

**Garant**
**Subland drill HSS 90°, vaporised, for threads: M6**

**Order data**

Order number	117060 M6
GTIN	4045197035806
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:**

**Tapping hole and countersink** are produced **in one operation**, precisely aligned.

For drilling tapping holes to DIN 336 sheet 1 with 90° countersinking (similar to DIN 69, medium version).

No. of teeth Z: 2

Through-coolant: no

Ø D<sub>1</sub> 1st step with chamfer h<sub>9</sub>: 5 mm

Ø D<sub>2</sub> 2nd step with chamfer h<sub>8</sub>: 6.6 mm

Step height L<sub>1</sub> 1st step: 16.5 mm

Flute length L<sub>c</sub>: 63 mm

Overall length L: 101 mm

Shank Ø D<sub>s</sub>: 6.6 mm

**Technical description**

Flute length L <sub>c</sub>	63 mm
Ø D <sub>1</sub> 1st step with chamfer h <sub>9</sub>	5 mm
for threads	M6
Ø D <sub>2</sub> 2nd step with chamfer h <sub>8</sub>	6.6 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.07 mm/rev.
Shank Ø D <sub>s</sub>	6.6 mm
Overall length L	101 mm

No. of teeth Z	2
Through-coolant	no
Step height L <sub>1</sub> 1st step	16.5 mm
Coating	vaporised
Tool material	HSS
Standard	DIN 8378
Tolerance nominal Ø	h9
Point angle	118 °
Shank	Parallel shank to h8
Helix angle	20-30 °
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 <sub>c</sub>	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		

