

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

**Order data**

Order number	117120 M8
GTIN	4045197035936
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.

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

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

Number of cutting edges Z: 2

$\varnothing D_1$  1st step with chamfer h8: 8.4 mm

$\varnothing D_2$  2nd step with chamfer h8: 15 mm

Step height  $L_1$  1st step: 19 mm

Flute length  $L_c$ : 56 mm

Overall length L: 111 mm

Shank  $\varnothing D_s$ : 15 mm

**Technical description**

Flute length $L_c$	56 mm
Number of cutting edges Z	2
for screws	M8
$\varnothing D_1$ 1st step with chamfer h8	8.4 mm

Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.
Ø D <sub>2</sub> 2nd step with chamfer h8	15 mm
Shank Ø D <sub>s</sub>	15 mm
Overall length L	111 mm
Step height L <sub>1</sub> 1st step	19 mm
Coating	vaporised
Tool material	HSS
Standard	DIN 1897
Tolerance nominal Ø	h8
Point angle	118 °
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		

