Garant

HSS jobber drill N, uncoated, ∅ DC h8 (mm or inch): 19/64

Order data

Order number	114150 19/64
GTIN	4045197364388
Item class	11B

Description

Version:
Profile ground: Jobber drill with high pitch accuracy and concentricity as well as precision ground point.
Steam tempered from ∅ 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 ∅ 16 mm.

Technical description

Flute length L_c	75 mm
Feed f in steel < 750 N/mm^2	0.07 mm/rev.
Number of cutting edges Z	2
Inch nominal ∅ corresponds to	7.54 mm
Tolerance nominal ∅	h8
Shank ∅ D_s	7.54 mm
Overall length L	117 mm
Standard	DIN 338
recommended maximum drilling depth L_2	63.7 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/mm²	suitable	40 m/min	P
Steel < 750 N/mm²	suitable	30 m/min	P
Steel < 900 N/mm²	suitable	25 m/min	P
Steel < 1100 N/mm²	suitable only under restricted conditions	10 m/min	P
Steel < 1400 N/mm²	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		