

**Garant****Stub drill HSS-E N, TiN, Ø DC h8: 8,6mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 113230 8,6    |
| GTIN         | 4045197005908 |
| Item class   | 11B           |

**Description****Version:**

Particularly robust and strong due to strengthened core.

Ground flutes, with high concentricity.

**Advantage:**

**Ideal for drilling shallow holes (approx. 2 - 4×D) on NC machines and automatic machines.**

**Recommendation:****Maximum drilling depth:**

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

**Technical description**

|                                                   |             |
|---------------------------------------------------|-------------|
| Nominal Ø D <sub>c</sub>                          | 8.6 mm      |
| Number of cutting edges Z                         | 2           |
| Flute length L <sub>c</sub>                       | 40 mm       |
| Feed f in steel < 900 N/mm <sup>2</sup>           | 0.1 mm/rev. |
| Tolerance nominal Ø                               | h8          |
| Shank Ø D <sub>s</sub>                            | 8.6 mm      |
| Overall length L                                  | 84 mm       |
| Standard                                          | DIN 1897    |
| recommended maximum drilling depth L <sub>2</sub> | 27.1 mm     |
| Point angle                                       | 130 degrees |
| Shank                                             | Plain shank |

|                 |              |
|-----------------|--------------|
| Coating         | TiN          |
| Tool material   | HSS E        |
| Type            | N            |
| Through-coolant | no           |
| Colour ring     | without      |
| Type of product | Jobber drill |

## User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|-------------------------------------------|----------------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 50 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 37 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 31 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 12 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 10 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 15 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 10 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable only under restricted conditions | 6 m/min        | S        |
| GG(G)                          | suitable                                  | 31 m/min       | K        |
| CuZn                           | suitable only under restricted conditions | 100 m/min      | N        |
| Uni                            | suitable                                  |                |          |
| Oil                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |