

**Garant**
**Stub drill HSS-Co8 FS, TiAlN, Ø DC h8: 1 mm**

**Order data**

Order number	113140 1
GTIN	4045197003164
Item class	11B

**Description**
**Version:**

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

Ground flutes, with high concentricity.

With point geometry shape S (special)

**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**

Flute length $L_c$	6 mm
Nominal $\varnothing D_c$	1 mm
Feed $f$ in steel $< 750 \text{ N/mm}^2$	0.03 mm/rev.
Number of cutting edges $Z$	2
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	1 mm
Overall length $L$	26 mm
Standard	DIN 1897
recommended maximum drilling depth $L_2$	4.5 mm
Point angle	130 degrees

Shank	Plain shank
Coating	TiAlN
Tool material	HSS Co 8
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 only under restricted conditions	87 m/min	N
Aluminium (short chipping)	suitable	56 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	35 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	15 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	10 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	6 m/min	S
Oil	suitable		
wet maximum	suitable		

