

**Garant**
**HSS-E jobber drill, TiAlN, Ø DC h8: 8,6mm**

**Order data**

Order number	114500 8,6
GTIN	4045197020314
Item class	11B

**Description**
**Version:**
**Strengthened core taper.**

With point geometry shape C.

**Recommendation:**
**Maximum drilling depth:**

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

**Technical description**

Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.09 mm/rev.
Number of cutting edges Z	2
Flute length L <sub>c</sub>	81 mm
Nominal Ø D <sub>c</sub>	8.6 mm
Tolerance nominal Ø	h8
Shank Ø D <sub>s</sub>	8.6 mm
Overall length L	125 mm
Standard	DIN 338
recommended maximum drilling depth L <sub>2</sub>	68.1 mm
Point angle	130 degrees
Shank	Plain shank
Coating	TiAlN

Tool material	HSS E
Helix angle	35 degrees
Through-coolant	no
Colour ring	blue
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	37 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	31 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	15 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	12 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	6 m/min	S
Oil	suitable		
wet maximum	suitable		