

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

Order data

Order number	117320 M6
GTIN	4045197036353
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.

Note:

For suitable reducing adapters for tools with MT shanks see **No. 343000-343530**.

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
Step height L_1 1st step 180°	15 mm
Number of cutting edges Z	2
$\varnothing D_1$ 1st step 180° h9	6.6 mm
Overall length L	175 mm
Morse taper MT size	1
Coating	vaporised
Tool material	HSS

Standard	DIN 8377
Tolerance nominal \varnothing	h9
Point angle	118 °
Helix angle	20-30 °
Shank	Morse taper
Countersink angle	180 °
Through-coolant	no
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		