⚡ Hoffmann Group

Garant

Jobber drill, extra long HSS-E FS, uncoated, ∅ DC h8 × overall length L: 4X220mm

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Order data

Order number	116250 4X220
GTIN	4062406265816
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

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Technical description

Shank ∅ D_s	4 mm
Standard	DIN 1869
recommended maximum drilling depth L_2	144 mm
Nominal ∅ D_C	4 mm
Number of cutting edges Z	2
Flute length L_c	150 mm

Point angle	130 degrees
Tolerance nominal Ø	h8
Feed f in steel < 750 N/mm^2	0.05 mm/rev.
Overall length L	220 mm
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/mm²	suitable	32 m/min	P
Steel < 750 N/mm²	suitable	25 m/min	P
Steel < 900 N/mm²	suitable	20 m/min	P
Steel < 1100 N/mm²	suitable	5 m/min	P
INOX < 900 N/mm²	suitable only under restricted conditions	8 m/min	M
INOX > 900 N/mm²	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