

**Garant**
**Subland drill HSS 180°, vaporised, for screws: M8**

**Order data**

Order number	117280 M8
GTIN	4045197036322
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.

**Technical description**

Step height $L_1$ 1st step 180°	19 mm
$\varnothing D_1$ 1st step 180° h9	9 mm
Flute length $L_c$	114 mm
Number of cutting edges Z	2
for screws	M8
$\varnothing D_2$ 2nd step 180° h8	15 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.
Shank $\varnothing D_s$	15 mm
Overall length L	169 mm
Coating	vaporised
Tool material	HSS
Standard	DIN 8376

Tolerance nominal $\varnothing$	h9
Point angle	118 °
Helix angle	20-30 °
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	45 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	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		