

Garant
Stub drill HSS-E, TiAlN, Ø DC h8: 8,4mm

Order data

Order number	113260 8,4
GTIN	4045197007094
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

Flute length L_c	37 mm
Number of cutting edges Z	2
Nominal $\varnothing D_c$	8.4 mm
Feed f in stainless steel < 900 N/mm ²	0.09 mm/rev.
Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	8.4 mm
Overall length L	79 mm
Standard	DIN 1897
recommended maximum drilling depth L_2	24.4 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		