

**Garant**
**Jobber drill long HSS W, uncoated, Ø DC h8: 10mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 116040 10     |
| GTIN         | 4045197025913 |
| 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**

|   |              |
|---|--------------|
| Number of cutting edges Z                         | 2            |
| Nominal Ø D <sub>c</sub>                          | 10 mm        |
| Flute length L <sub>c</sub>                       | 121 mm       |
| Feed f in aluminium short-chipping                | 0.18 mm/rev. |
| Tolerance nominal Ø                               | h8           |
| Shank Ø D <sub>s</sub>                            | 10 mm        |
| Overall length L                                  | 184 mm       |
| Standard  | DIN 340      |
| recommended maximum drilling depth L <sub>2</sub> | 106 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                                  |          |          |