

**Garant**
**Jobber drill HSS-E-PM HPC, TiAlN, Ø DC h8: 9 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 114610 9      |
| GTIN         | 4045197856746 |
| 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  $L_2$ : 67.5 mm

Flute length  $L_c$ : 81 mm

Overall length L: 125 mm

Shank Ø  $D_s$ : 9 mm

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

**Technical description**

|                                         |              |
|-----------------------------------------|--------------|
| Flute length $L_c$                      | 81 mm        |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.11 mm/rev. |
| Standard                                | DIN 338      |
| Overall length L                        | 125 mm       |
| Nominal Ø $D_c$                         | 9 mm         |

|                                          |              |
|------------------------------------------|--------------|
| recommended maximum drilling depth $L_2$ | 67.5 mm      |
| Number of cutting edges Z                | 2            |
| Shank $\varnothing D_s$                  | 9 mm         |
| Tolerance nominal $\varnothing$          | h8           |
| 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 |