

**Garant**
**Solid carbide jobber drill, uncoated, Ø DC h7: 8,5mm**

**Order data**

Order number	122250 8,5
GTIN	4045197042002
Item class	11E

**Description**
**Version:**
**Similar to DIN 338.**

Nominal Ø and shank Ø equal.

**Note:**

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Non slip clamping in drill chuck No. 341050 with diamond coated jaws.

**Technical description**

Shank tolerance	h7
Nominal Ø $D_c$	8.5 mm
Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.11 mm/rev.
Flute length $L_c$	75 mm
Number of cutting edges $Z$	2
Tolerance nominal Ø	h7
Shank Ø $D_s$	8.5 mm
Overall length $L$	117 mm
Standard	DIN 338
recommended maximum drilling depth $L_2$	62.3 mm
Coating	uncoated
Tool material	Solid carbide

Type	N
Point angle	118 degrees
Helix angle	30 degrees
Shank	Parallel shank to h7
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	200 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable only under restricted conditions	140 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	25 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	20 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	20 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	15 m/min	S
CuZn	suitable	140 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		

dry

suitable only under  
restricted conditions