

Garant
Centre drill HSS-E, long A, uncoated, Nominal \varnothing DC k12: 1mm

Order data

Order number	111290 1
GTIN	4045197884541
Item class	11A

Description
Version:

Ground from solid and relief-ground.
Spiral fluted, extra long shank, similar to DIN 333-A.

Technical description

Feed f in steel < 900 N/mm ²	0.02 mm/rev.
Shank tolerance	h7
Shank \varnothing D _s	4 mm
Nominal \varnothing D _c	1 mm
for workpiece \varnothing	6 – 8 mm
Overall length L	60 mm
Number of cutting edges Z	2
Coating	uncoated
Tool material	HSS E
Standard	Manufacturer's standard
Type	A
Tolerance nominal \varnothing	k12
Countersink angle	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 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	8 m/min	P
INOX < 900 N/mm ²	suitable	12 m/min	M
INOX > 900 N/mm ²	suitable	8 m/min	M
GG(G)	suitable only under restricted conditions	25 m/min	K
CuZn	suitable	80 m/min	N
Oil	suitable		
wet maximum	suitable		