

## Garant

### Solid carbide NC spotting drill 142° extra long spiral flutes, TiAlN, Ø DC h6: 8mm



#### Order data

Order number	121121 8
GTIN	4062406120863
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

Overall length L	140 mm
Shank tolerance	h6
Nominal Ø D <sub>c</sub>	8 mm
Shank Ø D <sub>s</sub>	8 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.03 mm/rev.
Shank	DIN 6535 HA to h6
Flute length L <sub>c</sub>	23 mm
Coating	TiAlN

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 <sup>2</sup>	suitable	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	55 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	35 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	30 m/min	M
Ti > 850 N/mm <sup>2</sup>	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