

Garant
Jobber drill with stepped tip HSS N, uncoated, Ø DC h8: 8,5mm

Order data

Order number	114004 8,5
GTIN	4062406877507
Item class	11Q

Description
Version:

Chamfers are nitrided. Particularly sturdy and robust due to the **strengthened core diameter**. Ground flutes, with high concentricity. Precision ground point. Three **drive flats on the shank** for use in a 3-jaw chuck.

- **Ideal for producing precise holes in sheet metal, pipes, and profiles.**
- **Reliable spot drilling without centring or centre punching – even on curved surfaces – thanks to innovative ground point.**
- **Oblique drilling possible without any problems after the first level of the drill tip has penetrated the material.**
- **Drilling with significantly less force required than with conventional DIN338 HSS drills – up to a diameter of 13 mm directly in the cordless drill/driver.**
- **Stable and secure form fit in the 3-jaw chuck.**
- **General use across a wide spectrum of materials including plastic, wood and acrylic without tearing or splintering.**
- **The drill does not rattle or dig in – even in the case of thin-walled materials.**
- **Burr-free drill exit.**
- **Ideal for drilling out bolts and rivets.**

Recommendation:
Maximum drilling depth:

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

Technical description

Standard	DIN 338
Tolerance nominal Ø	h8
recommended maximum drilling depth L_2	62.3 mm

Feed f in steel < 750 N/mm ²	0.16 mm/rev.
Number of cutting edges Z	2
Nominal Ø D _c	8.5 mm
Flute length L _c	75 mm
Point angle	118 degrees
Overall length L	117 mm
Shank Ø D _s	8.5 mm
Shank	Three drive flats shank
Coating	uncoated
Tool material	HSS
Type	N
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	70 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	70 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm ²	suitable	30 m/min	P
Steel < 750 N/mm ²	suitable	27 m/min	P
Steel < 900 N/mm ²	suitable	22 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	10 m/min	P
GG(G)	suitable	25 m/min	K

CuZn	suitable only under restricted conditions
Oil	suitable
wet maximum	suitable