

Garant**Jobber drill HSS N, uncoated, Ø DC h8: 19mm****Order data**

Order number	116340 19
GTIN	4045197030429
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

Number of cutting edges Z	2
Feed f in steel < 750 N/mm ²	0.2 mm/rev.
Nominal Ø D _c	19 mm
Flute length L _c	135 mm
Tolerance nominal Ø	h8
Overall length L	233 mm
Morse taper MT size	2
Standard	DIN 345

Data sheet

recommended maximum drilling depth L_2	106.5 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		