

Garant
Solid carbide centre drills A, uncoated, Ø DC k13: 1mm

Order data

Order number	121000 1
GTIN	4045197038326
Item class	11E

Description
Version:

Ground from solid carbide bar. Spiral fluted.

Technical description

Nominal Ø D _c	1 mm
Feed f in steel < 1100 N/mm ²	0.02 mm/rev.
for workpiece Ø	6 – 8 mm
Shank tolerance	h6
Number of cutting edges Z	2
Shank Ø D _s	3.15 mm
Overall length L	31.5 mm
Coating	uncoated
Tool material	Solid carbide
Standard	DIN 333
Type	A
Tolerance nominal Ø	k13
Countersink angle	60 degrees
Cutting direction	right-hand
Shank	Parallel shank to h6

Through-coolant	no
Colour ring	without
Type of product	Centre drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	200 m/min	N
Aluminium (short chipping)	suitable	180 m/min	N
Alu > 10% Si	suitable only under restricted conditions	160 m/min	N
Steel < 500 N/mm ²	suitable	80 m/min	P
Steel < 750 N/mm ²	suitable	75 m/min	P
Steel < 900 N/mm ²	suitable	65 m/min	P
Steel < 1100 N/mm ²	suitable	50 m/min	P
Steel < 1400 N/mm ²	suitable	35 m/min	P
INOX < 900 N/mm ²	suitable	35 m/min	M
INOX > 900 N/mm ²	suitable	30 m/min	M
Ti > 850 N/mm ²	suitable	25 m/min	S
GG(G)	suitable	70 m/min	K
CuZn	suitable	160 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		