DC k12: 1,6mm

Order data

| | |
|--------------|---------------|
| Order number | 111455 1,6 |
| GTIN | 4045197853943 |
| Item class | 11A |

Description
Version:

Ground from solid and relief ground, spiral fluted.
Features of centre drills with radius form R: See No. 111350.

Technical description

| | |
|---|--------------|
| Nominal \varnothing D _c | 1.6 mm |
| for workpiece \varnothing | 10 – 15 mm |
| Number of cutting edges Z | 2 |
| s – 0.1 | 3.25 mm |
| Overall length L | 35.5 mm |
| Shank tolerance | h7 |
| Feed f in steel < 900 N/mm ² | 0.02 mm/rev. |
| Shank \varnothing D _s | 4 mm |
| Coating | TiAlN |
| Tool material | HSS E |
| Standard | DIN 333 |
| Type | R |
| Tolerance nominal \varnothing | k12 |
| Countersink angle with radius | 60 degrees |

| | |
|-------------------|----------------------|
| Cutting direction | right-hand |
| Shank | Parallel shank to h7 |
| Through-coolant | no |
| Colour ring | without |
| Type of product | Centre drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Alu plastics | suitable | 70 m/min | N |
| Aluminium (short chipping) | suitable | 45 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 40 m/min | N |
| Steel < 500 N/mm ² | suitable | 40 m/min | P |
| Steel < 750 N/mm ² | suitable | 30 m/min | P |
| Steel < 900 N/mm ² | suitable | 25 m/min | P |
| Steel < 1100 N/mm ² | suitable | 10 m/min | P |
| Steel < 1400 N/mm ² | suitable | 8 m/min | P |
| INOX < 900 N/mm ² | suitable | 12 m/min | M |
| INOX > 900 N/mm ² | suitable | 8 m/min | M |
| Ti > 850 N/mm ² | suitable | 5 m/min | S |
| GG(G) | suitable | 25 m/min | K |
| CuZn | suitable | 80 m/min | N |
| Oil | suitable | | |
| wet maximum | suitable | | |