

**Garant**
**Jobber drill, long, HSS-E VA, uncoated, Ø DC h8: 1mm**

**Order data**

Order number	116070 1
GTIN	4045197027092
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 $L_c$	33 mm
Number of cutting edges $Z$	2
Nominal $\varnothing D_c$	1 mm
Feed $f$ in stainless steel < 900 N/mm <sup>2</sup>	0.01 mm/rev.
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	1 mm
Overall length $L$	56 mm
Standard	DIN 340
recommended maximum drilling depth $L_2$	31.5 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 <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	40 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	20 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	12 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	8 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	5 m/min	S
Oil	suitable		
wet maximum	suitable		