

**Garant**
**HSS-E jobber drill, TiAlN, Ø DC h8: 4,2mm**

**Order data**

Order number	114500 4,2
GTIN	4045197019875
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**

Flute length $L_c$	43 mm
Number of cutting edges Z	2
Nominal $\varnothing D_c$	4.2 mm
Feed f in stainless steel $> 900 \text{ N/mm}^2$	0.03 mm/rev.
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	4.2 mm
Overall length L	75 mm
Standard	DIN 338
recommended maximum drilling depth $L_2$	36.7 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		