

## Garant

### Jobber drill SS-E-PM HPC, TiAlN, Ø DC h8: 12 mm



#### Order data

Order number	114620 12
GTIN	4045197023971
Item class	11B

#### Description

##### Version:

Dimensions similar to DIN 338.

Shank to DIN 1835A.

**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.

With form S point.

##### 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  $L_2$ : 83 mm

Flute length  $L_c$ : 101 mm

Overall length L: 158 mm

Shank Ø  $D_s$ : 12 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.17 mm/rev.

#### Technical description

Nominal Ø $D_c$	12 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.17 mm/rev.
Flute length $L_c$	101 mm

Number of cutting edges Z	2
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	12 mm
Overall length L	158 mm
Standard	DIN 338
recommended maximum drilling depth $L_2$	83 mm
Point angle	130 degrees
Coating	TiAlN
Tool material	HSS E PM
Helix angle	38 degrees
Shank	DIN 1835 A to h6
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill