

Garant
Stub drill HSS-E, TiAlN, Ø DC h8: 3,5mm

Order data

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|--------------|---------------|
| Order number | 113260 3,5 |
| GTIN | 4045197006578 |
| Item class | 11B |

Description
Version:

High concentricity and **special chip flutes** ensure precise bores.

With point geometry shape C from size 2.4 mm

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 stainless steel $< 900 \text{ N/mm}^2$ | 0.02 mm/rev. |
| Flute length L_c | 20 mm |
| Number of cutting edges Z | 2 |
| Nominal $\varnothing D_c$ | 3.5 mm |
| Tolerance nominal \varnothing | h8 |
| Shank $\varnothing D_s$ | 3.5 mm |
| Overall length L | 52 mm |
| Standard | DIN 1897 |
| recommended maximum drilling depth L_2 | 14.8 mm |
| Point angle | 130 degrees |
| Shank | Plain shank |

| | |
|-----------------|--------------|
| Coating | TiAlN |
| Tool material | HSS E |
| Through-coolant | no |
| Colour ring | blue |
| Type of product | Jobber drill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Aluminium (short chipping) | suitable | 56 m/min | N |
| 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 only under restricted conditions | 31 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 12 m/min | P |
| INOX < 900 N/mm ² | suitable | 17 m/min | M |
| INOX > 900 N/mm ² | suitable | 13 m/min | M |
| Ti > 850 N/mm ² | suitable | 6 m/min | S |
| CuZn | suitable only under restricted conditions | 100 m/min | N |
| Oil | suitable | | |
| wet maximum | suitable | | |