

## Garant

### Jobber drill extra long HSS N, uncoated, Ø DC h8 × overall length L: 6,8X225mm



#### Order data

Order number	116245 6,8X225
GTIN	4045197745903
Item class	11B

#### Description

##### Version:

With precision ground point.

Vaporised high performance drills for drilling particularly deep holes. Take particular care to ensure **frequent chip clearance**.

##### Recommendation:

##### Maximum drilling depth:

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

##### Note:

Suitable NC spotting drills No. 112103, 112110 and 112160 with **120° tip angle** for enhanced process reliability

#### Technical description

Flute length $L_c$	155 mm
Overall length L	225 mm
Nominal Ø $D_c$	6.8 mm
Standard	DIN 1869
Number of cutting edges Z	2
Shank Ø $D_s$	6.8 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.07 mm/rev.
Tolerance nominal Ø	h8
recommended maximum drilling depth $L_2$	144.8 mm

Point angle	118 degrees
Shank	Plain shank
Coating	uncoated
Tool material	HSS
Type	N
Helix angle	38 degrees
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable only under restricted conditions	50 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	32 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	28 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	21 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	18 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	5 m/min	P
GG(G)	suitable	18 m/min	K
Oil	suitable		
wet maximum	suitable		