

Garant
HSS-E jobber drill, TiAlN, Ø DC h8: 8,5mm

Order data

Order number	114580 8,5
GTIN	4045197855671
Item class	11B

Description
Version:

High performance drills for outstanding performance. Precision holes due to optimised diamond point geometry and 4-face grinding. The special flute profile yields a significant reduction in cutting forces.

Recommendation:
Maximum drilling depth:

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

Technical description

Flute length L_c	75 mm
Feed f in stainless steel $> 900 \text{ N/mm}^2$	0.09 mm/rev.
recommended maximum drilling depth L_2	62.3 mm
Nominal $\varnothing D_c$	8.5 mm
Overall length L	117 mm
Shank $\varnothing D_s$	8.5 mm
Tolerance nominal \varnothing	h8
Standard	DIN 338
Number of cutting edges Z	2
Point angle	118 degrees
Shank	Plain shank
Coating	TiAlN

Tool material	HSS E
Helix angle	35 degrees
Through-coolant	no
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	75 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	65 m/min	N
Alu > 10% Si	suitable only under restricted conditions	60 m/min	N
Steel < 500 N/mm ²	suitable	50 m/min	P
Steel < 750 N/mm ²	suitable	40 m/min	P
Steel < 900 N/mm ²	suitable	35 m/min	P
Steel < 1100 N/mm ²	suitable	16 m/min	P
INOX < 900 N/mm ²	suitable	17 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	13 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	8 m/min	S
GG(G)	suitable	40 m/min	K
CuZn	suitable	50 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		