

Garant**HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 0,25****Order data**

| | |
|--------------|---------------|
| Order number | 114150 0,25 |
| GTIN | 4045197302304 |
| Item class | 11B |

Description**Version:**

Profile ground: Jobber drill with high pitch accuracy and concentricity as well as precision ground point.

Steam tempered from Ø 2.4 mm.

With point geometry shape C from size 4 mm

Recommendation:**Maximum drilling depth:**

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

Note:

Size 16 - 20: Drills with shank Ø 16 mm.

Technical description

| | |
|---|--------------|
| Feed f in steel < 750 N/mm ² | 0.03 mm/rev. |
| Number of cutting edges Z | 2 |
| Flute length L _c | 3 mm |
| Nominal Ø D _c | 0.25 mm |
| Tolerance nominal Ø | h8 |
| Shank Ø D _s | 0.25 mm |
| Overall length L | 19 mm |
| Standard | DIN 338 |
| recommended maximum drilling depth L ₂ | 2.6 mm |
| Point angle | 118 degrees |

| | |
|-----------------|--------------|
| Shank | Plain shank |
| Coating | uncoated |
| Tool material | HSS |
| Type | N |
| Through-coolant | no |
| Colour ring | without |
| Type of product | Jobber drill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|----------|----------|
| Alu plastics | suitable only under restricted conditions | 80 m/min | N |
| Aluminium (short chipping) | suitable only under restricted conditions | 45 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 50 m/min | N |
| Steel < 500 N/mm ² | suitable | 40 m/min | P |
| Steel < 750 N/mm ² | suitable | 30 m/min | P |
| Steel < 900 N/mm ² | suitable | 25 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 10 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 8 m/min | P |
| GG(G) | suitable | 25 m/min | K |
| CuZn | suitable | 80 m/min | N |
| Oil | suitable | | |
| wet maximum | suitable | | |