

Part Number	6542-22
Product	90° Carbide Countersink Single Flute Indexable
Range	5.5 – 22mm
Barcode	9326518187813



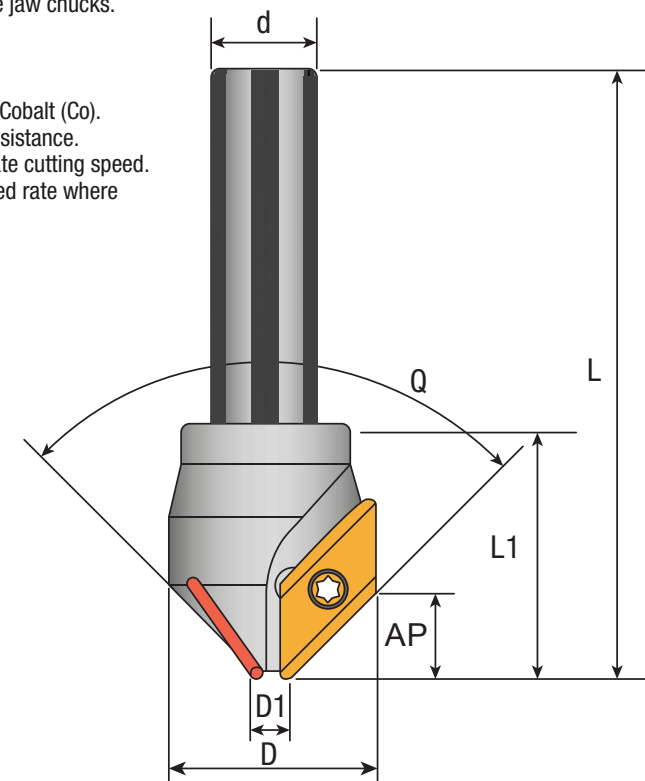
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Bordo International Pty Ltd Australia

- Carbide strip cutter with replaceable insert.
- Clean cutting even at lower RPMs.
- Tri-flat shank facilitates high torque transmission in standard three jaw chucks.
- Chatter free countersinking and deburring even at low RPMs.
- Excellent surface finish.
- Two cutting edges for longer tool life.
- Cemented carbide insert is an alloy of Tungsten Carbide (WC) and Cobalt (Co).
- B100 is a unique rare metal grade with great heat and cracking resistance.
- TiAlN PVD coated - suitable for applications with low to intermediate cutting speed.
- PVD coated grades are recommended for applications with low feed rate where high edge toughness is required.

DIMENSIONAL DATA		
D1	mm	5.5
D	mm	22
d	mm	10
L	mm	65
AP	mm	8
L1	mm	27
Q	degrees	90
Shank Type		Tri-flat
Weight	grams	140

REPLACEABLE COMPONENTS		
Carbide Cutter	Part Number	6542-22-C
Torx Screw	Part Number	6542-22-S
Torx Screw Key	Part Number	6542-22-K



FEEDS AND SPEEDS BY MATERIAL TYPE									
Diameter of hole Ø mm	Steel	Hardened Steel	Stainless Steel	Cast Iron		Aluminium		Titanium Alloys, Ni based super alloys, Co based super alloys	
	Vc : 20m/min	Fz : 0.1mm/tooth		Vc : 15m/min	Fz : 0.12mm/tooth	Vc : 50m/min	Fz : 0.15mm/tooth	Vc : 20m/min	Fz : 0.1mm/tooth
	RPM	Feed mm/min		RPM	Feed mm/min	RPM	Feed mm/min	RPM	Feed mm/min
		Single Cutter			Single Cutter		Single Cutter		Single Cutter
5 – 7	1062	106		796	96	2654	398	796	80
8 – 10	708	71		531	64	1769	265	531	53
11 – 13	531	53		398	48	1327	199	398	40
14 – 16	425	42		318	38	1062	159	318	32
17 – 19	354	35		265	32	885	133	265	27
20 – 22	303	30		227	27	758	114	227	23
23 – 25	265	27		199	24	663	100	199	20
26 – 28	236	24		177	21	590	88	177	18
29 – 31	212	21		159	19	531	80	159	16
32 – 34	193	19		145	17	483	72	145	14
35 – 37	177	18		133	16	442	66	133	13