

**Garant****HSS jobber drill W, uncoated, Ø DC h8: 12mm****Order data**

Order number	114200 12
GTIN	4045197016133
Item class	11B

**Description****Version:**

Standard core without core taper.

Precision ground point.

Ground flute with high helix.

Bright ground surface finish.

With point geometry shape A from size 2.0 mm.

**Recommendation:****Maximum drilling depth:**

$$L_2 = L_c - 1.5 \times D_c$$

**Technical description**

Flute length $L_c$	101 mm
Number of cutting edges $Z$	2
Nominal $\varnothing D_c$	12 mm
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	12 mm
Overall length $L$	151 mm
Feed $f$ in long-chipping aluminium plastics	0.22 mm/rev.
Standard	DIN 338
recommended maximum drilling depth $L_2$	83 mm
Point angle	130 degrees
Shank	Plain shank

Coating	uncoated
Tool material	HSS
Type	W
Helix angle	35-40 degrees
Through-coolant	no
Colour ring	yellow
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	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		