

**Garant**
**Stub drill HSS-E FS, uncoated, Ø DC h8: 8,6mm**


## Order data

Order number	113020 8,6
GTIN	4045197002655
Item class	11B

## Description

### Version:

Particularly **robust and strong** due to **strengthened core**.

Ground flutes, with high concentricity.

Bright finish flutes, nitrided lands.

With point geometry shape C up to 3.9 mm; shape S (special) from 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

Number of cutting edges Z	2
Nominal Ø D <sub>c</sub>	8.6 mm
Flute length L <sub>c</sub>	40 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.
Tolerance nominal Ø	h8
Shank Ø D <sub>s</sub>	8.6 mm
Overall length L	84 mm
Standard	DIN 1897
recommended maximum drilling depth L <sub>2</sub>	27.1 mm
Point angle	135 degrees

Shank	Plain shank
Coating	uncoated
Tool material	HSS E
Type	FS
Helix angle	38 degrees
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	70 m/min	N
Aluminium (short chipping)	suitable	45 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
GG(G)	suitable	25 m/min	K
Oil	suitable		
wet maximum	suitable		