

Garant
Stub drill HSS-E-PM HPC, TiAlN, Ø DC h8: 8,6mm

Order data

Order number	113280 8,6
GTIN	4062406232276
Item class	11B

Description
Version:

Tool made of sintered **powder metallurgy HSS** for heavy duty applications. Ground flutes with high concentricity. Generous flute profile.

With point geometry shape A/C from size 2.2 mm.

Advantage:

Can be used at increased cutting data.

Recommendation:
Maximum drilling depth:

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

Technical description

Number of cutting edges Z	2
Standard	DIN 1897
Flute length L_c	40 mm
Tolerance nominal \varnothing	h8
Nominal $\varnothing D_c$	8.6 mm
Overall length L	84 mm
Feed f in stainless steel < 900 N/mm ²	0.09 mm/rev.
Shank $\varnothing D_s$	8.6 mm
Point angle	130 degrees
recommended maximum drilling depth L_2	27.1 mm

Shank	Plain shank
Coating	TiAlN
Tool material	HSS E PM
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	80 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	70 m/min	N
Alu > 10% Si	suitable only under restricted conditions	60 m/min	N
Steel < 750 N/mm ²	suitable only under restricted conditions	50 m/min	P
Steel < 900 N/mm ²	suitable	40 m/min	P
Steel < 1100 N/mm ²	suitable	25 m/min	P
Steel < 1400 N/mm ²	suitable	14 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	20 m/min	M
INOX > 900 N/mm ²	suitable	15 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	12 m/min	S
GG(G)	suitable	50 m/min	K
CuZn	suitable only under restricted conditions	60 m/min	N
Oil	suitable		
wet maximum	suitable		

