

## Garant

### Deep hole drill HSS-E, uncoated, Ø DC h8: 2,7mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 116061 2,7    |
| GTIN         | 4045197026651 |
| Item class   | 11B           |

#### Description

##### Version:

Significantly **strengthened core** without taper.

Precision ground point.

With **specially 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

|  |              |
|--|--------------|
| Number of cutting edges Z                | 2            |
| Flute length $L_c$                       | 66 mm        |
| Feed f in steel < 500 N/mm <sup>2</sup>  | 0.05 mm/rev. |
| Nominal Ø $D_c$                          | 2.7 mm       |
| Tolerance nominal Ø                      | h8           |
| Shank Ø $D_s$                            | 2.7 mm       |
| Overall length L                         | 100 mm       |
| Standard                                 | DIN 340      |
| recommended maximum drilling depth $L_2$ | 62 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                                  |                |          |