

**Garant**
**HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 8,6**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 114150 8,6    |
| GTIN         | 4045197013347 |
| 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**

|   |             |
|---|-------------|
| Nominal Ø D <sub>c</sub>                          | 8.6 mm      |
| Feed f in steel < 750 N/mm <sup>2</sup>           | 0.1 mm/rev. |
| Number of cutting edges Z                         | 2           |
| Flute length L <sub>c</sub>                       | 81 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                                       | 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 <sub>c</sub> | 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 <sup>2</sup>  | suitable                                  | 40 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 30 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 25 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 10 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | 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                                  |                |          |