

**Garant**
**Stub drill HSS-E, TiAlN, Ø DC h8: 6,4mm**

**Order data**

Order number	113265 6,4
GTIN	4062406234904
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 $L_c$	31 mm
recommended maximum drilling depth $L_2$	21.4 mm
Feed $f$ in stainless steel $< 900 \text{ N/mm}^2$	0.05 mm/rev.
Point angle	118 degrees
Overall length $L$	70 mm
Standard	DIN 1897
Nominal $\varnothing D_c$	6.4 mm
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	6.4 mm
Number of cutting edges $Z$	2
Shank	Plain shank

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

### User data

	Suitability	V <sub>c</sub>	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 <sup>2</sup>	suitable	50 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	35 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	16 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	17 m/min	M
INOX > 900 N/mm <sup>2</sup>	Suitable only under restricted conditions	13 m/min	M
Ti > 850 N/mm <sup>2</sup>	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		