

Garant
GARANT Master Steel FEED solid carbide stepped drill, TiAlN, for threads: M8

Order data

Order number	125035 M8
GTIN	4062406066468
Item class	11E

Description
Version:

3-flute drill, specially developed for **use at very high feed rates**. Outstandingly suitable for machines with high installed power and stable machining conditions.

Diameter tolerance first level: h7.

For generation of **optimum tapping holes**. Creates **ideal machining conditions** for the subsequent tapping tool. The cutter \varnothing of the drill is matched to the thread that is to be produced, in order to achieve a threads true to gauge and for **high process reliability of the tapping process**. The 90° counterbore for the thread is produced **in the same operation** as drilling the tapping hole.

Thread type: M

No. of teeth Z: 3

Through-coolant: yes, with 25 bar

Thread pitch: 1.25

$\varnothing D_1$ 1st step: 6.85 mm

$\varnothing D_2$ 2nd step with chamfer h7: 8.8 mm

Step height L_1 1st step: 21 mm

Flute length L_c : 47 mm

Overall length L: 89 mm

Technical description

for threads	M8
Feed f in steel < 1100 N/mm ²	0.37 mm/rev.
Flute length L_c	47 mm
Shank $\varnothing D_s$	10 mm

Ø D ₂ 2nd step with chamfer h7	8.8 mm
Overall length L	89 mm
No. of teeth Z	3
Thread type	M
Thread pitch	1.25
Through-coolant	yes, with 25 bar
Ø D ₁ 1st step	6.85 mm
Step height L ₁ 1st step	21 mm
Series	GARANT Master Steel
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal Ø	m7
Point angle	145 degrees
Shank	DIN 6535 HA to h6
Countersink angle	90 degrees
Machining strategy	HPC
Colour ring	green
Type of product	Stepped drill