

Garant
Stub drill HSS-E, TiAlN, Ø DC h8: 12mm

Order data

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| Order number | 113265 12 |
| GTIN | 4062406235826 |
| 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

| | |
|---|--------------|
| Flute length L_c | 51 mm |
| Overall length L | 102 mm |
| Point angle | 118 degrees |
| recommended maximum drilling depth L_2 | 33 mm |
| Standard | DIN 1897 |
| Tolerance nominal \varnothing | h8 |
| Feed f in stainless steel < 900 N/mm ² | 0.13 mm/rev. |
| Number of cutting edges Z | 2 |
| Shank $\varnothing D_s$ | 12 mm |
| Nominal $\varnothing D_c$ | 12 mm |
| Shank | Plain shank |

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|-----------------|--------------|
| 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 | | |