

Garant
Jobber drill HSS-E VA, uncoated, Ø DC h8: 22mm

Order data

Order number	116360 22
GTIN	4045197032157
Item class	11C

Description
Version:
With strengthened core.

Specially treated surface, reducing edge build up and improving chip evacuation.
With point geometry shape C.

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	150 mm
Nominal $\varnothing D_c$	22 mm
Number of cutting edges Z	2
Feed f in steel < 750 N/mm ²	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	135 degrees

Shank	Morse taper
Coating	uncoated
Tool material	HSS E
Type	INOX
Helix angle	35-40 degrees
Through-coolant	no
Colour ring	without
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
INOX < 900 N/mm ²	suitable	12 m/min	M
Ti > 850 N/mm ²	suitable	5 m/min	S
GG(G)	suitable	25 m/min	K
CuZn	suitable	80 m/min	N
Oil	suitable		
wet maximum	suitable		