

**Garant**
**Stub drill HSS-E-PM HPC, TiAlN, Ø DC h8: 12 mm**

**Order data**

Order number	113280 12
GTIN	4045197007773
Item class	11B

**Description**
**Version:**

Tool made of sintered **powder metallurgy HSS** for heavy duty applications. Ground flutes with high concentricity. Generous flute profile.

With point geometry shape A/C from size 2.2 mm.

**Advantage:**

Can be used at increased cutting data.

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

flute length (see table) less 1.5×nominal Ø.

Machining strategy: HPC

Standard: DIN 1897

Tolerance nominal Ø: h8

Point angle: 130 degrees

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 33 mm

Flute length  $L_c$ : 51 mm

Overall length L: 102 mm

Shank Ø  $D_s$ : 12 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.13 mm/rev.

**Technical description**

Nominal Ø $D_c$	12 mm
Number of cutting edges Z	2
Flute length $L_c$	51 mm
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.13 mm/rev.

Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	12 mm
Overall length L	102 mm
Standard	DIN 1897
recommended maximum drilling depth $L_2$	33 mm
Point angle	130 degrees
Coating	TiAlN
Tool material	HSS E PM
Shank	Plain shank
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill