

Garant

High-precision countersink with unequal spacing with 3 drive flats 60°, TiAlN, External Ø Dc: 6,3mm



Order data

Order number	150817 6,3
GTIN	4045197889256
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.

Three **drive flats on the shank** for use in a 3-jaw chuck.

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

Number of cutting edges Z	3
External Ø	6.3 mm
Shank Ø D _s	5 mm
Feed f in steel < 500 N/mm ²	0.1 mm/rev.
Overall length L	45 mm
smallest countersink Ø for holes from	1.6 mm
Coating	TiAlN

Countersink tip angle	60 degrees
Tool material	HSS
Spacing of the countersink cutting edges	unequal spacing
Standard	DIN 334
Shank	Three clamping flats 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