

**Garant**
**Jobber drill extra long HSS N, uncoated, Ø DC h8 × overall length L: 8X390 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 116245 8X390  |
| GTIN         | 4045197745972 |
| Item class   | 11B           |

**Description**
**Version:**

With precision ground point.

Vaporised high performance drills for drilling particularly deep holes. Take particular care to ensure **frequent chip clearance**.

**Recommendation:**
**Maximum drilling depth:**

$$L_2 = L_c - 1.5 \times D_c.$$

**Note:**

Suitable NC spotting drills No. 112103, 112110 and 112160 with **120° tip angle** for enhanced process reliability

Through-coolant: no

Standard: DIN 1869

Tolerance nominal Ø: h8

Point angle: 118 degrees

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 253 mm

Flute length  $L_c$ : 265 mm

Overall length L: 390 mm

Shank Ø  $D_s$ : 8 mm

Feed  $f$  in steel < 750 N/mm<sup>2</sup>: 0.1 mm/rev.

**Technical description**

|                           |          |
|---------------------------|----------|
| Shank Ø $D_s$             | 8 mm     |
| Standard                  | DIN 1869 |
| Number of cutting edges Z | 2        |

|   |              |
|---|--------------|
| Feed f in steel < 750 N/mm <sup>2</sup>           | 0.1 mm/rev.  |
| Flute length L <sub>c</sub>                       | 265 mm       |
| Overall length L                                  | 390 mm       |
| Nominal Ø D <sub>c</sub>                          | 8 mm         |
| Tolerance nominal Ø                               | h8           |
| recommended maximum drilling depth L <sub>2</sub> | 253 mm       |
| Point angle                                       | 118 degrees  |
| Coating   | uncoated     |
| Tool material                                     | HSS          |
| Type  | N            |
| Helix angle                                       | 38 degrees   |
| Shank   | Plain shank  |
| Through-coolant                                   | no           |
| Colour ring                                       | without      |
| Type of product                                   | Jobber drill |