

Garant

Solid carbide NC spotting drill 142° extra long spiral flutes, TiAlN, Ø DC h6: 12mm



Order data

| | |
|--------------|---------------|
| Order number | 121121 12 |
| GTIN | 4062406120887 |
| Item class | 11E |

Description

Version:

Exactly **central ground point**. **Easy spot drilling** and **high shape accuracy** of the centre hole. Sturdy due to short flutes.

Extra long version.

Application:

Point angle **142°** so that the cutting edges of the following twist drill engage easily.

Note:

Use the speed for the actual hole Ø (not generally the speed for the drill outer Ø).

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 121120**.

Form **HE**: order with **No. 121121 + 129100 HE**.

Technical description

| | |
|--|-------------------|
| Shank tolerance | h6 |
| Feed f in steel < 1100 N/mm ² | 0.03 mm/rev. |
| Flute length L _c | 24 mm |
| Nominal Ø D _c | 12 mm |
| Shank | DIN 6535 HA to h6 |
| Shank Ø D _s | 12 mm |
| Overall length L | 170 mm |
| Coating | TiAlN |

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|---------------------------------|-------------------------|
| Tool material | Solid carbide |
| Standard | Manufacturer's standard |
| Tolerance nominal \varnothing | h6 |
| Point angle | 142 degrees |
| Number of cutting edges Z | 2 |
| Through-coolant | no |
| Colour ring | without |
| Type of product | Spotting drill |

User data

| | Suitability | V_c | ISO code |
|--------------------------------|---|-----------|----------|
| Alu plastics | suitable | 260 m/min | N |
| Aluminium (short chipping) | suitable | 240 m/min | N |
| Alu > 10% Si | suitable | 200 m/min | N |
| Steel < 500 N/mm ² | suitable | 90 m/min | P |
| Steel < 750 N/mm ² | suitable | 80 m/min | P |
| Steel < 900 N/mm ² | suitable | 65 m/min | P |
| Steel < 1100 N/mm ² | suitable | 55 m/min | P |
| INOX < 900 N/mm ² | suitable | 35 m/min | M |
| INOX > 900 N/mm ² | suitable | 30 m/min | M |
| Ti > 850 N/mm ² | suitable | 40 m/min | S |
| GG(G) | suitable | 90 m/min | K |
| CuZn | suitable | 200 m/min | N |
| Uni | suitable | | |
| Oil | suitable | | |
| wet maximum | suitable | | |
| dry | suitable only under restricted conditions | | |

Services

| | |
|------------------------|-----------|
| Shank grinding Type HB | 129100 HB |
| Shank grinding Type HE | 129100 HE |