

Garant
Stub subland drill HSS 180°, vaporised, for screws: M8

Order data

Order number	117240 M8
GTIN	4045197036209
Item class	11C

Description
Version:

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

Special surface treatment, resulting in reduced tendency to edge build-up and improved chip evacuation.

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).

Technical description

Flute length L_c	56 mm
for screws	M8
Feed f in steel $< 750 \text{ N/mm}^2$	0.1 mm/rev.
$\varnothing D_1$ 1st step 180° h8	9 mm
$\varnothing D_2$ 2nd step 180° h8	15 mm
Number of cutting edges Z	2
Step height L_1 1st step 180°	19 mm
Shank $\varnothing D_s$	15 mm
Overall length L	111 mm
Coating	vaporised

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	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		