

Garant
Stub stepped drill HSS 90°, vaporised, for threads: M8

Order data

Order number	117020 M8
GTIN	4045197035677
Item class	11C

Description
Version:

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

$\varnothing D_1$ 1st step with chamfer h8: 6.8 mm

$\varnothing D_2$ 2nd step with chamfer h8: 9 mm

Step height L_1 1st step: 21 mm

Flute length L_c : 40 mm

Overall length L: 84 mm

Shank $\varnothing D_s$: 9 mm

Technical description

for threads	M8
Feed f in steel < 750 N/mm ²	0.1 mm/rev.

Flute length L_c	40 mm
$\varnothing D_2$ 2nd step with chamfer h8	9 mm
$\varnothing D_1$ 1st step with chamfer h8	6.8 mm
Shank $\varnothing D_s$	9 mm
Overall length L	84 mm
No. of teeth Z	2
Through-coolant	no
Step height L_1 1st step	21 mm
Coating	vaporised
Tool material	HSS
Standard	DIN 1897
Tolerance nominal \varnothing	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/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		