

Garant
Jobber drill, long, HSS-E VA, uncoated, Ø DC h8: 2,8mm

Order data

| | |
|--------------|---------------|
| Order number | 116070 2,8 |
| GTIN | 4045197027276 |
| Item class | 11B |

Description
Version:

Profile ground. Standard core thickness and core taper. Bright finish.
With point geometry shape C.

Advantage:

For drilling with drill bushes or long reach applications.

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

| | |
|--|--------------|
| Flute length L_c | 66 mm |
| Feed f in stainless steel $< 900 \text{ N/mm}^2$ | 0.02 mm/rev. |
| Number of cutting edges Z | 2 |
| Nominal $\varnothing D_c$ | 2.8 mm |
| Tolerance nominal \varnothing | h8 |
| Shank $\varnothing D_s$ | 2.8 mm |
| Overall length L | 100 mm |
| Standard | DIN 340 |
| recommended maximum drilling depth L_2 | 61.8 mm |

| | |
|-----------------|---------------|
| Point angle | 130 degrees |
| Shank | Plain shank |
| Coating | uncoated |
| Tool material | HSS E |
| Helix angle | 35-40 degrees |
| Through-coolant | no |
| Colour ring | blue |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|-------------------------------|---|----------------|----------|
| Steel < 500 N/mm ² | suitable only under restricted conditions | 40 m/min | P |
| Steel < 750 N/mm ² | suitable only under restricted conditions | 20 m/min | P |
| INOX < 900 N/mm ² | suitable | 12 m/min | M |
| INOX > 900 N/mm ² | suitable | 8 m/min | M |
| Ti > 850 N/mm ² | suitable | 5 m/min | S |
| Oil | suitable | | |
| wet maximum | suitable | | |