

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

**Order data**

Order number	113280 3,3
GTIN	4045197007452
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**

Nominal Ø $D_c$	3.3 mm
Flute length $L_c$	18 mm
Number of cutting edges $Z$	2
Feed $f$ in stainless steel < 900 N/mm <sup>2</sup>	0.02 mm/rev.
Tolerance nominal Ø	h8
Shank Ø $D_s$	3.3 mm
Overall length $L$	49 mm
Standard	DIN 1897
recommended maximum drilling depth $L_2$	13.1 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 <sub>c</sub>	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 <sup>2</sup>	suitable only under restricted conditions	50 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	14 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	20 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	15 m/min	M
Ti > 850 N/mm <sup>2</sup>	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		

