

Garant

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



Order data

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|--------------|---------------|
| Order number | 116000 1 |
| GTIN | 4045197025128 |
| 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

| | |
|---|--------------|
| Nominal Ø D _c | 1 mm |
| Feed f in steel < 750 N/mm ² | 0.02 mm/rev. |
| Flute length L _c | 33 mm |
| Number of cutting edges Z | 2 |
| Tolerance nominal Ø | h8 |
| Shank Ø D _s | 1 mm |
| Overall length L | 56 mm |
| Standard | DIN 340 |

| | |
|--|--------------|
| recommended maximum drilling depth L_2 | 31.5 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 | | |