

Garant**Solid carbide NC spotting drill 142° straight flutes, TiAlN, Ø DC h6: 12mm****Order data**

Order number	121111 12
GTIN	4045197504678
Item class	11E

Description**Version:**

≥ Ø 6 mm with HB drive flat.

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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	18 mm
Shank tolerance	h6
Nominal Ø D_c	12 mm
Feed f in steel < 1100 N/mm ²	0.03 mm/rev.
Shank Ø D_s	12 mm
Overall length L	70 mm
Shank	DIN 6535 HB to h6
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard
Tolerance nominal Ø	h6

Point angle	142 degrees
Colour ring	without

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		