

Garant
Deep hole drill HSS-E, uncoated, Ø DC h8: 6,8mm

Order data

Order number	116061 6,8
GTIN	4045197026897
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

Nominal Ø D _c	6.8 mm
Flute length L _c	102 mm
Number of cutting edges Z	2
Feed f in steel < 500 N/mm ²	0.12 mm/rev.
Tolerance nominal Ø	h8
Shank Ø D _s	6.8 mm
Overall length L	156 mm
Standard	DIN 340
recommended maximum drilling depth L ₂	91.8 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 _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		