

Garant
HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 9,9

Order data

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|--------------|---------------|
| Order number | 114150 9,9 |
| GTIN | 4045197013484 |
| 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

recommended maximum drilling depth L_2 : 72.2 mm

Flute length L_c : 87 mm

Overall length L: 133 mm

Shank Ø D_s : 9.9 mm

Feed f in steel < 750 N/mm²: 0.1 mm/rev.

Technical description

| | |
|---|-------------|
| Flute length L_c | 87 mm |
| Nominal Ø D_c | 9.9 mm |
| Feed f in steel < 750 N/mm ² | 0.1 mm/rev. |

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|--|--------------|
| Number of cutting edges Z | 2 |
| Tolerance nominal \varnothing | h8 |
| Shank $\varnothing D_s$ | 9.9 mm |
| Overall length L | 133 mm |
| Standard | DIN 338 |
| recommended maximum drilling depth L_2 | 72.2 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% Si | suitable only under restricted conditions | 50 m/min | N |
| Steel < 500 N/mm ² | suitable | 40 m/min | P |
| Steel < 750 N/mm ² | suitable | 30 m/min | P |
| Steel < 900 N/mm ² | suitable | 25 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 10 m/min | P |
| Steel < 1400 N/mm ² | 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 | | |