

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

Order data

Order number	121120 8
GTIN	4045197768742
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.

≥ Ø 6 mm with **HB drive flat**.

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).

Technical description

Flute length L_c	23 mm
Feed f in steel < 1100 N/mm ²	0.03 mm/rev.
Overall length L	140 mm
Shank tolerance	h6
Nominal Ø D_c	8 mm
Shank Ø D_s	8 mm
Shank	DIN 6535 HB to h6
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 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		