

Garant
Stub drill with 3 clamping faces HSS-E, uncoated, Ø DC h8: 1 mm

Order data

Order number	113001 1
GTIN	4045197764690
Item class	11B

Description
Version:

Stable and sturdy stub drill with **strengthened core diameter**. Ground flutes, with high concentricity. Precision ground point.

Recommendation:
Maximum drilling depth:

$$L_2 = L_c - 1.5 \times D_c$$

Note:

Drills with plain shank, **without drive flats**.

Technical description

Shank Ø D _s	1 mm
Overall length L	26 mm
Feed f in steel < 900 N/mm ²	0.03 mm/rev.
Number of cutting edges Z	2
Flute length L _c	6 mm
Standard	DIN 1897
Tolerance nominal Ø	h8
Nominal Ø D _c	1 mm
recommended maximum drilling depth L ₂	4.5 mm
Point angle	130 degrees
Shank	Plain shank

Coating	uncoated
Tool material	HSS E
Type	N
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	70 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	45 m/min	N
Alu > 10% Si	suitable only under restricted conditions	40 m/min	N
Steel < 500 N/mm ²	suitable	40 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
Steel < 1100 N/mm ²	suitable	10 m/min	P
Steel < 1400 N/mm ²	suitable	8 m/min	P
INOX < 900 N/mm ²	suitable	12 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	8 m/min	M
GG(G)	suitable only under restricted conditions	25 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		

