

## Garant

### Jobber drill extra long HSS N, uncoated, Ø DC h8 × overall length L: 8,5X390mm



#### Order data

Order number	116245 8,5X390
GTIN	4062406264772
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

Overall length L	390 mm
Tolerance nominal Ø	h8
Point angle	118 degrees
Flute length L <sub>c</sub>	265 mm
Number of cutting edges Z	2
recommended maximum drilling depth L <sub>2</sub>	252.3 mm
Standard	DIN 1869
Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.
Shank Ø D <sub>s</sub>	8.5 mm

Nominal $\varnothing D_c$	8.5 mm
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 <sup>2</sup>	suitable	28 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	21 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	18 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	5 m/min	P
GG(G)	suitable	18 m/min	K
Oil	suitable		
wet maximum	suitable		