

Garant
Jobber drill HSS-E H, uncoated, Ø DC h8: 4mm

Order data

| | |
|--------------|---------------|
| Order number | 114470 4 |
| GTIN | 4045197019394 |
| Item class | 11B |

Description
Version:

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

Strengthened core, bright, **flute length to DIN 1897, overall length DIN 338.**

Also for **HARDOX materials.**

With point geometry shape C.

Recommendation:
Maximum drilling depth:

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

Technical description

| | |
|--|--------------|
| Flute length L_c | 22 mm |
| Nominal $\varnothing D_c$ | 4 mm |
| Feed f in steel $< 750 \text{ N/mm}^2$ | 0.05 mm/rev. |
| Number of cutting edges Z | 2 |
| Tolerance nominal \varnothing | h8 |
| Shank $\varnothing D_s$ | 4 mm |
| Overall length L | 75 mm |
| Standard | DIN 338 |
| recommended maximum drilling depth L_2 | 16 mm |
| Point angle | 135 degrees |

| | |
|-----------------|--------------|
| Shank | Plain shank |
| Coating | uncoated |
| Tool material | HSS E |
| Type | H |
| Through-coolant | no |
| Colour ring | pink |
| Type of product | Jobber drill |

User data

| | Suitability | V_c | ISO code |
|-------------------------------------|---|----------|----------|
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 10 m/min | P |
| Steel < 1400 N/mm ² | suitable | 8 m/min | P |
| HARDOX 500 < 1600 N/mm ² | suitable | 6 m/min | H |
| INOX < 900 N/mm ² | suitable | 12 m/min | M |
| INOX > 900 N/mm ² | suitable | 8 m/min | M |
| Ti > 850 N/mm ² | suitable | 5 m/min | S |
| Oil | suitable | | |
| wet maximum | suitable | | |