

**Garant****Stub drill HSS-E N, uncoated, Ø DC h8: 5,4mm**

## Order data

|              |               |
|--------------|---------------|
| Order number | 113150 5,4    |
| GTIN         | 4045197004536 |
| Item class   | 11B           |

## Description

**Version:**

Particularly robust and strong due to strengthened core.

Ground flutes, with high concentricity.

Bright finish.

**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

|                                          |              |
|------------------------------------------|--------------|
| Flute length $L_c$                       | 28 mm        |
| Nominal $\varnothing D_c$                | 5.4 mm       |
| Feed $f$ in steel $< 900 \text{ N/mm}^2$ | 0.05 mm/rev. |
| Number of cutting edges $Z$              | 2            |
| Tolerance nominal $\varnothing$          | h8           |
| Shank $\varnothing D_s$                  | 5.4 mm       |
| Overall length $L$                       | 66 mm        |
| Standard                                 | DIN 1897     |
| recommended maximum drilling depth $L_2$ | 19.9 mm      |
| Point angle                              | 130 degrees  |

|                 |              |
|-----------------|--------------|
| Shank           | Plain shank  |
| Coating         | uncoated     |
| 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 |
|--------------------------------|-------------------------------------------|----------------|----------|
| Alu plastics                   | suitable only under restricted conditions | 80 m/min       | N        |
| Aluminium (short chipping)     | suitable only under restricted conditions | 45 m/min       | N        |
| Alu > 10% Si                   | suitable only under restricted conditions | 50 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 40 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 30 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 25 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 10 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 8 m/min        | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 12 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 8 m/min        | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable only under restricted conditions | 5 m/min        | S        |
| GG(G)                          | suitable                                  | 25 m/min       | K        |
| CuZn                           | suitable only under restricted conditions | 80 m/min       | N        |

|             |          |
|-------------|----------|
| Uni         | suitable |
| Oil         | suitable |
| wet maximum | suitable |