

**Garant**
**Micro drill set HSS-E-PM N, uncoated, Ø DC -0.004: 0,70mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 112305 0,70   |
| GTIN         | 4067263761136 |
| 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 drills                        | 5                   |
| Number of cutting edges Z               | 2                   |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.02 mm/rev.        |
| Shank Ø D <sub>s</sub>                  | 1 mm                |
| Flute length L <sub>c</sub>             | 5.6 mm              |
| Overall length L                        | 25 mm               |
| Nominal Ø D                             | 0.7 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 <sup>2</sup>  | suitable                                  | 40 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 30 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 25 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 10 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 8 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 12 m/min | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 8 m/min  | M        |
| Ti > 850 N/mm <sup>2</sup>     | 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                                  |          |          |

