

Garant
Subland drill HSS 90°, vaporised, for threads: M10

Order data

| | |
|--------------|---------------|
| Order number | 117060 M10 |
| GTIN | 4045197035820 |
| Item class | 11C |

Description
Version:

Drill and counterbore each with its own chip flutes and guide chamfers. This means the profile of the stepped drill is retained even after repeated regrinding.

Application:

Tapping hole and countersink are produced **in one operation**, precisely aligned.

For drilling tapping holes to DIN 336 sheet 1 with 90° countersinking (similar to DIN 69, medium version).

No. of teeth Z: 2

Through-coolant: no

Ø D₁ 1st step with chamfer h9: 8.5 mm

Ø D₂ 2nd step with chamfer h8: 11 mm

Step height L₁ 1st step: 25.5 mm

Flute length L_c: 94 mm

Overall length L: 142 mm

Shank Ø D_s: 11 mm

Technical description

| | |
|---|-------------|
| Flute length L _c | 94 mm |
| Feed f in steel < 750 N/mm ² | 0.1 mm/rev. |
| Ø D ₂ 2nd step with chamfer h8 | 11 mm |
| for threads | M10 |
| Ø D ₁ 1st step with chamfer h9 | 8.5 mm |
| Shank Ø D _s | 11 mm |
| Overall length L | 142 mm |

| | |
|-------------------------------------|---------------------------------|
| Through-coolant | no |
| No. of teeth Z | 2 |
| Step height L ₁ 1st step | 25.5 mm |
| Coating | vaporised |
| Tool material | HSS |
| Standard | DIN 8378 |
| Tolerance nominal Ø | h9 |
| Point angle | 118 ° |
| Shank | Parallel shank to h8 |
| Helix angle | 20-30 ° |
| 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/mm ² | suitable | 40 m/min | P |
| Steel < 750 N/mm ² | suitable | 30 m/min | P |
| Steel < 900 N/mm ² | 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 | | |

