

Garant
GARANT Master Steel FEED solid carbide stepped drill, TiAlN, for threads: M8X1

Order data

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|--------------|---------------|
| Order number | 125035 M8X1 |
| GTIN | 4062406066475 |
| 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 Ø 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: MF

No. of teeth Z: 3

Through-coolant: yes, with 25 bar

Thread pitch: 1

Ø D₁ 1st step: 7.1 mm

Ø D₂ 2nd step with chamfer h7: 8.8 mm

Step height L₁ 1st step: 21 mm

Flute length L_c: 47 mm

Overall length L: 89 mm

Technical description

| | |
|--|--------------|
| Flute length L _c | 47 mm |
| Shank Ø D _s | 10 mm |
| Feed f in steel < 1100 N/mm ² | 0.37 mm/rev. |

| | |
|---|-------------------------|
| Overall length L | 89 mm |
| Ø D ₂ 2nd step with chamfer h7 | 8.8 mm |
| for threads | M8×1 |
| Thread pitch | 1 |
| Through-coolant | yes, with 25 bar |
| No. of teeth Z | 3 |
| Thread type | MF |
| Ø D ₁ 1st step | 7.1 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 |