

**Garant****Centre drill HSS A, Diamond, Nominal  $\varnothing$  DC k12: 1mm****Order data**

Order number	111000 1
GTIN	4045197000118
Item class	11A

**Description****Version:**

Ground from solid and relief ground, spiral fluted.

Nominal  $\varnothing$   $D_c$ : 1 mm

for workpiece  $\varnothing$ : 6 – 8 mm

Shank  $\varnothing$   $D_s$ : 3.15 mm

Overall length L: 31.5 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.02 mm/rev.

**Technical description**

Number of cutting edges Z	2
Nominal $\varnothing$ $D_c$	1 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.02 mm/rev.
for workpiece $\varnothing$	6 – 8 mm
Shank tolerance	h7
Shank $\varnothing$ $D_s$	3.15 mm
Overall length L	31.5 mm
Coating	Diamond
Tool material	HSS
Standard	DIN 333
Type	A

Tolerance nominal $\varnothing$	k12
Countersink angle	60°
Cutting direction	right-hand
Shank	Parallel shank to h7
Through-coolant	no
Colour ring	without
Type of product	convex

### User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable	70 m/min	N
Aluminium (short chipping)	suitable	45 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	10 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	8 m/min	P
CuZn	suitable	80 m/min	N
Oil	suitable		
wet maximum	suitable		