

**Garant**
**HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 25/32**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 114150 25/32  |
| GTIN         | 4045197364661 |
| Item class   | 11B           |

**Description**
**Version:**

Profile ground: Jobber drill with high pitch accuracy and concentricity as well as precision ground point.

Steam tempered from Ø 2.4 mm.

With point geometry shape C from size 4 mm

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

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

**Note:**

Size 16 - 20: Drills with shank Ø 16 mm.

Through-coolant: no

Standard: DIN 338

Tolerance nominal Ø: h8

Point angle: 118 °

Shank: Plain shank

Number of cutting edges Z: 2

Inch nominal Ø corresponds to: 19.84 mm

recommended maximum drilling depth  $L_2$ : 110.2 mm

Flute length  $L_c$ : 140 mm

Overall length L: 205 mm

Shank Ø  $D_s$ : 16 mm

Feed f in steel < 750 N/mm<sup>2</sup>: 0.2 mm/rev.

**Technical description**

|                               |          |
|-------------------------------|----------|
| Number of cutting edges Z     | 2        |
| Inch nominal Ø corresponds to | 19.84 mm |

|  |              |
|--|--------------|
| Flute length $L_c$                       | 140 mm       |
| Feed $f$ in steel $< 750 \text{ N/mm}^2$ | 0.2 mm/rev.  |
| Tolerance nominal $\varnothing$          | h8           |
| Shank $\varnothing D_s$                  | 16 mm        |
| Overall length $L$                       | 205 mm       |
| Standard                                 | DIN 338      |
| recommended maximum drilling depth $L_2$ | 110.2 mm     |
| Point angle                              | 118°         |
| Shank                                    | Plain shank  |
| Coating                                  | uncoated     |
| Tool material                            | HSS          |
| Type                                     | N            |
| Through-coolant                          | no           |
| Colour ring                              | without      |
| Type of product                          | Jobber drill |

## User data

|                               | Suitability                               | $V_c$    | ISO code |
|-------------------------------|---|----------|----------|
| Alu plastics                  | suitable only under restricted conditions | 80 m/min | N        |
| Aluminium (short chipping)    | suitable only under restricted conditions | 45 m/min | N        |
| Alu $> 10\% \text{ Si}$       | suitable only under restricted conditions | 50 m/min | N        |
| Steel $< 500 \text{ N/mm}^2$  | suitable                                  | 40 m/min | P        |
| Steel $< 750 \text{ N/mm}^2$  | suitable                                  | 30 m/min | P        |
| Steel $< 900 \text{ N/mm}^2$  | suitable                                  | 25 m/min | P        |
| Steel $< 1100 \text{ N/mm}^2$ | suitable only under restricted conditions | 10 m/min | P        |

|                                |   |          |   |
|--------------------------------|---|----------|---|
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 8 m/min  | P |
| GG(G)                          | suitable                                  | 25 m/min | K |
| CuZn                           | suitable                                  | 80 m/min | N |
| Oil                            | suitable                                  |          |   |
| wet maximum                    | suitable                                  |          |   |