

Garant
Stub drill HSS-E-PM HPC, TiAlN, Ø DC h8: 9,3mm

Order data

| | |
|--------------|---------------|
| Order number | 113280 9,3 |
| GTIN | 4045197007674 |
| Item class | 11B |

Description
Version:

Tool made of sintered **powder metallurgy HSS** for heavy duty applications. Ground flutes with high concentricity. Generous flute profile.

With point geometry shape A/C from size 2.2 mm.

Advantage:

Can be used at increased cutting data.

Recommendation:
Maximum drilling depth:

$$L_2 = L_c - 1.5 \times D_c.$$

Technical description

| | |
|---|--------------|
| Number of cutting edges Z | 2 |
| Flute length L_c | 40 mm |
| Feed f in stainless steel < 900 N/mm ² | 0.09 mm/rev. |
| Nominal Ø D_c | 9.3 mm |
| Tolerance nominal Ø | h8 |
| Shank Ø D_s | 9.3 mm |
| Overall length L | 84 mm |
| Standard | DIN 1897 |
| recommended maximum drilling depth L_2 | 26.1 mm |
| Point angle | 130 degrees |

| | |
|--------------------|--------------|
| Shank | Plain shank |
| Coating | TiAlN |
| Tool material | HSS E PM |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | green |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Alu plastics | suitable only under restricted conditions | 80 m/min | N |
| Aluminium (short chipping) | suitable only under restricted conditions | 70 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 60 m/min | N |
| Steel < 750 N/mm ² | suitable only under restricted conditions | 50 m/min | P |
| Steel < 900 N/mm ² | suitable | 40 m/min | P |
| Steel < 1100 N/mm ² | suitable | 25 m/min | P |
| Steel < 1400 N/mm ² | suitable | 14 m/min | P |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 20 m/min | M |
| INOX > 900 N/mm ² | suitable | 15 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 12 m/min | S |
| GG(G) | suitable | 50 m/min | K |
| CuZn | suitable only under restricted conditions | 60 m/min | N |
| Oil | suitable | | |
| wet maximum | suitable | | |

