

Garant

Jobber drill extra long HSS N, uncoated, Ø DC h8 × overall length L: 8,5X240mm



Order data

| | |
|--------------|----------------|
| Order number | 116245 8,5X240 |
| GTIN | 4045197745989 |
| Item class | 11B |

Description

Version:

With precision ground point.

Vaporised high performance drills for drilling particularly deep holes. Take particular care to ensure **frequent chip clearance**.

Recommendation:

Maximum drilling depth:

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

Note:

Suitable NC spotting drills No. 112103, 112110 and 112160 with **120° tip angle** for enhanced process reliability

Technical description

| | |
|---|-------------|
| Tolerance nominal Ø | h8 |
| Overall length L | 240 mm |
| Shank Ø D _s | 8.5 mm |
| Feed f in steel < 750 N/mm ² | 0.1 mm/rev. |
| Number of cutting edges Z | 2 |
| Flute length L _c | 165 mm |
| Nominal Ø D _c | 8.5 mm |
| Standard | DIN 1869 |
| recommended maximum drilling depth L ₂ | 152.3 mm |

| | |
|-----------------|--------------|
| Point angle | 118 degrees |
| Shank | Plain shank |
| Coating | uncoated |
| Tool material | HSS |
| Type | N |
| Helix angle | 38 degrees |
| Through-coolant | no |
| Colour ring | without |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Alu plastics | suitable only under restricted conditions | 50 m/min | N |
| Aluminium (short chipping) | suitable only under restricted conditions | 32 m/min | N |
| Steel < 500 N/mm ² | suitable | 28 m/min | P |
| Steel < 750 N/mm ² | suitable | 21 m/min | P |
| Steel < 900 N/mm ² | suitable | 18 m/min | P |
| Steel < 1100 N/mm ² | suitable | 5 m/min | P |
| GG(G) | suitable | 18 m/min | K |
| Oil | suitable | | |
| wet maximum | suitable | | |