

Garant
Jobber drill extra long HSS N, uncoated, Ø DC h8: 22R2mm

Order data

| | |
|--------------|---------------|
| Order number | 116760 22R2 |
| GTIN | 4045197035547 |
| 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

| | |
|---|-------------|
| Feed f in steel < 750 N/mm ² | 0.2 mm/rev. |
| Number of cutting edges Z | 2 |
| Flute length L _c | 345 mm |
| Nominal Ø D _c | 22 mm |
| Tolerance nominal Ø | h8 |
| Overall length L | 515 mm |
| Morse taper MT size | 2 |
| Standard | DIN 1870 R2 |
| recommended maximum drilling depth L ₂ | 312 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 | | |