

## Garant

### Jobber drill, long, HSS-E VA, uncoated, Ø DC h8: 8,4mm



#### Order data

Order number	116070 8,4
GTIN	4045197027832
Item class	11B

#### Description

##### Version:

Profile ground. Standard core thickness and core taper. Bright finish.  
With point geometry shape C.

##### Advantage:

For drilling with drill bushes or long reach applications.

##### 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

Flute length $L_c$	109 mm
Number of cutting edges $Z$	2
Feed $f$ in stainless steel < 900 N/mm <sup>2</sup>	0.08 mm/rev.
Nominal Ø $D_c$	8.4 mm
Tolerance nominal Ø	h8
Shank Ø $D_s$	8.4 mm
Overall length $L$	165 mm
Standard	DIN 340
recommended maximum drilling depth $L_2$	96.4 mm

Point angle	130 degrees
Shank	Plain shank
Coating	uncoated
Tool material	HSS E
Helix angle	35-40 degrees
Through-coolant	no
Colour ring	blue
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	40 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	20 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	12 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	8 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	5 m/min	S
Oil	suitable		
wet maximum	suitable		