

**Garant****Jobber drill long HSS N, uncoated, Ø DC h8: 6,8mm****Order data**

Order number	116000 6,8
GTIN	4045197025531
Item class	11B

**Description****Version:**

Vaporised from 2.4 mm. Particularly for deep hole drilling (for deep holes, repeated chip evacuation is necessary).

With point geometry shape A from size 4 mm.

**Advantage:**

Especially suitable for **long reach purposes**. (When used to drill deep holes, low feed rates and frequent drill pecks are necessary).

**Recommendation:****Maximum drilling depth:**

$$L_2 = L_c - 1.5 \times D_c$$

**Note:**

Suitable NC spotting drills No. 112103, 112110 and 112160 with **120° tip angle** for enhanced process reliability.

**Technical description**

Feed f in steel < 750 N/mm <sup>2</sup>	0.05 mm/rev.
Flute length L <sub>c</sub>	102 mm
Nominal Ø D <sub>c</sub>	6.8 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h8
Shank Ø D <sub>s</sub>	6.8 mm
Overall length L	156 mm
Standard	DIN 340

recommended maximum drilling depth $L_2$	91.8 mm
Point angle	118 degrees
Shank	Plain shank
Coating	uncoated
Tool material	HSS
Type	N
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

### User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable only under restricted conditions	64 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	52 m/min	N
Alu > 10% Si	suitable only under restricted conditions	40 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	25 m/min	P
GG(G)	suitable only under restricted conditions	25 m/min	K
Oil	suitable		
wet maximum	suitable		