

**Garant**
**HSS-E jobber drill, TiAlN, Ø DC h8: 3,9mm**

**Order data**

Order number	114580 3,9
GTIN	4045197855213
Item class	11B

**Description**
**Version:**

High performance drills for outstanding performance. Precision holes due to optimised diamond point geometry and 4-face grinding. The special flute profile yields a significant reduction in cutting forces.

**Recommendation:**
**Maximum drilling depth:**

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

**Technical description**

Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.02 mm/rev.
Tolerance nominal Ø	h8
Overall length L	75 mm
Shank Ø D <sub>s</sub>	3.9 mm
Flute length L <sub>c</sub>	43 mm
recommended maximum drilling depth L <sub>2</sub>	37.2 mm
Nominal Ø D <sub>c</sub>	3.9 mm
Standard	DIN 338
Number of cutting edges Z	2
Point angle	118 degrees
Shank	Plain shank
Coating	TiAlN

Tool material	HSS E
Helix angle	35 degrees
Through-coolant	no
Colour ring	green
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable only under restricted conditions	75 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	65 m/min	N
Alu > 10% Si	suitable only under restricted conditions	60 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	35 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	16 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	17 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	13 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	8 m/min	S
GG(G)	suitable	40 m/min	K
CuZn	suitable	50 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		