

Garant
Stub stepped drill HSS 90°, vaporised, for threads: M6

Order data

Order number	117020 M6
GTIN	4045197035660
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.

Advantage:

Hole and countersink are produced in one operation and precisely aligned.

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 thread tapping drill holes to DIN 336 sheet 1 with 90° countersink. In the following operation, the tap therefore does not have to cut into the sharp edge of the hole.

Countersink angle: 90 degrees

No. of teeth Z: 2

Through-coolant: no

$\varnothing D_1$ 1st step with chamfer h8: 5 mm

$\varnothing D_2$ 2nd step with chamfer h8: 6.6 mm

Step height L_1 1st step: 16.5 mm

Flute length L_c : 31 mm

Overall length L: 70 mm

Shank $\varnothing D_s$: 6.6 mm

Technical description

$\varnothing D_2$ 2nd step with chamfer h8	6.6 mm
$\varnothing D_1$ 1st step with chamfer h8	5 mm

Feed f in steel < 750 N/mm ²	0.07 mm/rev.
Flute length L _c	31 mm
for threads	M6
Shank Ø D _s	6.6 mm
Overall length L	70 mm
Through-coolant	no
No. of teeth Z	2
Step height L ₁ 1st step	16.5 mm
Coating	vaporised
Tool material	HSS
Standard	DIN 1897
Tolerance nominal Ø	h8
Point angle	118 degrees
Shank	Parallel shank to h8
Countersink angle	90 degrees
Shank tolerance	h8
Colour ring	without
Type of product	Stepped drill