

**Garant**
**HSS-E jobber drill, TiAlN, Ø DC h8: 1,8mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 114580 1,8    |
| GTIN         | 4045197855008 |
| Item class   | 11B           |

**Description**
**Version:**

High performance drills for outstanding performance. Precision holes due to optimised diamond point geometry and 4-face grinding. The special flute profile yields a significant reduction in cutting forces.

**Recommendation:**
**Maximum drilling depth:**

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

**Technical description**

|   |              |
|---|--------------|
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0.02 mm/rev. |
| Flute length L <sub>c</sub>                       | 22 mm        |
| recommended maximum drilling depth L <sub>2</sub> | 19.3 mm      |
| Standard  | DIN 338      |
| Tolerance nominal Ø                               | h8           |
| Number of cutting edges Z                         | 2            |
| Shank Ø D <sub>s</sub>                            | 1.8 mm       |
| Nominal Ø D <sub>c</sub>                          | 1.8 mm       |
| Overall length L                                  | 46 mm        |
| Point angle                                       | 118 degrees  |
| Shank   | Plain shank  |
| Coating   | TiAlN        |

|                 |              |
|-----------------|--------------|
| Tool material   | HSS E        |
| Helix angle     | 35 degrees   |
| 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                                  |                |          |