

Garant
Centre drill HSS B, uncoated, Nominal \varnothing DC k12: 3,15mm

Order data

Order number	111520 3,15
GTIN	4045197000927
Item class	11A

Description
Version:

Ground from solid and relief-ground.

With additional centre protection (120° countersink angle), spiral fluted.

Technical description

Number of cutting edges Z	2
Nominal \varnothing D _c	3.15 mm
Shank tolerance	h7
Feed f in steel < 900 N/mm ²	0.03 mm/rev.
for workpiece \varnothing	30 – 40 mm
Shank \varnothing D _s	11.2 mm
Overall length L	60 mm
Coating	uncoated
Tool material	HSS
Standard	DIN 333
Type	B
Tolerance nominal \varnothing	k12
Countersink angle	120 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 _c	ISO code
Alu plastics	suitable	70 m/min	N
Aluminium (short chipping)	suitable	45 m/min	N
Steel < 500 N/mm ²	suitable	40 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
Steel < 1100 N/mm ²	suitable	10 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	8 m/min	P
CuZn	suitable	80 m/min	N
Oil	suitable		
wet maximum	suitable		