

Garant
Jobber drill HSS-E-PM HPC, TiAlN, Ø DC h8: 1,8 mm

Order data

Order number	114610 1,8
GTIN	4045197856029
Item class	11B

Description
Version:

With form S point.

High-performance HPC twist drills for high-alloy and high tensile materials. Particularly strong due to **strengthened core and a parabolic flute profile**. Point geometry with rake angle correction. Precise concentricity for exact holes.

Recommendation:
Maximum drilling depth:

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

Machining strategy: HPC

Standard: DIN 338

Tolerance nominal Ø: h8

Point angle: 130 degrees

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 19.3 mm

Flute length L_c : 22 mm

Overall length L: 46 mm

Shank Ø D_s : 1.8 mm

Feed f in steel < 900 N/mm²: 0.03 mm/rev.

Technical description

Shank Ø D_s	1.8 mm
Tolerance nominal Ø	h8
Feed f in steel < 900 N/mm ²	0.03 mm/rev.
recommended maximum drilling depth L_2	19.3 mm
Number of cutting edges Z	2

Nominal $\varnothing D_c$	1.8 mm
Overall length L	46 mm
Standard	DIN 338
Flute length L_c	22 mm
Point angle	130 degrees
Coating	TiAlN
Tool material	HSS E PM
Helix angle	38 degrees
Shank	Plain shank
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill