

**Garant**
**Stub subland drill HSS 180°, TiAlN, for screws: M10**

**Order data**

Order number	117260 M10
GTIN	4045197036278
Item class	11C

**Description**
**Version:**

**Very sturdy. Tight concentricity tolerances** between drill  $\varnothing$  and counterbore  $\varnothing$  guarantee exact alignment.

**Application:**

For through holes for screws to DIN-ISO 273 and countersinking to DIN 74, sheet 2 form H, J and K, medium version.

For screws to DIN 912, 6912 and 7984, ISO 1207 (DIN 84).

Number of cutting edges Z: 2

$\varnothing D_1$  1st step 180° h8: 11 mm

$\varnothing D_2$  2nd step 180° h8: 18 mm

Step height  $L_1$  1st step 180°: 23 mm

Flute length  $L_c$ : 62 mm

Overall length L: 123 mm

Shank  $\varnothing D_s$ : 18 mm

**Technical description**

$\varnothing D_1$ 1st step 180° h8	11 mm
$\varnothing D_2$ 2nd step 180° h8	18 mm
for screws	M10
Step height $L_1$ 1st step 180°	23 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.
Number of cutting edges Z	2
Flute length $L_c$	62 mm

Shank $\varnothing D_s$	18 mm
Overall length L	123 mm
Coating	TiAlN
Tool material	HSS
Standard	DIN 1897
Tolerance nominal $\varnothing$	h8
Point angle	118°
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	56 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	37 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	31 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	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