

Garant
Jobber drill HSS-E FS, uncoated, Ø DC h8: 8,5mm

Order data

Order number	114450 8,5
GTIN	4045197019042
Item class	11B

Description
Version:

Profile ground: this ensures high concentricity and pitch accuracy. Precision ground point. Drill for production use.

Strengthened core.

Bright finish **parabolic flutes**, from 3 mm nitrided chamfers.

With point geometry shape C up to size 3.9 mm

With point geometry shape S from size 4 mm

Recommendation:
Maximum drilling depth:

$$L_2 = L_c - 1.5 \times D_c.$$

Technical description

Number of cutting edges Z	2
Flute length L_c	75 mm
Nominal $\varnothing D_c$	8.5 mm
Feed f in steel < 750 N/mm ²	0.1 mm/rev.
Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	8.5 mm
Overall length L	117 mm
Standard	DIN 338
recommended maximum drilling depth L_2	62.3 mm
Point angle	130 degrees

Shank	Plain shank
Coating	uncoated
Tool material	HSS E
Type	FS
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable	70 m/min	N
Aluminium (short chipping)	suitable	45 m/min	N
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 only under restricted conditions	25 m/min	P
GG(G)	suitable	25 m/min	K
Oil	suitable		
wet maximum	suitable		