

Garant
Solid carbide stepped drill for tapping holes 90°, TiAlN, for threads: M6

Order data

Order number	125100 M6
GTIN	4045197064974
Item class	11E

Description
Version:

Drill and counterbore each with its own chip flutes and guide chamfers. This special design permits frequent regrinding without losing the stepped drill profile. Countersink angle 90°.

Advantage:

Precisely aligned **tapping drill hole and countersink** produced **in a single operation**. For tapping drill holes.

No. of teeth Z: 2

Through-coolant: no

Ø D₁ 1st step with chamfer h7: 5 mm

Ø D₂ 2nd step with chamfer h7: 8 mm

Step height L₁ 1st step: 16.5 mm

Flute length L_c: 41 mm

Overall length L: 79 mm

Shank Ø D_s: 8 mm

Technical description

Ø D ₁ 1st step with chamfer h7	5 mm
Flute length L _c	41 mm
Feed f in steel < 1100 N/mm ²	0.11 mm/rev.
Ø D ₂ 2nd step with chamfer h7	8 mm
for threads	M6
Shank Ø D _s	8 mm
Overall length L	79 mm

No. of teeth Z	2
Through-coolant	no
Step height L ₁ 1st step	16.5 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal Ø	h7
Point angle	140 °
Shank	DIN 6535 HA to h6
Countersink angle	90 °
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	110 m/min	K
CuZn	suitable	180 m/min	N
Uni	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		