

**Garant**
**Stub stepped drill HSS 90°, TiAlN, for threads: M8**

**Order data**

Order number	117040 M8
GTIN	4045197035745
Item class	11C

**Description**
**Version:**

**Very sturdy. Tight concentricity tolerances** between drill  $\varnothing$  and counterbore  $\varnothing$  guarantee exact alignment.

**Advantage:**

**Hole and countersink are produced in one operation and precisely aligned.**

**Application:**

**Particularly suitable for NC machines** due to high positional accuracy, excellent centring properties and great sturdiness. The preceding centring operation can thus often be omitted. For thread tapping drill holes to DIN 336 sheet 1 with 90° countersink. In the following operation, the tap therefore does not have to cut into the sharp edge of the hole.

Countersink angle: 90°

No. of teeth Z: 2

Through-coolant: no

$\varnothing D_1$  1st step with chamfer h8: 6.8 mm

$\varnothing D_2$  2nd step with chamfer h8: 9 mm

Step height  $L_1$  1st step: 21 mm

Flute length  $L_c$ : 40 mm

Overall length L: 84 mm

Shank  $\varnothing D_s$ : 9 mm

**Technical description**

for threads	M8
$\varnothing D_1$ 1st step with chamfer h8	6.8 mm
$\varnothing D_2$ 2nd step with chamfer h8	9 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.

Flute length $L_c$	40 mm
Shank $\varnothing D_s$	9 mm
Overall length L	84 mm
Through-coolant	no
No. of teeth Z	2
Step height $L_1$ 1st step	21 mm
Coating	TiAlN
Tool material	HSS
Standard	DIN 1897
Tolerance nominal $\varnothing$	h8
Point angle	118°
Shank	Parallel shank to h8
Countersink angle	90°
Shank tolerance	h8
Colour ring	without
Application for type of drilling	for blind hole and through hole
Type of product	Stepped drill

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	56 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	37 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	31 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	12 m/min	P

Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	10 m/min	P
GG(G)	suitable	31 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
Oil	suitable		
wet maximum	suitable		