

Garant
HSS jobber drill N, uncoated, Ø DC h8: 27,5mm

Order data

Order number	116340 27,5
GTIN	4045197030719
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

Flute length L_c	170 mm
Number of cutting edges Z	2
Nominal Ø D_c	27.5 mm
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	128.8 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		