

Garant
Centre drill HSS B, uncoated, Nominal \varnothing DC k12: 1mm

Order data

Order number	111520 1
GTIN	4045197000873
Item class	11A

Description
Version:

Ground from solid and relief-ground.

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

Technical description

Feed f in steel $< 900 \text{ N/mm}^2$	0.02 mm/rev.
Nominal $\varnothing D_c$	1 mm
Number of cutting edges Z	2
for workpiece \varnothing	6 – 8 mm
Shank tolerance	h7
Shank $\varnothing D_s$	4 mm
Overall length L	35 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		