

Garant
Jobber drill long HSS N, uncoated, Ø DC h8: 1,8mm

Order data

Order number	116000 1,8
GTIN	4045197025203
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

Flute length L_c	53 mm
Feed f in steel $< 750 \text{ N/mm}^2$	0.02 mm/rev.
Nominal $\varnothing D_c$	1.8 mm
Number of cutting edges Z	2
Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	1.8 mm
Overall length L	80 mm
Standard	DIN 340

recommended maximum drilling depth L_2	50.3 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 ²	suitable	40 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
GG(G)	suitable only under restricted conditions	25 m/min	K
Oil	suitable		
wet maximum	suitable		