

**Garant**
**Stub stepped drill HSS 90°, vaporised, for threads: M8**

**Order data**

Order number	117020 M8
GTIN	4045197035677
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: 6.8 mm

$\varnothing D_2$  2nd step with chamfer h8: 9 mm

Step height  $L_1$  1st step: 21 mm

Flute length  $L_c$ : 40 mm

Overall length L: 84 mm

Shank  $\varnothing D_s$ : 9 mm

**Technical description**

for threads	M8
Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.

Flute length $L_c$	40 mm
$\varnothing D_2$ 2nd step with chamfer h8	9 mm
$\varnothing D_1$ 1st step with chamfer h8	6.8 mm
Shank $\varnothing D_s$	9 mm
Overall length L	84 mm
No. of teeth Z	2
Through-coolant	no
Step height $L_1$ 1st step	21 mm
Coating	vaporised
Tool material	HSS
Standard	DIN 1897
Tolerance nominal $\varnothing$	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