


**Centre drill HSS A, uncoated, Nominal  $\varnothing$  DC k12: 1mm**

**Order data**

Order number	111005 1
GTIN	4045197255259
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>	0.02 mm/rev.
Number of cutting edges Z	2
Shank tolerance	h7
Nominal $\varnothing$ D <sub>c</sub>	1 mm
for workpiece $\varnothing$	6 – 8 mm
Shank $\varnothing$ D <sub>s</sub>	3.15 mm
Overall length L	31.5 mm
Coating	uncoated
Tool material	HSS
Standard	DIN 333
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 <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		