Garant

Stub subland drill HSS 90°, TiAlN, for screws: M10

Order data

Order number	117140 M10
GTIN	4045197036001
Item class	11C

Description

Version:
Very sturdy. Tight concentricity tolerances between drill Ø and counterbore Ø guarantee exact alignment.
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 through holes for screws to DIN-ISO 273 and countersinks to DIN 74, sheet 1 form A, fine version.
For screws to ISO 2009, 2010, 7046, 7047 (DIN 963, 964, 965 and 966).
Number of cutting edges Z: 2
Ø D_1 1st step with chamfer h8: 10.5 mm
Ø D_2 2nd step with chamfer h8: 19 mm
Step height L_1 1st step: 23 mm
Flute length L_c: 64 mm
Overall length L: 127 mm
Shank Ø D_s: 19 mm

Technical description

Number of cutting edges Z	2
Ø D_1 1st step with chamfer h8	10.5 mm
for screws	M10
Flute length L_c	64 mm
Feed f in steel < 750 N/mm^2	0.1 mm/rev.

$\varnothing$ D_2 2nd step with chamfer h8	19 mm
Shank $\varnothing$ D_s	19 mm
Overall length L	127 mm
Step height L_1 1st step	23 mm
Coating	TiAlN
Tool material	HSS
Standard	DIN 1897
Tolerance nominal $\varnothing$	h8
Point angle	118 °
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	56 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm²	suitable	50 m/min	P
Steel < 750 N/mm²	suitable	37 m/min	P
Steel < 900 N/mm²	suitable	31 m/min	P
Steel < 1100 N/mm²	suitable only under restricted conditions	12 m/min	P
Steel < 1400 N/mm²	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		