

Garant**Jobber drill, extra long HSS-E FS, uncoated, Ø DC h8 × overall length L:
8X390mm****Order data**

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|--------------|---------------|
| Order number | 116250 8X390 |
| GTIN | 4062406266011 |
| Item class | 11B |

Description**Version:**

With precision ground point.

Special 4-chamfer relief ground for very good guidance within the bore. Bright finish flutes, nitrided chamfers.

With point geometry shape C.

Advantage:

Special deep hole drills. For particularly deep or recessed holes. Good chip evacuation due to parabolic flutes, resulting in fewer chip evacuations even in particularly deep holes.

Recommendation:**Maximum drilling depth:**

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

Note:

Suitable NC spotting drills No. 112120, 112140 and 112170 with **142° tip angle** for enhanced process reliability

Technical description

| | |
|---|-------------|
| Overall length L | 390 mm |
| Feed f in steel < 750 N/mm ² | 0.1 mm/rev. |
| Number of cutting edges Z | 2 |
| Nominal Ø D _c | 8 mm |
| Shank Ø D _s | 8 mm |
| recommended maximum drilling depth L ₂ | 253 mm |

| | |
|---------------------------------|--------------|
| Standard | DIN 1869 |
| Point angle | 130 degrees |
| Flute length L_c | 265 mm |
| Tolerance nominal \varnothing | h8 |
| Shank | Plain shank |
| Coating | uncoated |
| Tool material | HSS E |
| Type | FS |
| 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 | 55 m/min | N |
| Aluminium (short chipping) | suitable only under restricted conditions | 30 m/min | N |
| Steel < 500 N/mm ² | suitable | 32 m/min | P |
| Steel < 750 N/mm ² | suitable | 25 m/min | P |
| Steel < 900 N/mm ² | suitable | 20 m/min | P |
| Steel < 1100 N/mm ² | suitable | 5 m/min | P |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 8 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 4 m/min | M |
| GG(G) | suitable only under restricted conditions | 20 m/min | K |
| Oil | suitable | | |

wet maximum

suitable