

## Garant

### Jobber drill, extra long HSS-E FS, uncoated, Ø DC h8 × overall length L: 8,5X240mm



#### Order data

Order number	116250 8,5X240
GTIN	4062406266028
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

Shank Ø D <sub>s</sub>	8.5 mm
Overall length L	240 mm
recommended maximum drilling depth L <sub>2</sub>	152.3 mm
Tolerance nominal Ø	h8
Number of cutting edges Z	2
Nominal Ø D <sub>c</sub>	8.5 mm

Standard	DIN 1869
Flute length $L_c$	165 mm
Point angle	130 degrees
Feed $f$ in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.
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 <sup>2</sup>	suitable	32 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	20 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	5 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	8 m/min	M
INOX > 900 N/mm <sup>2</sup>	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