

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

Order data

Order number	114200 8,5
GTIN	4045197015938
Item class	11B

Description
Version:

Standard core without core taper.
 Precision ground point.
 Ground flute with high helix.
 Bright ground surface finish.
 With point geometry shape A from size 2.0 mm.

Recommendation:
Maximum drilling depth:

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

Technical description

Nominal Ø D_c	8.5 mm
Flute length L_c	75 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h8
Shank Ø D_s	8.5 mm
Overall length L	117 mm
Feed f in long-chipping aluminium plastics	0.18 mm/rev.
Standard	DIN 338
recommended maximum drilling depth L_2	62.3 mm
Point angle	130 degrees
Shank	Plain shank

Coating	uncoated
Tool material	HSS
Type	W
Helix angle	35-40 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		