

**Garant**
**Jobber drill HSS-E, uncoated, Ø DC h8: 3,1 mm**

**Order data**

Order number	114400 3,1
GTIN	4045197017468
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:**

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

Through-coolant: no

Standard: DIN 338

Tolerance nominal Ø: h8

Point angle: 130 °

Shank: Plain shank

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 31.4 mm

Flute length  $L_c$ : 36 mm

Overall length L: 65 mm

Shank Ø  $D_s$ : 3.1 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.03 mm/rev.

**Technical description**

Nominal Ø $D_c$	3.1 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.03 mm/rev.
Flute length $L_c$	36 mm
Number of cutting edges Z	2

Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	3.1 mm
Overall length L	65 mm
Standard	DIN 338
recommended maximum drilling depth $L_2$	31.4 mm
Point angle	130°
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 <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
Steel < 1100 N/mm <sup>2</sup>	suitable	10 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	8 m/min	P
TOOLOX 33	suitable	8 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	12 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	8 m/min	M
Ti > 850 N/mm <sup>2</sup>	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