

**Garant**
**HSS core drill N, uncoated, Ø DC h8: 22mm**


## Order data

Order number	116620 22
GTIN	4045197033833
Item class	11C

## Description

**Version:**

Strong core. Sturdy jobber drill for better guidance in the hole

**Advantage:**

Particularly suitable **for drilling out** holes that are out of round. Misaligned holes can be aligned.

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

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

**Note:**
**Please note:**

Do not drill the respective tapping hole Ø (see table) less than the stated size.

For suitable reducing adapters for tools with MT shanks see **No. 343000-343530**.

## Technical description

recommended maximum drilling depth $L_2$	117 mm
Number of cutting edges Z	3
Standard	DIN 343
Overall length L	248 mm
Nominal Ø $D_c$	22 mm
Flute length $L_c$	150 mm
Tolerance nominal Ø	h8
Morse taper MT size	2
Feed f in steel < 750 N/mm <sup>2</sup>	0.22 mm/rev.

Min. pre-drilling - $\varnothing$ D <sub>min</sub>	15.3 mm
Point angle	120 degrees
Shank	Morse taper
Coating	uncoated
Tool material	HSS
Type	N
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	45 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	10 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	8 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	12 m/min	M
GG(G)	suitable only under restricted conditions	25 m/min	K
wet maximum	suitable		