

**Garant**
**Solid carbide jobber drill, TiAlN, Ø DC h7: 12mm**

**Order data**

Order number	122251 12
GTIN	4045197749666
Item class	11E

**Description**
**Version:**
**Similar to DIN 338.**

Nominal Ø and shank Ø equal.

TiAlN coating for even better performance.

**Note:**

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Non slip clamping in drill chuck No. 341050 with diamond coated jaws.

**Technical description**

Overall length L	151 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.18 mm/rev.
Number of cutting edges Z	2
Shank tolerance	h7
Standard	DIN 338
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	12 mm
Nominal Ø D <sub>c</sub>	12 mm
Flute length L <sub>c</sub>	101 mm
recommended maximum drilling depth L <sub>2</sub>	83 mm
Coating	TiAlN
Tool material	solid carbide

Type	N
Point angle	118 degrees
Helix angle	30 degrees
Shank	Parallel shank to h7
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	260 m/min	N
Aluminium (short chipping)	suitable	180 m/min	N
Alu > 10% Si	suitable	180 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	60 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	35 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	35 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	25 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	25 m/min	S
GG(G)	suitable	90 m/min	K
CuZn	suitable	180 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		

