

Garant
Subland drill HSS-E with long drilling step 90°, uncoated, for screws: M8

Order data

Order number	117160 M8
GTIN	4045197036049
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 D₁ 1st step with chamfer ±0.05: 8.4 mm

Ø D₂ 2nd step with chamfer h9: 16.4 mm

Step height L₁ 1st step: 30 mm

Flute length L_c: 70 mm

Overall length L: 110 mm

Shank Ø D_s: 12.5 mm

Technical description

Feed f in steel < 750 N/mm ²	0.1 mm/rev.
Flute length L _c	70 mm
Ø D ₁ 1st step with chamfer ±0.05	8.4 mm
Ø D ₂ 2nd step with chamfer h9	16.4 mm
Number of cutting edges Z	2
for screws	M8
Shank Ø D _s	12.5 mm

Overall length L	110 mm
Step height L ₁ 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 _c	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 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		

