

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

Order number	114500 8,5
GTIN	4045197020307
Item class	11B

Description**Version:****Strengthened core taper.**

With point geometry shape C.

Recommendation:**Maximum drilling depth:**

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

Technical description

Flute length L_c	75 mm
Nominal $\varnothing D_c$	8.5 mm
Feed f in stainless steel $> 900 \text{ N/mm}^2$	0.09 mm/rev.
Number of cutting edges Z	2
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	8.5 mm
Overall length L	117 mm
Standard	DIN 338
recommended maximum drilling depth L_2	62.3 mm
Point angle	130 degrees
Shank	Plain shank
Coating	TiAlN

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

User data

	Suitability	V _c	ISO code
Steel < 750 N/mm ²	suitable only under restricted conditions	37 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	31 m/min	P
INOX < 900 N/mm ²	suitable	15 m/min	M
INOX > 900 N/mm ²	suitable	12 m/min	M
Ti > 850 N/mm ²	suitable	6 m/min	S
Oil	suitable		
wet maximum	suitable		