

**Garant**
**Jobber drill HSS-E-PM HPC, TiAlN, Ø DC h8: 3,6 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 114610 3,6    |
| GTIN         | 4045197856203 |
| 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  $L_2$ : 33.6 mm

Flute length  $L_c$ : 39 mm

Overall length L: 70 mm

Shank Ø  $D_s$ : 3.6 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.03 mm/rev.

**Technical description**

|                                          |              |
|------------------------------------------|--------------|
| Shank Ø $D_s$                            | 3.6 mm       |
| Standard                                 | DIN 338      |
| Number of cutting edges Z                | 2            |
| Feed f in steel < 900 N/mm <sup>2</sup>  | 0.03 mm/rev. |
| recommended maximum drilling depth $L_2$ | 33.6 mm      |

|                             |              |
|-----------------------------|--------------|
| Nominal Ø D <sub>c</sub>    | 3.6 mm       |
| Tolerance nominal Ø         | h8           |
| Overall length L            | 70 mm        |
| Flute length L <sub>c</sub> | 39 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 |