

**Garant**
**HSS-Co8 jobber drill, TiAlN, Ø DC h8: 8,4mm**

**Order data**

Order number	114550 8,4
GTIN	4045197021335
Item class	11B

**Description**
**Version:**

**Extremely high heat resistance, very robust** due to **strong core**.

With point geometry shape C.

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

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

**Technical description**

Flute length $L_c$	75 mm
Feed $f$ in stainless steel $> 900 \text{ N/mm}^2$	0.09 mm/rev.
Nominal $\varnothing D_c$	8.4 mm
Number of cutting edges $Z$	2
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	8.4 mm
Overall length $L$	117 mm
Standard	DIN 338
recommended maximum drilling depth $L_2$	62.4 mm
Point angle	135 degrees
Shank	Plain shank
Coating	TiAlN

Tool material	HSS Co 8
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	31 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	10 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	20 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	15 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	6 m/min	S
Oil	suitable		
wet maximum	suitable		