

Garant
Solid carbide HPC micro-drill, TiAlN, Ø DC +0.004: 0,25mm

Order data

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|--------------|---------------|
| Order number | 121220 0,25 |
| GTIN | 4045197263889 |
| Item class | 11E |

Description
Version:

High performance miniature drill **with extra long flutes.**

Shank Ø 3 h6 for shrink-fit chucks.

High concentricity, precision ground for **HPC applications in steel.**

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Technical description

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|--|-------------------------|
| Number of cutting edges Z | 2 |
| Feed f in steel < 1100 N/mm ² | 0.01 mm/rev. |
| Flute length L_c | 3.5 mm |
| Shank tolerance | h6 |
| Nominal Ø D_c | 0.25 mm |
| Tolerance nominal Ø | 0 / 0.004 |
| Shank Ø D_s | 3 mm |
| Overall length L | 38 mm |
| Standard | Manufacturer's standard |
| recommended maximum drilling depth L_2 | 3.2 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |

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|--------------------|----------------------|
| Type | N |
| Point angle | 130 degrees |
| Shank | Parallel shank to h6 |
| Through-coolant | no |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | without |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Alu plastics | suitable only under restricted conditions | 200 m/min | N |
| Aluminium (short chipping) | suitable | 140 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 140 m/min | N |
| Steel < 500 N/mm ² | suitable | 70 m/min | P |
| Steel < 750 N/mm ² | suitable | 70 m/min | P |
| Steel < 900 N/mm ² | suitable | 70 m/min | P |
| Steel < 1100 N/mm ² | suitable | 55 m/min | P |
| Steel < 1400 N/mm ² | suitable | 35 m/min | P |
| Steel < 55 HRC | suitable only under restricted conditions | 25 m/min | H |
| INOX < 900 N/mm ² | suitable | 35 m/min | M |
| INOX > 900 N/mm ² | suitable | 30 m/min | M |
| Ti > 850 N/mm ² | suitable | 20 m/min | S |
| GG(G) | suitable | 90 m/min | K |
| CuZn | suitable | 140 m/min | N |
| Uni | suitable | | |

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|-------------|---|
| wet maximum | suitable |
| dry | suitable only under restricted conditions |