

**Garant****Deep hole drill HSS-E, uncoated, Ø DC h8: 8,5mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 116061 8,5    |
| GTIN         | 4045197026965 |
| 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           |
| Nominal Ø D <sub>c</sub>                          | 8.5 mm      |
| Feed f in steel < 500 N/mm <sup>2</sup>           | 0.2 mm/rev. |
| Flute length L <sub>c</sub>                       | 109 mm      |
| Tolerance nominal Ø                               | h8          |
| Shank Ø D <sub>s</sub>                            | 8.5 mm      |
| Overall length L                                  | 165 mm      |
| Standard  | DIN 340     |
| recommended maximum drilling depth L <sub>2</sub> | 96.3 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                                  |                |          |