

**Garant**
**Jobber drill HSS-E-PM HPC, TiAlN, Ø DC h8: 8,6 mm**

**Order data**

Order number	114610 8,6
GTIN	4045197856708
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  $L_2$ : 68.1 mm

Flute length  $L_c$ : 81 mm

Overall length L: 125 mm

Shank Ø  $D_s$ : 8.6 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.11 mm/rev.

**Technical description**

Tolerance nominal Ø	h8
Standard	DIN 338
recommended maximum drilling depth $L_2$	68.1 mm
Overall length L	125 mm
Number of cutting edges Z	2

Nominal $\varnothing D_c$	8.6 mm
Flute length $L_c$	81 mm
Shank $\varnothing D_s$	8.6 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.11 mm/rev.
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