

Garant
Subland drill HSS 180°, vaporised, for screws: M20

Order data

Order number	117320 M20
GTIN	4045197036414
Item class	11C

Description
Version:

Drill and counterbore each with its own chip flutes and guide chamfers. This means the profile of the stepped drill is retained even after repeated regrinding.

Application:

For screw through holes to DIN-ISO 273 and screw head counterbores shape H, J, and K. Medium version to DIN 74 sheet 2.

Note:

For suitable reducing adapters for tools with MT shanks see **No. 343000-343530**.

Technical description

Ø D ₁ 1st step 180° h ₉	22 mm
Flute length L _c	185 mm
for screws	M20
Step height L ₁ 1st step 180°	43 mm
Feed f in steel < 750 N/mm ²	0.2 mm/rev.
Number of cutting edges Z	2
Ø D ₂ 2nd step 180° h ₈	33 mm
Overall length L	334 mm
Morse taper MT size	4
Coating	vaporised
Tool material	HSS

Standard	DIN 8377
Tolerance nominal \varnothing	h9
Point angle	118 °
Helix angle	20-30 °
Shank	Morse taper
Countersink angle	180 °
Through-coolant	no
Colour ring	without
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		