

**Garant**
**Stub drill HSS-E, TiAlN, Ø DC h8: 2,7mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 113260 2,7    |
| GTIN         | 4045197006493 |
| 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**

|   |              |
|---|--------------|
| Number of cutting edges Z                         | 2            |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.02 mm/rev. |
| Flute length L <sub>c</sub>                       | 16 mm        |
| Nominal Ø D <sub>c</sub>                          | 2.7 mm       |
| Tolerance nominal Ø                               | h8           |
| Shank Ø D <sub>s</sub>                            | 2.7 mm       |
| Overall length L                                  | 46 mm        |
| Standard  | DIN 1897     |
| recommended maximum drilling depth L <sub>2</sub> | 12 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 <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping)     | suitable                                  | 56 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 50 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 37 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable only under restricted conditions | 31 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 12 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 17 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 13 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable                                  | 6 m/min        | S        |
| CuZn                           | suitable only under restricted conditions | 100 m/min      | N        |
| Oil                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |