

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

Order data

Order number	116760 18R1
GTIN	4045197035455
Item class	11C

Description
Version:

High concentricity. Core thickness and core taper are standard.

Special surface treatment.

Precision ground point. When drilling deep holes, evacuate chips from the hole frequently, and ensure adequate cooling.

Economy version with standard flutes.

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**.

Technical description

Feed f in steel < 750 N/mm ²	0.2 mm/rev.
Flute length L _c	245 mm
Nominal Ø D _c	18 mm
Number of cutting edges Z	2
Tolerance nominal Ø	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	118 degrees
Shank	Morse taper
Coating	uncoated
Tool material	HSS
Type	N
Helix angle	16-30 degrees
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
GG(G)	suitable	25 m/min	K
Oil	suitable		
wet maximum	suitable		