

Garant
Stub drill HSS-Co8 FS, TiAlN, Ø DC h8: 8,6mm

Order data

Order number	113140 8,6
GTIN	4045197003911
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	40 mm
Nominal $\varnothing D_c$	8.6 mm
Feed f in steel $< 750 \text{ N/mm}^2$	0.1 mm/rev.
Number of cutting edges Z	2
Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	8.6 mm
Overall length L	84 mm
Standard	DIN 1897
recommended maximum drilling depth L_2	27.1 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 _c	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 ²	suitable	50 m/min	P
Steel < 750 N/mm ²	suitable	35 m/min	P
Steel < 900 N/mm ²	suitable	30 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	15 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	10 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	6 m/min	S
Oil	suitable		
wet maximum	suitable		

