

**Garant**
**Deep hole drill HSS-E, uncoated, Ø DC h8: 3,5mm**

**Order data**

Order number	116061 3,5
GTIN	4045197026736
Item class	11B

**Description**
**Version:**

Significantly **strengthened core** without taper.

Precision ground point.

With **specialty shaped slots**. Designed for deep holes up to 10×D and materials with critical chip formation characteristics.

**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**

Flute length $L_c$	73 mm
Nominal $\varnothing D_c$	3.5 mm
Number of cutting edges Z	2
Feed f in steel < 500 N/mm <sup>2</sup>	0.05 mm/rev.
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	3.5 mm
Overall length L	112 mm
Standard	DIN 340
recommended maximum drilling depth $L_2$	67.8 mm

Point angle	130 degrees
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 <sub>c</sub>	ISO code
Alu plastics	suitable	70 m/min	N
Aluminium (short chipping)	suitable	45 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	28 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	21 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	18 m/min	P
GG(G)	suitable	25 m/min	K
Oil	suitable		
wet maximum	suitable		