

Garant**Value pack TiAlN-coated stub drills HSS-E, 10 pieces****Order data**

Order number	GG1115 8
GTIN	4069515044554
Item class	GGN

Description**Version:**

High concentricity and **special chip flutes** ensure precise bores.

With point geometry shape C from size 2.4 mm.

Same as No. 113265.

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

Number of cutting edges Z	2
Shank $\varnothing D_s$	8 mm
Tolerance nominal $\varnothing$	h8
Point angle	118 degrees
Flute length L_c	37 mm
Standard	DIN 1897
Overall length L	79 mm

Data sheet

Contents	10
Feed f in stainless steel < 900 N/mm ²	0.09 mm/rev.
recommended maximum drilling depth L ₂	25 mm
Shank	Plain shank
Nominal Ø D _c	8 mm
Coating	TiAlN
Tool material	HSS E
Through-coolant	no
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	75 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	65 m/min	N
Alu > 10% Si	suitable only under restricted conditions	60 m/min	N
Steel < 500 N/mm ²	suitable	50 m/min	P
Steel < 750 N/mm ²	suitable	40 m/min	P
Steel < 900 N/mm ²	suitable	35 m/min	P
Steel < 1100 N/mm ²	suitable	16 m/min	P
INOX < 900 N/mm ²	suitable	17 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	13 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	8 m/min	S
GG(G)	suitable	40 m/min	K
CuZn	suitable	50 m/min	N

Uni	suitable
Oil	suitable
wet maximum	suitable

Suitable products

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