

Garant
Jobber drill long HSS W, uncoated, Ø DC h8: 4,2mm

Order data

Order number	116040 4,2
GTIN	4045197025807
Item class	11B

Description
Version:

With point geometry shape A from size 2.5 mm.

Strengthened core **without core taper**. Precision ground point. Wide flutes with heavily honed back edges. Bright ground surface finish.

Advantage:

For deep hole drilling and for use with drill bushings.

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	78 mm
Nominal $\varnothing D_c$	4.2 mm
Number of cutting edges Z	2
Feed f in aluminium short-chipping	0.09 mm/rev.
Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	4.2 mm
Overall length L	119 mm
Standard	DIN 340
recommended maximum drilling depth L_2	71.7 mm

Point angle	130 degrees
Shank	Plain shank
Coating	uncoated
Tool material	HSS
Type	W
Helix angle	30-40 degrees
Through-coolant	no
Colour ring	yellow
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Alu plastics	suitable	70 m/min	N
Aluminium (short chipping)	suitable	45 m/min	N
Alu > 10% Si	suitable only under restricted conditions	40 m/min	N
Oil	suitable		
wet maximum	suitable		