

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

Order data

| | |
|--------------|---------------|
| Order number | 116760 19R1 |
| GTIN | 4045197035479 |
| Item class | 11C |

Description
Version:

High concentricity. Core thickness and core taper are standard.

Special surface treatment.

Precision ground point. When drilling deep holes, evacuate chips from the hole frequently, and ensure adequate cooling.

Economy version with standard flutes.

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

| | |
|---|-------------|
| Nominal Ø D _c | 19 mm |
| Feed f in steel < 750 N/mm ² | 0.2 mm/rev. |
| Flute length L _c | 245 mm |
| Number of cutting edges Z | 2 |
| 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 | 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 | | |