

**Garant**
**Stub subland drill HSS 180°, vaporised, for screws: M4**

**Order data**

Order number	117240 M4
GTIN	4045197036179
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:**

For through holes for screws to DIN-ISO 273 and countersinking to DIN 74, sheet 2 form H, J and K, medium version.

For screws to DIN 912, 6912 and 7984, ISO 1207 (DIN 84).

**Technical description**

Flute length $L_c$	37 mm
Feed $f$ in steel $< 750 \text{ N/mm}^2$	0.03 mm/rev.
$\varnothing D_1$ 1st step 180° h8	4.5 mm
Step height $L_1$ 1st step 180°	11 mm
$\varnothing D_2$ 2nd step 180° h8	8 mm
Number of cutting edges $Z$	2
for screws	M4
Shank $\varnothing D_s$	8 mm
Overall length $L$	79 mm
Coating	vaporised

Tool material	HSS
Standard	DIN 1897
Tolerance nominal Ø	h8
Point angle	118 °
Shank	Parallel shank to h8
Countersink angle	180 °
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		