

Garant
Stub subland drill HSS 90°, TiAlN, for screws: M6

Order data

Order number	117140 M6
GTIN	4045197035981
Item class	11C

Description
Version:

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

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

$\varnothing D_1$ 1st step with chamfer h8: 6.4 mm

$\varnothing D_2$ 2nd step with chamfer h8: 11.5 mm

Step height L_1 1st step: 15 mm

Flute length L_c : 47 mm

Overall length L: 95 mm

Shank $\varnothing D_s$: 11.5 mm

Technical description

Feed f in steel < 750 N/mm ²	0.07 mm/rev.
Number of cutting edges Z	2
for screws	M6
Flute length L_c	47 mm
$\varnothing D_1$ 1st step with chamfer h8	6.4 mm

Ø D ₂ 2nd step with chamfer h8	11.5 mm
Shank Ø D _s	11.5 mm
Overall length L	95 mm
Step height L ₁ 1st step	15 mm
Coating	TiAlN
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	56 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm ²	suitable	50 m/min	P
Steel < 750 N/mm ²	suitable	37 m/min	P
Steel < 900 N/mm ²	suitable	31 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	12 m/min	P
Steel < 1400 N/mm ²	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		