

Garant

Jobber drill, extra long HSS-E FS, TiAlN, Ø DC h8 × overall length L: 8X390mm



Order data

Order number	116280 8X390
GTIN	4045197029225
Item class	11B

Description

Version:

With point geometry shape C.

Advantage:

Particularly suitable for drilling under difficult conditions, e.g. insufficient cooling of the cutting edges due to poor chip evacuation.

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

Flute length L_c	265 mm
Nominal $\varnothing D_c$	8 mm
Number of cutting edges Z	2
Feed f in steel < 750 N/mm ²	0.1 mm/rev.
Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	8 mm
Overall length L	390 mm
Standard	DIN 1869
recommended maximum drilling depth L_2	253 mm

Point angle	135 degrees
Shank	Plain shank
Coating	TiAlN
Tool material	HSS E
Type	FS
Helix angle	38 degrees
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	60 m/min	N
Alu > 10% Si	suitable only under restricted conditions	38 m/min	N
Steel < 500 N/mm ²	suitable	38 m/min	P
Steel < 750 N/mm ²	suitable	28 m/min	P
Steel < 900 N/mm ²	suitable	22 m/min	P
Oil	suitable		
wet maximum	suitable		