

Garant
Jobber drill HSS-E N, uncoated, Ø DC h8: 8,6mm

Order data

Order number	114400 8,6
GTIN	4045197018014
Item class	11B

Description
Version:

Profile ground: this ensures high concentricity and pitch accuracy. Precision ground point. Drill for production use.

Reinforced core, bright finish.

With point geometry shape C from size 2 mm

Recommendation:
Maximum drilling depth:

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

Technical description

Number of cutting edges Z	2
Nominal Ø D _c	8.6 mm
Flute length L _c	81 mm
Feed f in steel < 750 N/mm ²	0.1 mm/rev.
Tolerance nominal Ø	h8
Shank Ø D _s	8.6 mm
Overall length L	125 mm
Standard	DIN 338
recommended maximum drilling depth L ₂	68.1 mm
Point angle	130 degrees
Shank	Plain shank

Coating	uncoated
Tool material	HSS E
Type	N
Through-coolant	no
Colour ring	red
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
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
Steel < 1100 N/mm ²	suitable	10 m/min	P
Steel < 1400 N/mm ²	suitable	8 m/min	P
TOOLOX 33	suitable	8 m/min	H
INOX < 900 N/mm ²	suitable	12 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	8 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	5 m/min	S
GG(G)	suitable	25 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		