

Garant

Jobber drill extra long HSS FS, uncoated, Ø DC h8: 18R1mm



Order data

Order number	116720 18R1
GTIN	4045197034939
Item class	11C

Description

Version:

High concentricity.

Large section parabolic flutes; strong due to strengthened core thickness (without core taper).
 ≤ 16 mm Ø: Bright finish flutes, nitrided lands; > 16 mm Ø: Specially treated surface.

Special sturdy drills **for extremely deep holes.** Up to approx. 15×Ø without drill withdrawal.

With point geometry shape A.

Recommendation:

Maximum drilling depth:

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

Note:

For suitable reducing adapters for tools with MT shanks see **No. 343000-343530.**

Through-coolant: no

Standard: DIN 1870 R1

Tolerance nominal Ø: h8

Point angle: 130 °

Shank: Morse taper

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 218 mm

Flute length L_c : 245 mm

Overall length L: 370 mm

Morse taper MT size: 2

Feed f in steel < 750 N/mm²: 0.2 mm/rev.

Technical description

Feed f in steel < 750 N/mm ²	0.2 mm/rev.
Number of cutting edges Z	2

Nominal $\varnothing D_c$	18 mm
Flute length L_c	245 mm
Tolerance nominal \varnothing	h8
Overall length L	370 mm
Morse taper MT size	2
Standard	DIN 1870 R1
recommended maximum drilling depth L_2	218 mm
Point angle	130°
Shank	Morse taper
Coating	uncoated
Tool material	HSS
Type	FS
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	40 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
Oil	suitable		
wet maximum	suitable		