

## Garant

### Jobber drill, extra long HSS-E FS, TiAlN, Ø DC h8 × overall length L: 7,5X290mm



#### Order data

Order number	116280 7,5X290
GTIN	4045197029195
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

Feed f in steel < 750 N/mm <sup>2</sup>	0.07 mm/rev.
Number of cutting edges Z	2
Flute length L <sub>c</sub>	200 mm
Nominal Ø D <sub>c</sub>	7.5 mm
Tolerance nominal Ø	h8
Shank Ø D <sub>s</sub>	7.5 mm
Overall length L	290 mm
Standard	DIN 1869

recommended maximum drilling depth $L_2$	188.8 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	$V_c$	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		