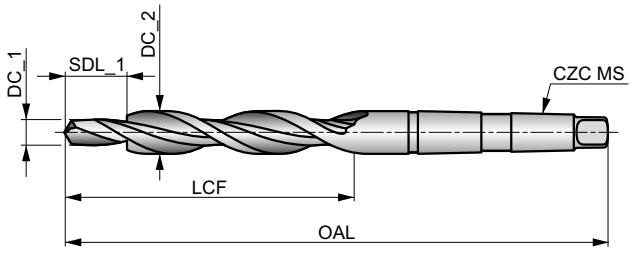
A405



HSS Taper Shank Subland Drill, Steam Tempered Finish

A versatile tool recommended for creating counterbored clearance holes for standard metric screws. A 118° Pilot and 180° counterbore. Suitable for both CNC and conventional machines. Steam tempered finish retains cutting fluid and prevents chip to tool welding. Suitable for drilling many materials.



HSS	DIN 8377	4×D
180°	ST	
λ20-35°	R	118°

Workpiece material group suitability, starting values for cutting speed (m/min) and feed Alpha Code. Tables with feed per revolution can be found starting from page 175.

P1.1	P1.2	P1.3	P2.1	P2.2	P2.3	P3.1	P3.2	P3.3	P4.1	P4.2	P4.3	M1.1	M1.2
■29 G	■33 G	■34 G	■25 G	■22 E	◪19 C	■15 E	■12 E	◪10 C	■9 E	◪7 C	◪6 C	◪22 E	◪19 E
M2.1	**M2.2**	**M3.1**	**M3.2**	**M3.3**	**M4.1**	**K1.1**	**K1.2**	**K1.3**	**K2.1**	**K2.2**	**K2.3**	**K3.1**	**K3.2**
◪20 E	◪16 E	◪10 G	◪9 G	◪8 G	◪12 C	■30 G	■22 E	■17 E	◪23 E	◪19 E	◪15 C	◪21 E	◪16 E
K3.3	**K4.1**	**K4.2**	**K4.3**	**K4.4**	**K4.5**	**K5.1**	**K5.2**	**K5.3**	**N1.1**	**N1.2**	**N1.3**	**N2.1**	**N2.2**
◪13 C	◪19 E	◪14 E	◪11 C	◪9 C	◪8 C	◪22 E	◪16 E	◪13 C	◪45 E	◪34 E	◪23 E	◪49 E	◪44 E
N2.3	**N3.1**	**N3.2**	**N3.3**	**N4.1**	**S1.1**	**S1.2**	**S1.3**	**S2.1**	**S2.2**	**S3.1**	**S3.2**	**S4.1**	**S4.2**
◪32 E	◪68 E	◪40 E	◪20 E	◪30 I	◪23 E	◪14 C	◪8 A	◪8 C	◪6 A	◪6 C	◪4 A	◪5 C	◪3 A

Product	TDZ	DC_1 (mm)	DC_1 (inch)	DC_2 (mm)	LCF (mm)	OAL (mm)	SDL_1 (mm)	CZC MS
A405M6	M6	6.60	0.2598	11.00	94.0	175.0	15.00	MK 1
A405M8	M8	9.00	0.3543	15.00	114.0	212.0	19.00	MK 2
A405M10	M10	11.00	0.4331	18.00	130.0	228.0	23.00	MK 2
A405M12	M12	13.50	0.5315	20.00	140.0	238.0	27.00	MK 2
A405M14	M14	15.50	0.6102	24.00	160.0	281.0	31.00	MK 3
A405M16	M16	17.50	0.6890	26.00	165.0	286.0	35.00	MK 3
A405M18	M18	20.00	0.7874	30.00	175.0	296.0	39.00	MK 3