

## Garant

**High-precision countersink, long, with 3 drive flats 90°, TiAlN, External Ø Dc: 25mm**



### Order data

Order number	150376 25
GTIN	4062406066048
Item class	11M

### Description

#### Version:

**All countersinks have 3 cutting edges**, radially relief ground. Flutes ground from solid. High-precision countersink, produced to tight manufacturing tolerances similar to DIN335-C, **with long plain shank.**

**Special geometry with extremely unequal spacing** and matching cutting edge preparation. Newly developed, **special TiAlN coating** for long tool life.

Three **drive flats on the shank** for use in a 3-jaw chuck.

#### Application:

High-precision countersinks for chatter-free production of **precise, round 90° countersunk surfaces.**

### Technical description

External Ø	25 mm
Number of cutting edges Z	3
for countersunk screws DIN 7991	M12
Overall length L	118 mm
Feed f in steel < 500 N/mm <sup>2</sup>	0.25 mm/rev.
smallest countersink Ø for holes from	3.8 mm
Pre-drill Ø	3.8 mm
Shank tolerance	h9

Shank $\varnothing D_s$	10 mm
Coating	TiAlN
Countersink tip angle	90 degrees
Tool material	HSS
Spacing of the countersink cutting edges	unequal spacing
Standard	Manufacturer's standard
Shank	Three clamping flats to h9
Through-coolant	no
Colour ring	green
Type of product	Stepped drill and countersink

## User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable	75 m/min	N
Aluminium (short chipping)	suitable	75 m/min	N
Alu > 10% Si	suitable	50 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	18 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	8 m/min	P
Steel < 55 HRC	Suitable only under restricted conditions	8 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	16 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	10 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	12 m/min	S
GG(G)	suitable	25 m/min	K
CuZn	suitable	60 m/min	N

Graphite, GRP, CRP	suitable only under restricted conditions
Uni	suitable
wet maximum	suitable
dry	suitable only under restricted conditions