

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

**Order data**

Order number	113140 6,8
GTIN	4045197003751
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**

Feed f in steel < 750 N/mm <sup>2</sup>	0.07 mm/rev.
Number of cutting edges Z	2
Flute length L <sub>c</sub>	34 mm
Nominal Ø D <sub>c</sub>	6.8 mm
Tolerance nominal Ø	h8
Shank Ø D <sub>s</sub>	6.8 mm
Overall length L	74 mm
Standard	DIN 1897
recommended maximum drilling depth L <sub>2</sub>	23.8 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		

