

Garant
HSS jobber drill N, uncoated, Ø DC h8: 27mm

Order data

| | |
|--------------|---------------|
| Order number | 116340 27 |
| GTIN | 4045197030702 |
| Item class | 11C |

Description
Version:

Special surface treatment, resulting in reduced tendency to edge build-up **and improved chip evacuation.**

Top quality high performance twist drills.

Cutting edge section ≤ 26.5 mm Ø ground from solid, > 26.5 mm Ø milled. This ensures high concentricity and pitch accuracy, and precision ground point up to 40 mm Ø.

With shape A point.

Recommendation:
Maximum drilling depth:

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

Note:

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

Technical description

| | |
|---|--------------|
| Nominal Ø D_c | 27 mm |
| Flute length L_c | 170 mm |
| Number of cutting edges Z | 2 |
| Feed f in steel < 750 N/mm ² | 0.25 mm/rev. |
| Tolerance nominal Ø | h8 |
| Overall length L | 291 mm |
| Morse taper MT size | 3 |
| Standard | DIN 345 |

| | |
|---|---------------|
| recommended maximum drilling depth L ₂ | 129.5 mm |
| Point angle | 118 degrees |
| Shank | Morse taper |
| Coating | uncoated |
| Tool material | HSS |
| Type | N |
| Helix angle | 20-30 degrees |
| Through-coolant | no |
| Colour ring | without |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|-------------------------------|---|----------------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 45 m/min | N |
| Steel < 500 N/mm ² | suitable | 40 m/min | P |
| Steel < 750 N/mm ² | suitable | 30 m/min | P |
| Steel < 900 N/mm ² | suitable | 25 m/min | P |
| GG(G) | suitable | 25 m/min | K |
| Oil | suitable | | |
| wet maximum | suitable | | |