

Garant
Stub drill HSS-Co8 FS, TiAlN, Ø DC h8: 8,3mm

Order data

| | |
|--------------|---------------|
| Order number | 113140 8,3 |
| GTIN | 4045197003881 |
| 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

| | |
|---|-------------|
| Nominal Ø D _c | 8.3 mm |
| Flute length L _c | 37 mm |
| Number of cutting edges Z | 2 |
| Feed f in steel < 750 N/mm ² | 0.1 mm/rev. |
| Tolerance nominal Ø | h8 |
| Shank Ø D _s | 8.3 mm |
| Overall length L | 79 mm |
| Standard | DIN 1897 |
| recommended maximum drilling depth L ₂ | 24.6 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 | | |

