Garant

Jobber drill extra long HSS N, uncoated, ⌀ DC h8: 22R1mm

Order data

Order number	116760 22R1
GTIN	4045197035530
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 ⌀ D_C	22 mm
Number of cutting edges Z	2
Flute length L_c	270 mm
Feed f in steel < 750 N/mm^2	0.2 mm/rev.
Tolerance nominal ⌀	h8
Overall length L	405 mm
Morse taper MT size	2
Standard	DIN 1870 R1
recommended maximum drilling depth L_2	237 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/mm²	suitable	40 m/min	P
Steel < 750 N/mm²	suitable	30 m/min	P
Steel < 900 N/mm²	suitable	25 m/min	P
GG(G)	suitable	25 m/min	K
Oil	suitable		
wet maximum	suitable		