

**Garant**
**Jobber drill, extra long HSS-E FS, TiAlN, Ø DC h8 × overall length L:  
10X265mm**

**Order data**

Order number	116280 10X265
GTIN	4045197029287
Item class	11B

**Description**
**Version:**

With point geometry shape C.

**Advantage:**

**Particularly suitable for drilling under difficult conditions**, e.g. insufficient cooling of the cutting edges due to poor chip evacuation.

**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
Flute length $L_c$	185 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.
Nominal Ø $D_c$	10 mm
Tolerance nominal Ø	h8
Shank Ø $D_s$	10 mm
Overall length L	265 mm
Standard	DIN 1869

recommended maximum drilling depth L <sub>2</sub>	170 mm
Point angle	135 degrees
Shank	Plain shank
Coating	TiAlN
Tool material	HSS E
Type	FS
Helix angle	38 degrees
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable only under restricted conditions	60 m/min	N
Alu > 10% Si	suitable only under restricted conditions	38 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	38 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	28 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	22 m/min	P
Oil	suitable		
wet maximum	suitable		