

**Garant**
**HSS jobber drill N, uncoated, Ø DC h8: 22mm**

**Order data**

Order number	116340 22
GTIN	4045197030542
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  $\leq 26.5$  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.**

Through-coolant: no

Standard: DIN 345

Tolerance nominal Ø: h8

Point angle: 118 °

Shank: Morse taper

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 117 mm

Flute length  $L_c$ : 150 mm

Overall length L: 248 mm

Morse taper MT size: 2

Feed f in steel  $< 750$  N/mm<sup>2</sup>: 0.2 mm/rev.

**Technical description**

Nominal Ø $D_c$	22 mm
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Number of cutting edges Z	2
Flute length $L_c$	150 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.2 mm/rev.
Tolerance nominal $\varnothing$	h8
Overall length L	248 mm
Morse taper MT size	2
Standard	DIN 345
recommended maximum drilling depth $L_2$	117 mm
Point angle	118°
Shank	Morse taper
Coating	uncoated
Tool material	HSS
Type	N
Helix angle	20-30°
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 <sup>2</sup>	suitable	40 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	25 m/min	P
GG(G)	suitable	25 m/min	K
Oil	suitable		
wet maximum	suitable		

