

**Garant**
**Jobber drill HSS-E-PM HPC, TiAlN, Ø DC h8: 8,5mm**

**Order data**

Order number	114610 8,5
GTIN	4045197856692
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**

Tolerance nominal Ø	h8
Standard	DIN 338
Overall length L	117 mm
Shank Ø D <sub>s</sub>	8.5 mm
recommended maximum drilling depth L <sub>2</sub>	62.3 mm
Flute length L <sub>c</sub>	75 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.11 mm/rev.
Nominal Ø D <sub>c</sub>	8.5 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 <sub>c</sub>	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 <sup>2</sup>	suitable only under restricted conditions	50 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	14 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	20 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	15 m/min	M
Ti > 850 N/mm <sup>2</sup>	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