

**Garant**
**Subland drill HSS-E with long drilling step 90°, uncoated, for screws: M6**

**Order data**

Order number	117160 M6
GTIN	4045197036032
Item class	11C

**Description**
**Version:**
**With long drilling step.**
**Application:**

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

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

**Especially suitable for holes with simultaneous countersinking in the profile material.**

Number of cutting edges Z: 2

Ø D<sub>1</sub> 1st step with chamfer ±0.05: 6.4 mm

Ø D<sub>2</sub> 2nd step with chamfer h9: 12.4 mm

Step height L<sub>1</sub> 1st step: 30 mm

Flute length L<sub>c</sub>: 55 mm

Overall length L: 110 mm

Shank Ø D<sub>s</sub>: 12.4 mm

**Technical description**

Feed f in steel < 750 N/mm <sup>2</sup>	0.07 mm/rev.
Flute length L <sub>c</sub>	55 mm
Ø D <sub>2</sub> 2nd step with chamfer h9	12.4 mm
for screws	M6
Ø D <sub>1</sub> 1st step with chamfer ±0.05	6.4 mm
Number of cutting edges Z	2
Shank Ø D <sub>s</sub>	12.4 mm

Overall length L	110 mm
Step height L <sub>1</sub> 1st step	30 mm
Coating	uncoated
Tool material	HSS E
Standard	Manufacturer's standard
Tolerance nominal Ø	± 0.05
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
Alu plastics	suitable only under restricted conditions	70 m/min	N
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		

