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.

Technical description

Flute length L_c	47 mm
∅ D_2 2nd step with chamfer h7	10 mm
∅ 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 ∅ 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 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/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