

Garant
Stub drill HSS-E N, uncoated, Ø DC h8: 8,1mm

Order data

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|--------------|---------------|
| Order number | 113150 8,1 |
| GTIN | 4045197004826 |
| Item class | 11B |

Description
Version:

Particularly robust and strong due to strengthened core.

Ground flutes, with high concentricity.

Bright finish.

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

| | |
|---|-------------|
| Number of cutting edges Z | 2 |
| Feed f in steel < 900 N/mm ² | 0.1 mm/rev. |
| Nominal Ø D _c | 8.1 mm |
| Flute length L _c | 37 mm |
| Tolerance nominal Ø | h8 |
| Shank Ø D _s | 8.1 mm |
| Overall length L | 79 mm |
| Standard | DIN 1897 |
| recommended maximum drilling depth L ₂ | 24.9 mm |
| Point angle | 130 degrees |

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|-----------------|--------------|
| Shank | Plain shank |
| Coating | uncoated |
| Tool material | HSS E |
| Type | N |
| 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 | 80 m/min | N |
| Aluminium (short chipping) | suitable only under restricted conditions | 45 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 50 m/min | N |
| Steel < 500 N/mm ² | suitable | 40 m/min | P |
| Steel < 750 N/mm ² | suitable | 30 m/min | P |
| Steel < 900 N/mm ² | suitable | 25 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 10 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 8 m/min | P |
| INOX < 900 N/mm ² | suitable | 12 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 8 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 5 m/min | S |
| GG(G) | suitable | 25 m/min | K |
| CuZn | suitable only under restricted conditions | 80 m/min | N |

| | |
|-------------|----------|
| Uni | suitable |
| Oil | suitable |
| wet maximum | suitable |