

Garant
Jobber drill HSS-E, uncoated, Ø DC h8: 1,9mm

Order data

Order number	114400 1,9
GTIN	4045197017345
Item class	11B

Description
Version:

Profile ground: this ensures high concentricity and pitch accuracy. Precision ground point. Drill for production use.

Reinforced core, bright finish.

With point geometry shape C from size 2 mm

Recommendation:
Maximum drilling depth:

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

Through-coolant: no

Standard: DIN 338

Tolerance nominal Ø: h8

Point angle: 130 °

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 : 1.9 mm

Feed f in steel < 900 N/mm²: 0.03 mm/rev.

Technical description

Number of cutting edges Z	2
Feed f in steel < 900 N/mm ²	0.03 mm/rev.
Nominal Ø D_c	1.9 mm
Flute length L_c	22 mm

Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	1.9 mm
Overall length L	46 mm
Standard	DIN 338
recommended maximum drilling depth L_2	19.2 mm
Point angle	130°
Shank	Plain shank
Coating	uncoated
Tool material	HSS E
Type	N
Through-coolant	no
Colour ring	red
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
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	10 m/min	P
Steel < 1400 N/mm ²	suitable	8 m/min	P
TOOLOX 33	suitable	8 m/min	H
INOX < 900 N/mm ²	suitable	12 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	8 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	5 m/min	S
GG(G)	suitable	25 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N

Uni	suitable
Oil	suitable
wet maximum	suitable