



## Centre drill HSS A, uncoated, Nominal $\varnothing$ DC k12: 4mm



### Order data

Order number	111005 4
GTIN	4045197255310
Item class	12A

### Description

#### Version:

Ground from solid and relief ground, spiral fluted.

### Technical description

Nominal $\varnothing$ $D_c$	4 mm
Shank tolerance	h7
Feed $f$ in steel < 900 N/mm <sup>2</sup>	0.03 mm/rev.
Number of cutting edges $Z$	2
for workpiece $\varnothing$	40 – 63 mm
Shank $\varnothing$ $D_s$	10 mm
Overall length $L$	56 mm
Coating	uncoated
Tool material	HSS
Standard	DIN 333
Type	A
Tolerance nominal $\varnothing$	k12
Countersink angle	60 degrees
Cutting direction	right-hand
Shank	Parallel shank to h7

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

## User data

	Suitability	V <sub>c</sub>	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		