

Garant
Stub subland drill HSS 180°, TiAlN, for screws: M8

Order data

Order number	117260 M8
GTIN	4045197036261
Item class	11C

Description
Version:

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

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).

Number of cutting edges Z: 2

$\varnothing D_1$ 1st step 180° h8: 9 mm

$\varnothing D_2$ 2nd step 180° h8: 15 mm

Step height L_1 1st step 180°: 19 mm

Flute length L_c : 56 mm

Overall length L: 111 mm

Shank $\varnothing D_s$: 15 mm

Technical description

Number of cutting edges Z	2
Feed f in steel < 750 N/mm ²	0.1 mm/rev.
for screws	M8
Flute length L_c	56 mm
$\varnothing D_2$ 2nd step 180° h8	15 mm
Step height L_1 1st step 180°	19 mm
$\varnothing D_1$ 1st step 180° h8	9 mm

Shank $\varnothing D_s$	15 mm
Overall length L	111 mm
Coating	TiAlN
Tool material	HSS
Standard	DIN 1897
Tolerance nominal \varnothing	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_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 ²	suitable	50 m/min	P
Steel < 750 N/mm ²	suitable	37 m/min	P
Steel < 900 N/mm ²	suitable	31 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	12 m/min	P
Steel < 1400 N/mm ²	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