

Garant
Stub drill HSS-E N, TiN, Ø DC h8: 1,85mm

Order data

Order number	113230 1,85
GTIN	4045197648310
Item class	11B

Description
Version:

Particularly robust and strong due to strengthened core.
Ground flutes, with high concentricity.

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	11 mm
Nominal $\varnothing D_c$	1.85 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.03 mm/rev.
Number of cutting edges Z	2
Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	1.85 mm
Overall length L	36 mm
Standard	DIN 1897
recommended maximum drilling depth L_2	8.2 mm
Point angle	130 degrees
Shank	Plain shank

Coating	TiN
Tool material	HSS E
Type	N
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable	50 m/min	P
Steel < 750 N/mm ²	suitable	37 m/min	P
Steel < 900 N/mm ²	suitable	31 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable	10 m/min	P
INOX < 900 N/mm ²	suitable	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
GG(G)	suitable	31 m/min	K
CuZn	suitable only under restricted conditions	100 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		