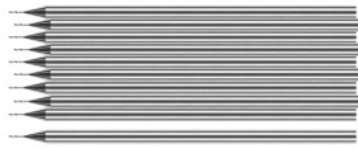


Garant
Micro drill set HSS-E-PM N, uncoated, Ø DC -0.004: 0,15mm

Order data

Order number	112305 0,15
GTIN	4067263732693
Item class	11A

Description
Version:

Special drill with reinforced shank, high concentricity and precision ground point.

Recommendation:
Maximum drilling depth:

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

Technical description

Shank	Plain shank with h8
Number of cutting edges Z	2
Number of drills	10
Shank Ø D _s	1 mm
Overall length L	25 mm
Feed f in steel < 900 N/mm ²	0.006 mm/rev.
Flute length L _c	1 mm
Nominal Ø D	0.15 mm
Coating	uncoated
Tool material	HSS E PM
Standard	DIN 1899 A

Type	N
Tolerance nominal \varnothing	0 / -0.004
Point angle	118 degrees
Through-coolant	no
Colour ring	without
Type of product	Twist Drill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	70 m/min	N
Aluminium (short chipping)	suitable	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	8 m/min	M
Ti > 850 N/mm ²	suitable	5 m/min	S
GG(G)	suitable only under restricted conditions	25 m/min	K
CuZn	suitable	80 m/min	N
Uni	suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		

