

**Garant**
**Solid carbide stub stepped drill 90°, TiAlN, for threads: M8F**

**Order data**

Order number	125050 M8F
GTIN	4045197265579
Item class	11E

**Description**
**Version:**

**Very sturdy – step length to DIN 8378. Tight concentricity tolerances** between drill and counterbore  $\varnothing$  guarantee exact alignment.

**Application:**

**Particularly suitable for NC machines and automatic machines.** For drilling tapping holes to DIN 336 sheet 1 with 90° countersinking. In the following operation, the tap therefore does not have to cut into the sharp edge of the hole.

Sizes **F: Tapping holes** for the following **fluteless taps**.

No. of teeth Z: 2

Through-coolant: no

$\varnothing D_1$  1st step with chamfer h8: 7.45 mm

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

Step height  $L_1$  1st step: 21 mm

Flute length  $L_c$ : 47 mm

Overall length L: 89 mm

Shank  $\varnothing D_s$ : 10 mm

**Technical description**

Feed f in steel < 1100 N/mm <sup>2</sup>	0.11 mm/rev.
for threads	M8F
$\varnothing D_2$ 2nd step with chamfer h8	9 mm
$\varnothing D_1$ 1st step with chamfer h8	7.45 mm
Flute length $L_c$	47 mm
Shank $\varnothing D_s$	10 mm

Overall length L	89 mm
No. of teeth Z	2
Through-coolant	no
Step height L <sub>1</sub> 1st step	21 mm
Coating	TiAlN
Tool material	Solid carbide
Standard	DIN 8378
Type	N
Tolerance nominal Ø	h8
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Countersink angle	90 degrees
Shank tolerance	h6
Colour ring	without
Type of product	Stepped drill