Garant

High-precision countersink with unequal spacing 90°, AlTiCN, External Ø Dc: 8mm
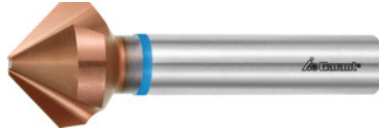
Order data

Order number	150389 8
GTIN	4062406073244
Item class	11M

Description

Version:
All countersinks have 3 cutting edges, radially relieved.
Flutes are ground from solid.
High-precision countersink, produced with tight manufacturing tolerances similar to DIN 335-C.
Special geometry with **unequal spacing** and matching cutting edge preparation.
Newly developed AlTiCN coating especially **for stainless steels.**
Application:
High-precision countersinks for chatter-free production of **precise, round 90° countersunk surfaces.**

Technical description

smallest countersink Ø for holes from	2 mm
for countersunk screws ISO 2009, 2010, 7046, 7047	M4
Number of cutting edges Z	3
Shank Ø D_s	6 mm
Overall length L	50 mm
External Ø	8 mm
Feed f in stainless steel < 900 N/mm^2	0.1 mm/rev.
Coating	AlTiCN

Countersink tip angle	90 degrees
Tool material	HSS E
Spacing of the countersink cutting edges	unequal spacing
Standard	DIN 335 C
Shank	Parallel shank to h9
Through-coolant	no
Colour ring	blue
Type of product	Stepped drill and countersink

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	53 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	40 m/min	N
Alu > 10% Si	suitable only under restricted conditions	35 m/min	N
Steel < 500 N/mm²	suitable	55 m/min	P
Steel < 750 N/mm²	suitable	30 m/min	P
Steel < 900 N/mm²	suitable	25 m/min	P
Steel < 1100 N/mm²	suitable	15 m/min	P
Steel < 1400 N/mm²	suitable	12 m/min	P
INOX < 900 N/mm²	suitable	18 m/min	M
INOX > 900 N/mm²	suitable	13 m/min	M
Ti > 850 N/mm²	suitable	13 m/min	S
GG(G)	suitable only under restricted conditions	30 m/min	K
CuZn	suitable only under restricted conditions	42 m/min	N
wet maximum	suitable		

wet minimum	suitable
dry	suitable only under restricted conditions