

Garant
Jobber drill long HSS W, uncoated, Ø DC h8: 8,5mm

Order data

| | |
|--------------|---------------|
| Order number | 116040 8,5 |
| GTIN | 4045197025890 |
| Item class | 11B |

Description
Version:

With point geometry shape A from size 2.5 mm.

Strengthened core **without core taper**. Precision ground point. Wide flutes with heavily honed back edges. Bright ground surface finish.

Advantage:

For deep hole drilling and for use with drill bushings.

Recommendation:
Maximum drilling depth:

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

Note:

Suitable NC spotting drills No. 112120, 112140 and 112170 with **142° tip angle** for enhanced process reliability.

Technical description

| | |
|---|--------------|
| Nominal Ø D _c | 8.5 mm |
| Number of cutting edges Z | 2 |
| Flute length L _c | 109 mm |
| Feed f in aluminium short-chipping | 0.18 mm/rev. |
| Tolerance nominal Ø | h8 |
| Shank Ø D _s | 8.5 mm |
| Overall length L | 165 mm |
| Standard | DIN 340 |
| recommended maximum drilling depth L ₂ | 96.3 mm |

| | |
|-----------------|---------------|
| Point angle | 130 degrees |
| Shank | Plain shank |
| Coating | uncoated |
| Tool material | HSS |
| Type | W |
| Helix angle | 30-40 degrees |
| Through-coolant | no |
| Colour ring | yellow |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|----------------------------|---|----------------|----------|
| Alu plastics | suitable | 70 m/min | N |
| Aluminium (short chipping) | suitable | 45 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 40 m/min | N |
| Oil | suitable | | |
| wet maximum | suitable | | |