

Garant
Deep hole drill HSS-E, uncoated, Ø DC h8: 12mm

Order data

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|--------------|---------------|
| Order number | 116061 12 |
| GTIN | 4045197027054 |
| 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 | 134 mm |
| Nominal $\varnothing D_c$ | 12 mm |
| Feed f in steel < 500 N/mm ² | 0.25 mm/rev. |
| Number of cutting edges Z | 2 |
| Tolerance nominal \varnothing | h8 |
| Shank $\varnothing D_s$ | 12 mm |
| Overall length L | 205 mm |
| Standard | DIN 340 |
| recommended maximum drilling depth L_2 | 116 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 | | |