

COUNT

LINE



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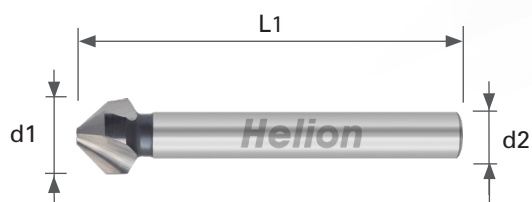
COUNT LINE

Ø range	6,30-31	6,30-31	6-20	6,30 - 8,30 - 10,40 - 12,40 - 16,50 - 20,50	6,30 - 8,30 - 10,40 - 12,40 - 16,50 - 20,50
Code	21.0300	21.2300	21.7100	BOX2100	BOX2123
Page	205	206	207	208	209
Type	HSS	HSS	HSS	HSS	HSS
Coating	Bright	TiAlN	TiN Up	Bright	TiAlN
Coolant	-	-	-	-	-
Shape	90°	90°	180°	90°	90°
Shank design	HA	HA	HA	HA	HA
Steel (600/1400 N/mm <sup>2</sup> )	●	●	●	●	●
Stainless steel	●	●	●	●	●
Cast iron	●	●	●	●	●
Plastic	●	○	○	●	○
GFK-CFK	○	●	●	○	●
ALU-NE	●	○		●	○
NI ALLOYS		●	●		●

## COUNTERSINKER 90° DIN 335 HSS

# 21.0300

-  Avellanador cónico 90° DIN 335 HSS
-  Fraise à noyer et ébavurer 90° DIN 335 HSS
-  Svasatore conico 90° DIN 335 HSS
-  Зенковки HSS 90° DIN 335



600  
1400  
N/mm<sup>2</sup>


INOX


GG(G)

PLASTIC


ALU  
NE



BRIGHT





HA








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COUNT LINE

Cod.	d1	d2	L1	Price €
2103000630	6,30	5	45	
2103000830	8,30	6	50	
2103001040	10,40	6	50	
2103001240	12,40	8	56	
2103001650	16,50	10	60	
2103002050	20,50	10	63	
2103002500	25,00	10	67	
2103003100	31,00	12	71	

## 21.2300

### COUNTERSINKER 90° DIN 335 HSS TiAlN





-  Avellanador cónico 90° DIN 335 HSS TiAlN
-  Fraise à noyer et ébavurer 90° DIN 335 HSS TiAlN
-  Svasatore conico 90° DIN 335 HSS TiAlN
-  Зенковки HSS 90° DIN 335 TiAlN

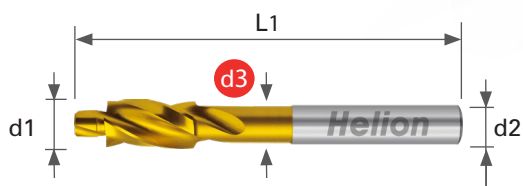


Cod.	d1	d2	L1	Price €
2123000630	6,30	5	45	
2123000830	8,30	6	50	
2123001040	10,40	6	50	
2123001240	12,40	8	56	
2123001650	16,50	10	60	
2123002050	20,50	10	63	
2123002500	25,00	10	67	
2123003100	31,00	12	71	

## COUNTERSINKER 180° FINE GUIDE TOL. DIN 373 HSS TiN

# 21.7100

-  Avellanador cilíndrico 180° guía tol. fina DIN 373 HSS TiN
-  Fraise á lamer et chambrer 180° DIN 373 HSS TiN
-  Lamatori per sedi di viti a norma DIN 373 HSS TiN
-  Цековки с цилиндрическим хвостовиком DIN 373 HSS TiN







600  
1400  
N/mm<sup>2</sup>
INOX
GG(G)
GFK  
CFK
NI  
ALLOYS
TiN  
Up



Cod.	d1	d2	d3	L1	Price €
2171000600	6,00	5,0	3,2	71	
2171000800	8,00	5,0	4,3	71	
2171001000	10,00	8,0	5,3	80	
2171001100	11,00	8,0	6,4	80	
2171001500	15,00	12,5	8,4	100	
2171001800	18,00	12,5	10,5	100	
2171002000	20,00	12,5	13,0	100	

## BOX 2100

### SET BOX 6 PCS. COUNTERSINK DIN 335 90° D: 6,30 - 20,50 HSS





-  Estuche 6 pcs. Avellanadores DIN 335 90° D: 6,30 - 20,50 HSS
-  Coffret 6 pièces fraises à noyer DIN 335 90° D: 6,30 - 20,50 HSS
-  Kit 6 pezzi. Svasatore DIN 335 90° D: 6,30 - 20,50 HSS
-  случай 6 части зенкер DIN 335 90° D: 6.30 - 20.50 HSS

