

## Garant

### Jobber drill, long, HSS-E N, uncoated, Ø DC h8: 8,2mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 116065 8,2    |
| GTIN         | 4045197270740 |
| Item class   | 11B           |

#### Description

##### Version:

Profile ground. Standard core thickness and core taper. Bright finish.  
With point geometry shape AC from 2 mm.

##### Advantage:

For drilling with drill bushes or long reach applications.  
For high-tensile tempered steels, **including TOOLOX**.

##### 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

|   |              |
|---|--------------|
| Number of cutting edges Z                         | 2            |
| Nominal Ø D <sub>c</sub>                          | 8.2 mm       |
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.08 mm/rev. |
| Flute length L <sub>c</sub>                       | 109 mm       |
| Tolerance nominal Ø                               | h8           |
| Shank Ø D <sub>s</sub>                            | 8.2 mm       |
| Overall length L                                  | 165 mm       |
| Standard  | DIN 340      |
| recommended maximum drilling depth L <sub>2</sub> | 96.7 mm      |

|                 |               |
|-----------------|---------------|
| Point angle     | 118 degrees   |
| Shank           | Plain shank   |
| Coating         | uncoated      |
| Tool material   | HSS E         |
| Type            | N             |
| Helix angle     | 35-40 degrees |
| Through-coolant | no            |
| Colour ring     | red           |
| Type of product | Jobber drill  |

### User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 30 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 25 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 10 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 8 m/min        | P        |
| TOOLOX 33                      | suitable                                  | 8 m/min        | H        |
| TOOLOX 44                      | suitable                                  | 5 m/min        | H        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 12 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 8 m/min        | M        |
| CuZn                           | suitable only under restricted conditions | 80 m/min       | N        |
| Oil                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |