

Garant
GARANT Master Steel FEED solid carbide stepped drill, TiAlN, for threads: M8X1

Order data

Order number	125035 M8X1
GTIN	4062406066475
Item class	11E

Description
Version:

For generation of **optimum tapping holes**. Creates **ideal machining conditions** for the subsequent tapping tool. The cutter \varnothing of the drill is matched to the thread that is to be produced, in order to achieve a threads true to gauge and for **high process reliability of the tapping process**. The 90° counterbore for the thread is produced **in the same operation** as drilling the tapping hole.

3-flute drill, specially developed for **use at very high feed rates**. Outstandingly suitable for machines with high installed power and stable machining conditions.

Diameter tolerance first level: h7.

Thread type: MF

No. of teeth Z: 3

Through-coolant: yes, with 25 bar

Thread pitch: 1

$\varnothing D_1$ 1st step: 7.1 mm

$\varnothing D_2$ 2nd step with chamfer h7: 8.8 mm

Step height L_1 1st step: 21 mm

Flute length L_c : 47 mm

Overall length L: 89 mm

Technical description

Flute length L_c	47 mm
Shank $\varnothing D_s$	10 mm
Feed f in steel < 1100 N/mm ²	0.37 mm/rev.

Overall length L	89 mm
Ø D ₂ 2nd step with chamfer h7	8.8 mm
for threads	M8×1
Thread pitch	1
Through-coolant	yes, with 25 bar
No. of teeth Z	3
Thread type	MF
Ø D ₁ 1st step	7.1 mm
Step height L ₁ 1st step	21 mm
Series	Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal Ø	m7
Point angle	145 °
Shank	DIN 6535 HA to h6
Countersink angle	90 °
Machining strategy	HPC
Colour ring	green
Application for type of drilling	for blind hole and through hole
Type of product	Stepped drill

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	160 m/min	P
Steel < 750 N/mm ²	suitable	140 m/min	P
Steel < 900 N/mm ²	suitable	130 m/min	P
Steel < 1100 N/mm ²	suitable	110 m/min	P
Steel < 1400 N/mm ²	suitable	90 m/min	P

Steel < 55 HRC	suitable	60 m/min	H
INOX < 900 N/mm ²	suitable	60 m/min	M
INOX > 900 N/mm ²	suitable	50 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	40 m/min	S
GG	suitable	130 m/min	K
GGG	suitable	80 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		