

Garant

Jobber drill, long, HSS-E N, uncoated, Ø DC h8: 9mm



Order data

| | |
|--------------|---------------|
| Order number | 116065 9 |
| GTIN | 4045197270764 |
| Item class | 11B |

Description

Version:

Profile ground. Standard core thickness and core taper. Bright finish.
With point geometry shape AC from 2 mm.

Advantage:

For drilling with drill bushes or long reach applications.
For high-tensile tempered steels, **including TOOLOX**.

Recommendation:

Maximum drilling depth:

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

Note:

Suitable NC spotting drills No. 112103, 112110 and 112160 with **120° tip angle** for enhanced process reliability

Technical description

| | |
|--|--------------|
| Number of cutting edges Z | 2 |
| Flute length L_c | 115 mm |
| Feed f in steel < 1100 N/mm ² | 0.08 mm/rev. |
| Nominal Ø D_c | 9 mm |
| Tolerance nominal Ø | h8 |
| Shank Ø D_s | 9 mm |
| Overall length L | 175 mm |
| Standard | DIN 340 |
| recommended maximum drilling depth L_2 | 101.5 mm |

| | |
|-----------------|---------------|
| Point angle | 118 degrees |
| Shank | Plain shank |
| Coating | uncoated |
| Tool material | HSS E |
| Type | N |
| Helix angle | 35-40 degrees |
| Through-coolant | no |
| Colour ring | red |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 750 N/mm ² | suitable | 30 m/min | P |
| Steel < 900 N/mm ² | suitable | 25 m/min | P |
| Steel < 1100 N/mm ² | suitable | 10 m/min | P |
| Steel < 1400 N/mm ² | suitable | 8 m/min | P |
| TOOLOX 33 | suitable | 8 m/min | H |
| TOOLOX 44 | suitable | 5 m/min | H |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 12 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 8 m/min | M |
| CuZn | suitable only under restricted conditions | 80 m/min | N |
| Oil | suitable | | |
| wet maximum | suitable | | |