

Garant

Deep hole drill HSS-E, uncoated, Ø DC h8: 3,9mm



Order data

Order number	116061 3,9
GTIN	4045197026774
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

Flute length L_c	78 mm
Number of cutting edges Z	2
Nominal $\varnothing D_c$	3.9 mm
Feed f in steel $< 500 \text{ N/mm}^2$	0.05 mm/rev.
Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	3.9 mm
Overall length L	119 mm
Standard	DIN 340
recommended maximum drilling depth L_2	72.2 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_c	ISO code
Alu plastics	suitable	70 m/min	N
Aluminium (short chipping)	suitable	45 m/min	N
Steel < 500 N/mm ²	suitable	28 m/min	P
Steel < 750 N/mm ²	suitable	21 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	18 m/min	P
GG(G)	suitable	25 m/min	K
Oil	suitable		
wet maximum	suitable		