

Garant
Micro drill HSS-E-PM N, uncoated, Ø DC -0.004: 0,25mm

Order data

Order number	112300 0,25
GTIN	4045197001610
Item class	11A

Description
Version:

Special drill with reinforced shank, high concentricity and precision ground point.

Recommendation:
Maximum drilling depth:

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

Through-coolant: no

Standard: DIN 1899 A

Tolerance nominal Ø: 0 / -0.004

Point angle: 118 °

Shank: Parallel shank to h8

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 1.9 mm

Flute length L_c : 2.2 mm

Overall length L: 25 mm

Shank Ø D_s : 1 mm

Feed f in steel < 900 N/mm²: 0.009 mm/rev.

Technical description

Feed f in steel < 900 N/mm ²	0.009 mm/rev.
Nominal Ø D_c	0.25 mm
Shank tolerance	h8
Flute length L_c	2.2 mm
Number of cutting edges Z	2
Tolerance nominal Ø	0 / -0.004

Shank Ø D _s	1 mm
Overall length L	25 mm
Standard	DIN 1899 A
recommended maximum drilling depth L ₂	1.9 mm
Point angle	118 °
Shank	Parallel shank to h8
Coating	uncoated
Tool material	HSS E PM
Type	N
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	70 m/min	N
Aluminium (short chipping)	suitable	45 m/min	N
Alu > 10% Si	suitable only under restricted conditions	40 m/min	N
Steel < 500 N/mm ²	suitable	40 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
Steel < 1100 N/mm ²	suitable	10 m/min	P
Steel < 1400 N/mm ²	suitable	8 m/min	P
INOX < 900 N/mm ²	suitable	12 m/min	M
INOX > 900 N/mm ²	suitable	8 m/min	M
Ti > 850 N/mm ²	suitable	5 m/min	S
GG(G)	suitable only under restricted conditions	25 m/min	K

CuZn	suitable	80 m/min	N
Uni	suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		