

Garant
Stub stepped drill HSS 90°, TiAlN, for threads: M12

Order data

Order number	117040 M12
GTIN	4045197035769
Item class	11C

Description
Version:

Very sturdy. Tight concentricity tolerances between drill \varnothing and counterbore \varnothing guarantee exact alignment.

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

$\varnothing D_1$ 1st step with chamfer h8: 10.2 mm

$\varnothing D_2$ 2nd step with chamfer h8: 13.5 mm

Step height L_1 1st step: 30 mm

Flute length L_c : 54 mm

Overall length L: 107 mm

Shank $\varnothing D_s$: 13.5 mm

Technical description

$\varnothing D_1$ 1st step with chamfer h8	10.2 mm
$\varnothing D_2$ 2nd step with chamfer h8	13.5 mm
for threads	M12
Flute length L_c	54 mm

Feed f in steel < 750 N/mm ²	0.16 mm/rev.
Shank Ø D _s	13.5 mm
Overall length L	107 mm
Through-coolant	no
No. of teeth Z	2
Step height L ₁ 1st step	30 mm
Coating	TiAlN
Tool material	HSS
Standard	DIN 1897
Tolerance nominal Ø	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	56 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm ²	suitable	50 m/min	P
Steel < 750 N/mm ²	suitable	37 m/min	P
Steel < 900 N/mm ²	suitable	31 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	12 m/min	P

Steel < 1400 N/mm ²	suitable only under restricted conditions	10 m/min	P
GG(G)	suitable	31 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
Oil	suitable		
wet maximum	suitable		