

Garant
Solid carbide short stepped drill 90°, TiAlN, for threads: M10

Order data

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| Order number | 125050 M10 |
| GTIN | 4045197064929 |
| Item class | 11E |

Description
Version:

Very sturdy – step length to DIN 8378. Tight concentricity tolerances between drill and counterbore \varnothing guarantee exact alignment.

Application:

Particularly suitable for NC machines and automatic machines. For drilling tapping holes to DIN 336 sheet 1 with 90° countersinking. In the following operation, the tap therefore does not have to cut into the sharp edge of the hole.

Sizes **F: Tapping holes** for the following **fluteless taps**.

Technical description

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| for threads | M10 |
| Feed f in steel < 1100 N/mm ² | 0.14 mm/rev. |
| $\varnothing D_2$ 2nd step with chamfer h8 | 11 mm |
| $\varnothing D_1$ 1st step with chamfer h8 | 8.5 mm |
| Flute length L_c | 55 mm |
| Shank $\varnothing D_s$ | 12 mm |
| Overall length L | 102 mm |
| No. of teeth Z | 2 |
| Through-coolant | no |
| Step height L_1 1st step | 25.5 mm |
| Coating | TiAlN |

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| Tool material | Solid carbide |
| Standard | DIN 8378 |
| Type | N |
| Tolerance nominal \varnothing | h8 |
| Point angle | 140 degrees |
| Shank | DIN 6535 HA to h6 |
| Countersink angle | 90 degrees |
| Shank tolerance | h6 |
| Colour ring | without |
| Application for type of drilling | for blind hole and through hole |
| Type of product | Stepped drill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Alu plastics | suitable only under restricted conditions | 260 m/min | N |
| Aluminium (short chipping) | suitable | 180 m/min | N |
| Alu > 10% Si | suitable | 180 m/min | N |
| Steel < 500 N/mm ² | suitable | 90 m/min | P |
| Steel < 750 N/mm ² | suitable | 90 m/min | P |
| Steel < 900 N/mm ² | suitable | 90 m/min | P |
| Steel < 1100 N/mm ² | suitable | 60 m/min | P |
| Steel < 1400 N/mm ² | suitable | 35 m/min | P |
| INOX < 900 N/mm ² | suitable | 35 m/min | M |
| INOX > 900 N/mm ² | suitable | 30 m/min | M |
| Ti > 850 N/mm ² | suitable | 25 m/min | S |
| GG(G) | suitable only under restricted conditions | 110 m/min | K |
| CuZn | suitable | 180 m/min | N |

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|-------------|--|
| Uni | suitable |
| wet maximum | suitable |
| dry | suitable only under restricted conditions |