

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

Order data

Order number	114470 8,5
GTIN	4045197019493
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	37 mm
Feed f in steel $< 750 \text{ N/mm}^2$	0.1 mm/rev.
Number of cutting edges Z	2
Nominal $\varnothing D_c$	8.5 mm
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	24.3 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		