

Garant
Jobber drill HSS-E-PM HPC, TiAlN, Ø DC h8: 8,4 mm

Order data

Order number	114610 8,4
GTIN	4045197856685
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 : 62.4 mm

Flute length L_c : 75 mm

Overall length L: 117 mm

Shank Ø D_s : 8.4 mm

Feed f in steel < 900 N/mm²: 0.11 mm/rev.

Technical description

Tolerance nominal Ø	h8
Overall length L	117 mm
Feed f in steel < 900 N/mm ²	0.11 mm/rev.
Shank Ø D_s	8.4 mm
Nominal Ø D_c	8.4 mm

Number of cutting edges Z	2
Standard	DIN 338
Flute length L _c	75 mm
recommended maximum drilling depth L ₂	62.4 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