Garant

Solid carbide HPC micro-drill, TiAlN, ⌀ DC +0.004: 1,5mm

Order data

Order number	121220 1,5
GTIN	4045197264459
Item class	11E

Description

Version:
High performance miniature drill **with extra long flutes.**
Shank ⌀ 3 h6 for shrink-fit chucks.
High concentricity, precision ground for **HPC applications in steel.**
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.

Technical description

Nominal ⌀ D_C	1.5 mm
Feed f in steel < 1100 N/mm^2	0.04 mm/rev.
Number of cutting edges Z	2
Shank tolerance	h6
Flute length L_c	10.5 mm
Tolerance nominal ⌀	0 / 0.004
Shank ⌀ D_s	3 mm
Overall length L	38 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	8.3 mm
Coating	TiAlN
Tool material	Solid carbide

Type	N
Point angle	130 degrees
Shank	Parallel shank to h6
Through-coolant	no
Machining strategy	HPC
Semi-Standard	yes
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable only under restricted conditions	200 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable only under restricted conditions	140 m/min	N
Steel < 500 N/mm²	suitable	70 m/min	P
Steel < 750 N/mm²	suitable	70 m/min	P
Steel < 900 N/mm²	suitable	70 m/min	P
Steel < 1100 N/mm²	suitable	55 m/min	P
Steel < 1400 N/mm²	suitable	35 m/min	P
Steel < 55 HRC	suitable only under restricted conditions	25 m/min	H
INOX < 900 N/mm²	suitable	35 m/min	M
INOX > 900 N/mm²	suitable	30 m/min	M
Ti > 850 N/mm²	suitable	20 m/min	S
GG(G)	suitable	90 m/min	K
CuZn	suitable	140 m/min	N
Uni	suitable		

wet maximum	suitable
dry	suitable only under restricted conditions