

Garant
Jobber drill HSS-E FS, uncoated, Ø DC h8: 8,6mm

Order data

| | |
|--------------|---------------|
| Order number | 114450 8,6 |
| GTIN | 4045197019059 |
| 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

| | |
|---|-------------|
| Nominal Ø D _c | 8.6 mm |
| Feed f in steel < 750 N/mm ² | 0.1 mm/rev. |
| Number of cutting edges Z | 2 |
| Flute length L _c | 81 mm |
| Tolerance nominal Ø | h8 |
| Shank Ø D _s | 8.6 mm |
| Overall length L | 125 mm |
| Standard | DIN 338 |
| recommended maximum drilling depth L ₂ | 68.1 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 | | |