Garant

NC spotting drill HSS-E 142° N, TiAlN, ∅ DC h6: 4mm

Order data

Order number	112170 4
GTIN	4045197959508
Item class	11A

Description

Version:
≥ ∅ 6 mm with **drive flat to DIN 1835-B.**
Precision centred ground point with thin chisel edge - gives easy spot drilling and high accuracy of the centre hole form. Very sturdy due to short flutes.
Application:
Point angle 142° so that the cutting edges of the following drill engage easily.
Note:
Use speed for the actual hole ∅
(not necessarily the speed for the drill outer ∅).

Technical description

Feed f in steel < 900 N/mm^2	0.04 mm/rev.
Shank ∅ D_s	4 mm
Flute length L_c	12 mm
Nominal ∅ D_C	4 mm
Overall length L	100 mm
Shank	DIN 1835 B to h6
Shank tolerance	h6
Coating	TiAlN
Tool material	HSS E
Standard	Manufacturer's standard
Type	N

Tolerance nominal ∅	h6
Point angle	142 degrees
Number of cutting edges Z	2
Through-coolant	no
Colour ring	without
Type of product	Spotting drill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	87 m/min	N
Aluminium (short chipping)	suitable	56 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm²	suitable	50 m/min	P
Steel < 750 N/mm²	suitable	37 m/min	P
Steel < 900 N/mm²	suitable	31 m/min	P
Steel < 1100 N/mm²	suitable	12 m/min	P
Steel < 1400 N/mm²	suitable	10 m/min	P
INOX < 900 N/mm²	suitable	15 m/min	M
INOX > 900 N/mm²	suitable	10 m/min	M
Ti > 850 N/mm²	suitable	6 m/min	S
GG(G)	suitable	31 m/min	K
CuZn	suitable	100 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		