

**Garant**
**Subland drill HSS 180°, vaporised, for screws: M6**

**Order data**

Order number	117280 M6
GTIN	4045197036315
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**

Flute length $L_c$	94 mm
Feed $f$ in steel $< 750 \text{ N/mm}^2$	0.07 mm/rev.
$\varnothing D_2$ 2nd step 180° h8 for screws	11 mm M6
$\varnothing D_1$ 1st step 180° h9	6.6 mm
Step height $L_1$ 1st step 180°	15 mm
Number of cutting edges $Z$	2
Shank $\varnothing D_s$	11 mm
Overall length $L$	142 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		