

Garant
HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 1,85

Order data

Order number	114150 1,85
GTIN	4045197012593
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 : 19.2 mm

Flute length L_c : 22 mm

Overall length L: 46 mm

Shank Ø D_s : 1.85 mm

Feed f in steel < 750 N/mm²: 0.03 mm/rev.

Technical description

Feed f in steel < 750 N/mm ²	0.03 mm/rev.
Flute length L_c	22 mm
Number of cutting edges Z	2

Nominal $\varnothing D_c$	1.85 mm
Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	1.85 mm
Overall length L	46 mm
Standard	DIN 338
recommended maximum drilling depth L_2	19.2 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		