

Garant
Jobber drill HSS-E-PM HPC, TiAlN, Ø DC h8: 2,4mm

Order data

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|--------------|---------------|
| Order number | 114610 2,4 |
| GTIN | 4045197856081 |
| Item class | 11B |

Description
Version:

High-performance HPC twist drills for high-alloy and high tensile materials. Particularly strong due to **strengthened core and a parabolic flute profile**. Point geometry with rake angle correction. Precise concentricity for exact holes.

With form S point.

Recommendation:
Maximum drilling depth:

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

Technical description

| | |
|--|--------------|
| recommended maximum drilling depth L_2 | 26.4 mm |
| Overall length L | 57 mm |
| Nominal $\varnothing D_c$ | 2.4 mm |
| Tolerance nominal \varnothing | h8 |
| Standard | DIN 338 |
| Number of cutting edges Z | 2 |
| Feed f in steel < 900 N/mm ² | 0.03 mm/rev. |
| Shank $\varnothing D_s$ | 2.4 mm |
| Flute length L_c | 30 mm |
| Point angle | 130 degrees |
| Shank | Plain shank |

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|--------------------|--------------|
| Coating | TiAlN |
| Tool material | HSS E PM |
| Helix angle | 38 degrees |
| Through-coolant | no |
| Machining strategy | HPC |
| Colour ring | green |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Alu plastics | suitable only under restricted conditions | 80 m/min | N |
| Aluminium (short chipping) | suitable only under restricted conditions | 70 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 60 m/min | N |
| Steel < 750 N/mm ² | suitable only under restricted conditions | 50 m/min | P |
| Steel < 900 N/mm ² | suitable | 40 m/min | P |
| Steel < 1100 N/mm ² | suitable | 25 m/min | P |
| Steel < 1400 N/mm ² | suitable | 14 m/min | P |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 20 m/min | M |
| INOX > 900 N/mm ² | suitable | 15 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 12 m/min | S |
| GG(G) | suitable | 50 m/min | K |
| CuZn | suitable only under restricted conditions | 60 m/min | N |
| Uni | suitable | | |
| Oil | suitable | | |

wet maximum

suitable