

## Garant

### Jobber drill, extra long HSS-E FS, uncoated, Ø DC h8 × overall length L: 10X340mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 116250 10X340 |
| GTIN         | 4062406266080 |
| Item class   | 11B           |

#### Description

##### Version:

With precision ground point.

Special 4-chamfer relief ground for very good guidance within the bore. Bright finish flutes, nitrided chamfers.

With point geometry shape C.

##### Advantage:

**Special deep hole drills. For particularly deep or recessed holes.** Good chip evacuation due to parabolic flutes, resulting in fewer chip evacuations even in particularly deep holes.

##### Recommendation:

##### Maximum drilling depth:

$$L_2 = L_C - 1.5 \times D_C$$

##### Note:

Suitable NC spotting drills No. 112120, 112140 and 112170 with **142° tip angle** for enhanced process reliability

#### Technical description

|   |             |
|---|-------------|
| Point angle                                       | 130 degrees |
| Shank Ø D <sub>s</sub>                            | 10 mm       |
| Feed f in steel < 750 N/mm <sup>2</sup>           | 0.1 mm/rev. |
| Overall length L                                  | 340 mm      |
| recommended maximum drilling depth L <sub>2</sub> | 220 mm      |
| Nominal Ø D <sub>C</sub>                          | 10 mm       |

|                                 |              |
|---------------------------------|--------------|
| Flute length $L_c$              | 235 mm       |
| Standard                        | DIN 1869     |
| Number of cutting edges Z       | 2            |
| Tolerance nominal $\varnothing$ | h8           |
| Shank                           | Plain shank  |
| Coating                         | uncoated     |
| Tool material                   | HSS E        |
| Type                            | FS           |
| 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 | 55 m/min | N        |
| Aluminium (short chipping)     | suitable only under restricted conditions | 30 m/min | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 32 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 25 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 20 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 5 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 8 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 4 m/min  | M        |
| GG(G)                          | suitable only under restricted conditions | 20 m/min | K        |
| Oil                            | suitable                                  |          |          |

wet maximum

suitable