

**Garant**
**Jobber drill HSS-E N, uncoated, Ø DC h8: 12,2mm**

**Order data**

Order number	114400 12,2
GTIN	4045197018250
Item class	11B

**Description**
**Version:**

**Profile ground:** this ensures high concentricity and pitch accuracy. Precision ground point. Drill for production use.

**Reinforced core,** bright finish.

With point geometry shape C from size 2 mm

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

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

**Technical description**

Flute length $L_c$	101 mm
Nominal $\varnothing D_c$	12.2 mm
Number of cutting edges $Z$	2
Feed $f$ in steel $< 750 \text{ N/mm}^2$	0.16 mm/rev.
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	12.2 mm
Overall length $L$	151 mm
Standard	DIN 338
recommended maximum drilling depth $L_2$	82.7 mm
Point angle	130 degrees
Shank	Plain shank

Coating	uncoated
Tool material	HSS E
Type	N
Through-coolant	no
Colour ring	red
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable	40 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	30 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	25 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	10 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	8 m/min	P
TOOLOX 33	suitable	8 m/min	H
INOX < 900 N/mm <sup>2</sup>	suitable	12 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	8 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	5 m/min	S
GG(G)	suitable	25 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		