

Garant
Subland drill HSS 90°, vaporised, for threads: M8

Order data

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|--------------|---------------|
| Order number | 117060 M8 |
| GTIN | 4045197035813 |
| Item class | 11C |

Description
Version:

Drill and counterbore each with its own chip flutes and guide chamfers. This means the profile of the stepped drill is retained even after repeated regrinding.

Application:

Tapping hole and countersink are produced **in one operation**, precisely aligned.

For drilling tapping holes to DIN 336 sheet 1 with 90° countersinking (similar to DIN 69, medium version).

No. of teeth Z: 2

Through-coolant: no

Ø D₁ 1st step with chamfer h9: 6.8 mm

Ø D₂ 2nd step with chamfer h8: 9 mm

Step height L₁ 1st step: 21 mm

Flute length L_c: 81 mm

Overall length L: 125 mm

Shank Ø D_s: 9 mm

Technical description

| | |
|---|-------------|
| Feed f in steel < 750 N/mm ² | 0.1 mm/rev. |
| Flute length L _c | 81 mm |
| for threads | M8 |
| Ø D ₁ 1st step with chamfer h9 | 6.8 mm |
| Ø D ₂ 2nd step with chamfer h8 | 9 mm |
| Shank Ø D _s | 9 mm |
| Overall length L | 125 mm |

| | |
|-------------------------------------|----------------------|
| No. of teeth Z | 2 |
| Through-coolant | no |
| Step height L ₁ 1st step | 21 mm |
| Coating | vaporised |
| Tool material | HSS |
| Standard | DIN 8378 |
| Tolerance nominal Ø | h9 |
| Point angle | 118 degrees |
| Shank | Parallel shank to h8 |
| Helix angle | 20-30 degrees |
| Countersink angle | 90 degrees |
| Shank tolerance | h8 |
| Colour ring | without |
| Type of product | Stepped drill |