

Garant
Centre drill HSS-E R with flat, TiAlN, Nominal \varnothing DC k12: 4mm

Order data

Order number	111455 4
GTIN	4045197853981
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

Shank tolerance	h7
for workpiece \varnothing	40 – 63 mm
s – 0.1	8.4 mm
Shank \varnothing D _s	10 mm
Number of cutting edges Z	2
Nominal \varnothing D _c	4 mm
Feed f in steel < 900 N/mm ²	0.03 mm/rev.
Overall length L	55 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		