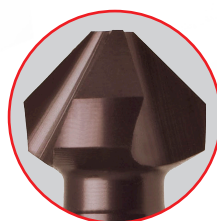


Cod.	Ø	Description	Norm	Type	Coating	Price €
BOX 2100	6,30	Countersink 90°	DIN 335	HSS	Bright	
	8,30	Countersink 90°	DIN 335	HSS	Bright	
	10,40	Countersink 90°	DIN 335	HSS	Bright	
	12,40	Countersink 90°	DIN 335	HSS	Bright	
	16,50	Countersink 90°	DIN 335	HSS	Bright	
	20,50	Countersink 90°	DIN 335	HSS	Bright	

## SET BOX 6 PCS. COUNTERSINK DIN 335 90° D: 6,30 - 20,50 HSS TIALN

## BOX 2123

-  Estuche 6 pcs. Avellanadores DIN 335 90° D: 6,30 - 20,50 HSS TiAlN
-  Coffret 6 pièces fraises à noyer DIN 335 90° D: 6,30 - 20,50 HSS TiAlN
-  Kit 6 pezzi. Svasatore DIN 335 90° D: 6,30 - 20,50 HSS TiAlN
-  случай 6 части зенкер DIN 335 90° D: 6.30 - 20.50 HSS TiAlN



600  
1400  
N/mm<sup>2</sup>    INOX    GG(G)    GFK  
CFK    NI  
ALLOYS    TiAlN



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COUNT LINE

Cod.	Ø	Description	Norm	Type	Coating	Price €
BOX 2123	6,30	Countersink 90°	DIN 335	HSS	TiAlN	
	8,30	Countersink 90°	DIN 335	HSS	TiAlN	
	10,40	Countersink 90°	DIN 335	HSS	TiAlN	
	12,40	Countersink 90°	DIN 335	HSS	TiAlN	
	16,50	Countersink 90°	DIN 335	HSS	TiAlN	
	20,50	Countersink 90°	DIN 335	HSS	TiAlN	

## CUTTING CONDITIONS

Bright	TiAlN	TiN
21.0300	21.2300	21.7100



		Vc m/min	Vc m/min	Vc m/min	feed op.
Steel	General steels <500 N/mm <sup>2</sup> (<150 HB)	32	40	35	<b>26</b>
	General steels <700 N/mm <sup>2</sup> (<205 HB)	28	35	33	<b>25</b>
	General steels <850 N/mm <sup>2</sup> (<25 HRC)	25	30	27	<b>25</b>
	General steels <1000 N/mm <sup>2</sup> (<32 HRC)	15	20	18	<b>24</b>
	General steels <1400 N/mm <sup>2</sup> (<44 HRC)	10	12	11	<b>24</b>
	Tempering steel <850 N/mm <sup>2</sup> (<25 HRC)	25	30	27	<b>24</b>
	Tempering steel <1000 N/mm <sup>2</sup> (<32 HRC)	15	20	18	<b>24</b>
	Tempering steel <1400 N/mm <sup>2</sup> (<44 HRC)	10	12	11	<b>24</b>
Cast iron	Cast iron <180HB	25	30	28	<b>25</b>
	Malleable cast iron GTW - GTS	20	25	22	<b>25</b>
	Nodular cast iron GG - GGG	16	20	17	<b>24</b>
Non ferrous	Aluminium and AL-alloyed <6 % S	80	95	90	<b>26</b>
	Aluminium and AL-alloyed 6%-12% S	40	50	45	<b>25</b>
	Aluminium alloyed over >12% S	30	35	32	<b>25</b>
	Copper, long chips	60	70	65	<b>24</b>
	Brass, bronze, short chips	30	35	33	<b>26</b>
	Brass, bronze, long chips	20	28	29	<b>26</b>
Inox	INOX Stainless steel <700 N/mm <sup>2</sup> (<205 HB)	16	18	17	<b>24</b>
	INOX Stainless steel >700 N/mm <sup>2</sup> (>205 HB)	12	14	13	<b>24</b>
Exotic materials	Titanium, Ti-, Ni-, Co- alloy (Inconel, Stellite...)	8	9	9	<b>24</b>
	Ti 1 / Ti Al6V4	10	12	11	<b>24</b>

d1	Feed OPTION		
	24	25	26
<b>6,00</b>	0,150	0,180	0,220
<b>8,00</b>	0,150	0,200	0,250
<b>10,00</b>	0,180	0,220	0,250
<b>12,00</b>	0,180	0,250	0,300
<b>16,00</b>	0,200	0,280	0,350
<b>20,00</b>	0,250	0,300	0,380
<b>25,00</b>	0,250	0,300	0,380
<b>31,00</b>	0,300	0,380	0,450

Conditions of work guidelines. may vary on each concrete case.  
 Condiciones de trabajo orientativas. pueden variar en función de cada caso concreto.