

Garant**Jobber drill, long, HSS-E VA, uncoated, Ø DC h8: 3,3mm****Order data**

| | |
|--------------|---------------|
| Order number | 116070 3,3 |
| GTIN | 4045197027320 |
| 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

| | |
|---|--------------|
| Nominal Ø D _c | 3.3 mm |
| Flute length L _c | 69 mm |
| Number of cutting edges Z | 2 |
| Feed f in stainless steel < 900 N/mm ² | 0.02 mm/rev. |
| Tolerance nominal Ø | h8 |
| Shank Ø D _s | 3.3 mm |
| Overall length L | 106 mm |
| Standard | DIN 340 |
| recommended maximum drilling depth L ₂ | 64.1 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 | | |