

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

Order data

Order number	113265 8,6
GTIN	4062406235345
Item class	11B

Description
Version:

High concentricity and **special chip flutes** ensure precise bores.

With point geometry shape C from size 2.4 mm.

Advantage:

Ideal for drilling shallow holes (approx. 2 - 4×D) on NC machines and automatic machines.

Recommendation:
Maximum drilling depth:

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

Technical description

recommended maximum drilling depth L_2	27.1 mm
Feed f in stainless steel < 900 N/mm ²	0.09 mm/rev.
Shank Ø D_s	8.6 mm
Standard	DIN 1897
Tolerance nominal Ø	h8
Overall length L	84 mm
Point angle	118 degrees
Flute length L_c	40 mm
Number of cutting edges Z	2
Nominal Ø D_c	8.6 mm
Shank	Plain shank

Coating	TiAlN
Tool material	HSS E
Through-coolant	no
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	Suitable only under restricted conditions	75 m/min	N
Aluminium (short chipping)	Suitable only under restricted conditions	65 m/min	N
Alu > 10% Si	Suitable only under restricted conditions	60 m/min	N
Steel < 500 N/mm ²	suitable	50 m/min	P
Steel < 750 N/mm ²	suitable	40 m/min	P
Steel < 900 N/mm ²	suitable	35 m/min	P
Steel < 1100 N/mm ²	suitable	16 m/min	P
INOX < 900 N/mm ²	suitable	17 m/min	M
INOX > 900 N/mm ²	Suitable only under restricted conditions	13 m/min	M
Ti > 850 N/mm ²	Suitable only under restricted conditions	8 m/min	S
GG(G)	suitable	40 m/min	K
CuZn	suitable	50 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		