

Garant
Jobber drill long HSS N, uncoated, Ø DC h8: 27mm

Order data

Order number	116700 27
GTIN	4045197034489
Item class	11C

Description
Version:

Compared to DIN 345 the flute length is longer by the drill bushing height. Thus the effective drilling depth is unaffected. Special surface treatment for improved chip evacuation.

With point geometry shape A.

Advantage:

For drilling through drill bushings in tool making, machine building and series production. Particularly important for drilling into uneven, inclined or arched surfaces.

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

Nominal Ø D _c	27 mm
Feed f in steel < 750 N/mm ²	0.25 mm/rev.
Number of cutting edges Z	2
Flute length L _c	222 mm
Tolerance nominal Ø	h8
Overall length L	343 mm
Morse taper MT size	3
Standard	DIN 341

recommended maximum drilling depth L_2	181.5 mm
Point angle	118 degrees
Shank	Morse taper
Coating	uncoated
Tool material	HSS
Type	N
Helix angle	16-30 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
GG(G)	suitable	25 m/min	K
Oil	suitable		
wet maximum	suitable		