

**Garant**
**Centre drill HSS R, uncoated, Nominal  $\varnothing$  DC k12: 3,15mm**

**Order data**

Order number	111350 3,15
GTIN	4045197000668
Item class	11A

**Description**
**Version:**

Ground from solid and relief ground, spiral fluted.

Centre drill with radius form R:

- **The radius curve eliminates the sharp transition from drill point to countersink angle that is present on form A, so the risk of fracture is reduced.**
- **In the event of angular misalignment of the lathe centre, the ring bearing face avoids the component running only on the external or internal edge of the bearing face. Even if the lathe centres are not in line, good support is provided.**

**Technical description**

Shank tolerance	h7
for workpiece $\varnothing$	30 – 40 mm
Number of cutting edges Z	2
Nominal $\varnothing$ D <sub>c</sub>	3.15 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.03 mm/rev.
Shank $\varnothing$ D <sub>s</sub>	8 mm
Overall length L	50 mm
Coating	uncoated
Tool material	HSS
Standard	DIN 333
Type	R

Tolerance nominal $\varnothing$	k12
Countersink angle with radius	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	$V_c$	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		