

Garant
Solid carbide short stepped drill 180°, TiAlN, for screws: M8

Order data

Order number	125120 M8
GTIN	4045197065056
Item class	11E

Description
Version:

Very sturdy– step length to DIN 8376. **Tight concentricity tolerances** between drill and counterbore \varnothing guarantee exact alignment.

Application:

For screw through holes to DIN-ISO 273 and counterbores to DIN 74, sheet 2 form H, J, and K, medium version. For screws to DIN 912, 6912, and 7984, ISO 1207 (DIN 84).

Technical description

for screws	M8
$\varnothing D_2$ 2nd step 180° h8	15 mm
Number of cutting edges Z	2
Feed f in steel < 1100 N/mm ²	0.11 mm/rev.
Flute length L_c	65 mm
Step height L_1 1st step 180°	19 mm
$\varnothing D_1$ 1st step 180° h8	9 mm
Shank $\varnothing D_s$	16 mm
Overall length L	115 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 8376

Type	N
Tolerance nominal \varnothing	h8
Point angle	140 degrees
Shank	Plain shank
Countersink angle	180 degrees
Through-coolant	no
Shank tolerance	h6
Colour ring	without
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
Uni	suitable		
wet maximum	suitable		

dry

suitable only under
restricted conditions