

Garant
High-precision countersink with unequal spacing 60°, TiAlN, External Ø Dc: 25mm

Order data

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| Order number | 150815 25 |
| GTIN | 4045197868114 |
| Item class | 11M |

Description
Version:
High-precision 60° countersink with unequal spacing.

Special geometry with extremely unequal spacing and matching cutting edge preparation. Radially relief ground. Flutes ground from solid. Newly developed **special TiAlN coating** for long service life.

Advantage:

Very smooth cutting throughout the entire countersinking operation. Chatter-free running for perfect results and **optimum tool service life**.

Application:

High-precision countersinks for production of **exactly round 60° countersunk surfaces**.

Technical description

| | |
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| smallest countersink Ø for holes from | 6.3 mm |
| Overall length L | 71 mm |
| Number of cutting edges Z | 3 |
| Feed f in steel < 500 N/mm ² | 0.25 mm/rev. |
| External Ø | 25 mm |
| Shank Ø D _s | 10 mm |
| Coating | TiAlN |
| Countersink tip angle | 60 degrees |

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| Tool material | HSS |
| Spacing of the countersink cutting edges | unequal spacing |
| Standard | DIN 334 |
| Shank | Parallel shank to h9 |
| Through-coolant | no |
| Colour ring | green |
| Type of product | Stepped drill and countersink |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Alu plastics | suitable | 75 m/min | N |
| Aluminium (short chipping) | suitable | 75 m/min | N |
| Alu > 10% Si | suitable | 50 m/min | N |
| Steel < 500 N/mm ² | suitable | 65 m/min | P |
| Steel < 750 N/mm ² | suitable | 50 m/min | P |
| Steel < 900 N/mm ² | suitable | 30 m/min | P |
| Steel < 1100 N/mm ² | suitable | 18 m/min | P |
| Steel < 1400 N/mm ² | suitable | 8 m/min | P |
| Steel < 55 HRC | suitable only under restricted conditions | 8 m/min | H |
| INOX < 900 N/mm ² | suitable | 16 m/min | M |
| INOX > 900 N/mm ² | suitable | 10 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 12 m/min | S |
| GG(G) | suitable | 25 m/min | K |
| CuZn | suitable | 60 m/min | N |
| Graphite, GRP, CRP | suitable only under restricted conditions | | |
| Uni | suitable | | |

| | |
|-------------|---|
| wet maximum | suitable |
| dry | suitable only under restricted conditions |