

**Garant**
**Jobber drill extra long HSS FS, uncoated, Ø DC h8: 19R1mm**

**Order data**

Order number	116720 19R1
GTIN	4045197034953
Item class	11C

**Description**
**Version:**

High concentricity.

**Large section parabolic flutes;** strong due to strengthened core thickness (without core taper).

≤ 16 mm Ø: Bright finish flutes, nitrided lands; > 16 mm Ø: Specially treated surface.

Special sturdy drills **for extremely deep holes.** Up to approx. 15×Ø without drill withdrawal.

With point geometry shape A.

**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 $L_c$	245 mm
Number of cutting edges Z	2
Nominal Ø $D_c$	19 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.2 mm/rev.
Tolerance nominal Ø	h8
Overall length L	370 mm
Morse taper MT size	2
Standard	DIN 1870 R1
recommended maximum drilling depth $L_2$	216.5 mm

Point angle	130 degrees
Shank	Morse taper
Coating	uncoated
Tool material	HSS
Type	FS
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	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
Oil	suitable		
wet maximum	suitable		