

Garant

Jobber drill, extra long HSS-E FS, uncoated, Ø DC h8 × overall length L: 3,5X165mm



Order data

| | |
|--------------|----------------|
| Order number | 116250 3,5X165 |
| GTIN | 4062406265786 |
| 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

| | |
|---------------------------------------------------|--------------|
| Number of cutting edges Z | 2 |
| recommended maximum drilling depth L ₂ | 109.8 mm |
| Standard | DIN 1869 |
| Overall length L | 165 mm |
| Feed f in steel < 750 N/mm ² | 0.05 mm/rev. |
| Point angle | 130 degrees |

| | |
|---------------------------------|--------------|
| Nominal $\varnothing D_c$ | 3.5 mm |
| Tolerance nominal \varnothing | h8 |
| Shank $\varnothing D_s$ | 3.5 mm |
| Flute length L_c | 115 mm |
| 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 ² | suitable | 32 m/min | P |
| Steel < 750 N/mm ² | suitable | 25 m/min | P |
| Steel < 900 N/mm ² | suitable | 20 m/min | P |
| Steel < 1100 N/mm ² | suitable | 5 m/min | P |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 8 m/min | M |
| INOX > 900 N/mm ² | 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