

Garant

Jobber drill, extra long HSS-E FS, TiAlN, Ø DC h8 × overall length L: 8,5X240mm



Order data

| | |
|--------------|----------------|
| Order number | 116280 8,5X240 |
| GTIN | 4045197029232 |
| Item class | 11B |

Description

Version:

With point geometry shape C.

Advantage:

Particularly suitable for drilling under difficult conditions, e.g. insufficient cooling of the cutting edges due to poor chip evacuation.

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

| | |
|---|-------------|
| Feed f in steel < 750 N/mm ² | 0.1 mm/rev. |
| Nominal Ø D _c | 8.5 mm |
| Flute length L _c | 165 mm |
| Number of cutting edges Z | 2 |
| Tolerance nominal Ø | h8 |
| Shank Ø D _s | 8.5 mm |
| Overall length L | 240 mm |
| Standard | DIN 1869 |

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|--|--------------|
| recommended maximum drilling depth L_2 | 152.3 mm |
| Point angle | 135 degrees |
| Shank | Plain shank |
| Coating | TiAlN |
| Tool material | HSS E |
| Type | FS |
| Helix angle | 38 degrees |
| Through-coolant | no |
| Colour ring | without |
| Type of product | Jobber drill |

User data

| | Suitability | V_c | ISO code |
|-------------------------------|---|----------|----------|
| Alu plastics | suitable only under restricted conditions | 60 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 38 m/min | N |
| Steel < 500 N/mm ² | suitable | 38 m/min | P |
| Steel < 750 N/mm ² | suitable | 28 m/min | P |
| Steel < 900 N/mm ² | suitable | 22 m/min | P |
| Oil | suitable | | |
| wet maximum | suitable | | |