

Garant
**Jobber drill extra long HSS N, uncoated, Ø DC h8 × overall length L:
4,2X220mm**

Order data

Order number	116245 4,2X220
GTIN	4062406264598
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

Shank Ø D _s	4.2 mm
Standard	DIN 1869
Point angle	118 degrees
Flute length L _c	150 mm
Overall length L	220 mm
Feed f in steel < 750 N/mm ²	0.05 mm/rev.
Tolerance nominal Ø	h8
recommended maximum drilling depth L ₂	143.7 mm
Nominal Ø D _c	4.2 mm

Number of cutting edges Z	2
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 _c	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 ²	suitable	28 m/min	P
Steel < 750 N/mm ²	suitable	21 m/min	P
Steel < 900 N/mm ²	suitable	18 m/min	P
Steel < 1100 N/mm ²	suitable	5 m/min	P
GG(G)	suitable	18 m/min	K
Oil	suitable		
wet maximum	suitable		