

**Garant**
**Stub drill HSS-E, TiAlN, Ø DC h8: 6,8mm**

**Order data**

Order number	113260 6,8
GTIN	4045197006929
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**

Nominal Ø D <sub>c</sub>	6.8 mm
Flute length L <sub>c</sub>	34 mm
Number of cutting edges Z	2
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.05 mm/rev.
Tolerance nominal Ø	h8
Shank Ø D <sub>s</sub>	6.8 mm
Overall length L	74 mm
Standard	DIN 1897
recommended maximum drilling depth L <sub>2</sub>	23.8 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 <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		