

Garant
Jobber drill, long, HSS-E VA, uncoated, Ø DC h8: 8,6mm

Order data

Order number	116070 8,6
GTIN	4045197027856
Item class	11B

Description
Version:

Profile ground. Standard core thickness and core taper. Bright finish.
With point geometry shape C.

Advantage:

For drilling with drill bushes or long reach applications.

Recommendation:
Maximum drilling depth:

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

Note:

Suitable NC spotting drills No. 112120, 112140 and 112170 with **142° tip angle** for enhanced process reliability.

Technical description

Number of cutting edges Z	2
Nominal Ø D _c	8.6 mm
Flute length L _c	115 mm
Feed f in stainless steel < 900 N/mm ²	0.08 mm/rev.
Tolerance nominal Ø	h8
Shank Ø D _s	8.6 mm
Overall length L	175 mm
Standard	DIN 340
recommended maximum drilling depth L ₂	102.1 mm

Point angle	130 degrees
Shank	Plain shank
Coating	uncoated
Tool material	HSS E
Helix angle	35-40 degrees
Through-coolant	no
Colour ring	blue
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	40 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	20 m/min	P
INOX < 900 N/mm ²	suitable	12 m/min	M
INOX > 900 N/mm ²	suitable	8 m/min	M
Ti > 850 N/mm ²	suitable	5 m/min	S
Oil	suitable		
wet maximum	suitable		