

**Garant**
**Subland drill HSS 90°, vaporised, for screws: M8**

**Order data**

Order number	117180 M8
GTIN	4045197036100
Item class	11C

**Description**
**Version:**

**Drill and counterbore each with its own chip flutes and guide chamfers.** This means it can be reground many times.

**Application:**

For through holes for screws to DIN-ISO 273 and countersinks to DIN 74, sheet 1 form A, fine version.

For countersunk screws to ISO 2009, 2010, 7046, 7047 (DIN 963, 964, 965 and 966).

Number of cutting edges Z: 2

Ø D<sub>1</sub> 1st step with chamfer h<sub>9</sub>: 8.4 mm

Ø D<sub>2</sub> 2nd step with chamfer h<sub>8</sub>: 15 mm

Step height L<sub>1</sub> 1st step: 19 mm

Flute length L<sub>c</sub>: 114 mm

Overall length L: 169 mm

Shank Ø D<sub>s</sub>: 15 mm

**Technical description**

Number of cutting edges Z	2
Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.
Flute length L <sub>c</sub>	114 mm
Ø D <sub>2</sub> 2nd step with chamfer h <sub>8</sub>	15 mm
Ø D <sub>1</sub> 1st step with chamfer h <sub>9</sub>	8.4 mm
for screws	M8
Shank Ø D <sub>s</sub>	15 mm

Overall length L	169 mm
Step height L <sub>1</sub> 1st step	19 mm
Coating	vaporised
Tool material	HSS
Standard	DIN 8374
Tolerance nominal Ø	h9
Point angle	118 °
Helix angle	20-30 °
Shank	Parallel shank to h8
Countersink angle	90 °
Through-coolant	no
Shank tolerance	h8
Colour ring	without
Type of product	Stepped drill

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	45 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	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		