

Garant
Subland drill HSS 90°, vaporised, for screws: M6

Order data

Order number	117180 M6
GTIN	4045197036094
Item class	11C

Description
Version:

Drill and counterbore each with its own chip flutes and guide chamfers. This means it can be reground many times.

Application:

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

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

Number of cutting edges Z: 2

Ø D₁ 1st step with chamfer h9: 6.4 mm

Ø D₂ 2nd step with chamfer h8: 11.5 mm

Step height L₁ 1st step: 15 mm

Flute length L_c: 94 mm

Overall length L: 142 mm

Shank Ø D_s: 11.5 mm

Technical description

Flute length L _c	94 mm
Feed f in steel < 750 N/mm ²	0.07 mm/rev.
for screws	M6
Ø D ₂ 2nd step with chamfer h8	11.5 mm
Number of cutting edges Z	2
Ø D ₁ 1st step with chamfer h9	6.4 mm
Shank Ø D _s	11.5 mm

Overall length L	142 mm
Step height L ₁ 1st step	15 mm
Coating	vaporised
Tool material	HSS
Standard	DIN 8374
Tolerance nominal Ø	h9
Point angle	118 °
Helix angle	20-30 °
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
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		