

Garant**HSS-E centre drill for tapping holes A with flat, uncoated, for threads: M8****Order data**

Order number	111313 M8
GTIN	4062406101978
Item class	11A

Description**Version:**

Stepped centre drill for tapping holes to Form A.

For **combined production** of centring, entry chamfer and tapping hole **all in a single operation**.

With additional flats on the shank.

Nominal $\varnothing D_c$: 6.8 mm

$\varnothing D_1$ 1st step with chamfer ± 0.05 : 8.4 mm

$\varnothing D_2$ 2nd step: 14 mm

Step height L_1 1st step: 19 mm

Step height L_2 2nd step: 23 mm

for workpiece \varnothing : 150 – 180 mm

Technical description

Feed f in steel $< 900 \text{ N/mm}^2$	0.12 mm/rev.
Shank $\varnothing D_s$	14 mm
$s - 0.1$	12.5 mm
Overall length L	88 mm
for workpiece \varnothing	150 – 180 mm
Number of cutting edges Z	2
Nominal $\varnothing D_c$	6.8 mm
Step height L_2 2nd step	23 mm

Step height L ₁ 1st step	19 mm
Ø D ₂ 2nd step	14 mm
Ø D ₁ 1st step with chamfer ±0.05	8.4 mm
Coating	uncoated
Tool material	HSS E
Standard	DIN 332/2
Type	A
Tolerance nominal Ø	0 / -0.05
Countersink angle	60 °
Cutting direction	right-hand
Shank	Parallel shank to h7
Through-coolant	no
Colour ring	without
Type of product	convex

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	65 m/min	N
Aluminium (short chipping)	suitable	65 m/min	N
Alu > 10% Si	suitable	60 m/min	N
Steel < 500 N/mm ²	suitable	28 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	30 m/min	P
Steel < 1100 N/mm ²	suitable	9 m/min	P
Steel < 1400 N/mm ²	suitable	7 m/min	P
INOX < 900 N/mm ²	suitable	7 m/min	M
GG(G)	suitable	28 m/min	K
CuZn	suitable	35 m/min	N

Data sheet

Oil	suitable
wet maximum	suitable