

Garant**Stub drill with 3 clamping faces HSS-E, uncoated, Ø DC h8: 18mm****Order data**

Order number	113001 18
GTIN	4062406230647
Item class	11B

Description**Version:**

Stable and sturdy stub drill with **strengthened core diameter**. Ground flutes, with high concentricity. Precision ground point.

Recommendation:**Maximum drilling depth:**

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

Note:

Three **drive flats on the shank** for use in a 3-jaw chuck.
Shank Ø 12.5mm.

Technical description

recommended maximum drilling depth L_2	35 mm
Shank Ø D_s	12.5 mm
Standard	DIN 1897
Flute length L_c	62 mm
Nominal Ø D_c	18 mm
Feed f in steel < 900 N/mm ²	0.2 mm/rev.
Number of cutting edges Z	2
Tolerance nominal Ø	h8
Point angle	130 degrees
Overall length L	123 mm

Shank	Three drive flats shank
Coating	uncoated
Tool material	HSS E
Type	N
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	70 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	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 only under restricted conditions	8 m/min	M
GG(G)	suitable only under restricted conditions	25 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		

