Hoffmann Group

Garant

Stub subland drill HSS 90°, vaporised, for screws: M3

Order data

Order number	117120 M3
GTIN	4045197035899
Item class	11C

Description

Version:
Very sturdy. Tight concentricity tolerances between drill Ø and counterbore Ø guarantee exact alignment.
Special surface treatment, resulting in reduced tendency to edge build-up and improved chip evacuation.
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: 3.2 mm
Ø D_2 2nd step with chamfer h8: 6 mm
Step height L_1 1st step: 9 mm
Flute length L_c: 28 mm
Overall length L: 66 mm
Shank Ø D_s: 6 mm

Technical description

Ø D_2 2nd step with chamfer h8	6 mm
for screws	M3
Ø D_1 1st step with chamfer h8	3.2 mm
Flute length L_c	28 mm

Feed f in steel < 750 N/mm^2	0.03 mm/rev.
Number of cutting edges Z	2
Shank Ø D_s	6 mm
Overall length L	66 mm
Step height L_1 1st step	9 mm
Coating	vaporised
Tool material	HSS
Standard	DIN 1897
Tolerance nominal Ø	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	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		