Garant

Solid carbide stepped drill for tapping holes 90°, TiAlN, for threads: M8

Order data

Order number	125100 M8
GTIN	4045197064981
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 D_1 1st step with chamfer h7: 6.8 mm
Ø D_2 2nd step with chamfer h7: 10 mm
Step height L_1 1st step: 21 mm
Flute length L_c: 47 mm
Overall length L: 89 mm
Shank Ø D_s: 10 mm

Technical description

Flute length L_c	47 mm
Ø D_2 2nd step with chamfer h7	10 mm
Ø D_1 1st step with chamfer h7	6.8 mm
for threads	M8
Feed f in steel < 1100 N/mm^2	0.11 mm/rev.
Shank Ø D_s	10 mm
Overall length L	89 mm

Through-coolant	no
No. of teeth Z	2
Step height L_1 1st step	21 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Type	N
Tolerance nominal ∅	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/mm²	suitable	90 m/min	P
Steel < 750 N/mm²	suitable	90 m/min	P
Steel < 900 N/mm²	suitable	90 m/min	P
Steel < 1100 N/mm²	suitable	60 m/min	P
Steel < 1400 N/mm²	suitable	35 m/min	P
INOX < 900 N/mm²	suitable	35 m/min	M

INOX > 900 N/mm²	suitable	30 m/min	M
Ti > 850 N/mm²	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		