

**Centre drill HSS A, uncoated, Nominal Ø DC k12: 6,3mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 111005 6,3    |
| GTIN         | 4045197255334 |
| Item class   | 12A           |

**Description****Version:**

Ground from solid and relief ground, spiral fluted.

**Technical description**

|                                         |                      |
|-----------------------------------------|----------------------|
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.05 mm/rev.         |
| for workpiece Ø                         | 100 – 150 mm         |
| Number of cutting edges Z               | 2                    |
| Nominal Ø D <sub>c</sub>                | 6.3 mm               |
| Shank tolerance                         | h7                   |
| Shank Ø D <sub>s</sub>                  | 16 mm                |
| Overall length L                        | 71 mm                |
| Coating                                 | uncoated             |
| Tool material                           | HSS                  |
| Standard                                | DIN 333              |
| Type                                    | A                    |
| Tolerance nominal Ø                     | 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 <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                                  |          |          |