Garant

Stub stepped drill HSS 90°, vaporised, for threads: M3

Order data

Order number	117020 M3
GTIN	4045197035639
Item class	11C

Description

Version:
Very sturdy. Tight concentricity tolerances between drill ∅ and counterbore ∅ guarantee exact alignment.
Special surface treatment, resulting in reduced tendency to edge build-up and improved chip evacuation.
Advantage:
Hole and countersink are produced in one operation and precisely aligned.
Application:
Particularly suitable for NC machines due to high positional accuracy, excellent centring properties and great sturdiness. The preceding centring operation can thus often be omitted. For thread tapping drill holes to DIN 336 sheet 1 with 90° countersink. In the following operation, the tap therefore does not have to cut into the sharp edge of the hole.
Countersink angle: 90 °
No. of teeth Z: 2
Through-coolant: no
∅ D_1 1st step with chamfer h8: 2.5 mm
∅ D_2 2nd step with chamfer h8: 3.4 mm
Step height L_1 1st step: 8.8 mm
Flute length L_c: 20 mm
Overall length L: 52 mm
Shank ∅ D_s: 3.4 mm

Technical description

Feed f in steel < 750 N/mm^2	0.03 mm/rev.
∅ D_2 2nd step with chamfer h8	3.4 mm

∅ D_1 1st step with chamfer h8	2.5 mm
for threads	M3
Flute length L_c	20 mm
Shank ∅ D_s	3.4 mm
Overall length L	52 mm
No. of teeth Z	2
Through-coolant	no
Step height L_1 1st step	8.8 mm
Coating	vaporised
Tool material	HSS
Standard	DIN 1897
Tolerance nominal ∅	h8
Point angle	118 °
Shank	Parallel shank to h8
Countersink angle	90 °
Shank tolerance	h8
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
Aluminium (short chipping)	suitable only under restricted conditions	45 m/min	N
Steel < 500 N/mm²	suitable	40 m/min	P
Steel < 750 N/mm²	suitable	30 m/min	P
Steel < 900 N/mm²	suitable	25 m/min	P
GG(G)	suitable	25 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N

Oil	suitable
wet maximum	suitable