

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

Order data

| | |
|--------------|---------------|
| Order number | 114610 4,4 |
| GTIN | 4045197856289 |
| 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

| | |
|---|--------------|
| Shank Ø D _s | 4.4 mm |
| Overall length L | 80 mm |
| Standard | DIN 338 |
| Tolerance nominal Ø | h8 |
| Nominal Ø D _c | 4.4 mm |
| Flute length L _c | 47 mm |
| Feed f in steel < 900 N/mm ² | 0.05 mm/rev. |
| recommended maximum drilling depth L ₂ | 40.4 mm |
| Number of cutting edges Z | 2 |
| Point angle | 130 degrees |
| Shank | Plain shank |

| | |
|--------------------|--------------|
| 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