

**Garant****Solid carbide NC spotting drill 90° spiral flutes, TiAlN, Ø DC h6: 12mm****Order data**

Order number	121040 12
GTIN	4045197038586
Item class	11E

**Description****Version:**

Exactly **central ground point**. **Easy spot drilling** and **high shape accuracy** of the centre hole. Sturdy due to short flutes.

**≥ Ø 6 mm with HB drive flat.**

**Application:**

Point angle **90°** for spot drilling and countersinking in one operation when a drill of smaller Ø is used afterwards.

**Note:**

Use the speed for the actual hole Ø (not generally the speed for the drill outer Ø).

**Technical description**

Nominal Ø D <sub>c</sub>	12 mm
Flute length L <sub>c</sub>	24 mm
Feed f in steel < 1100 N/mm <sup>2</sup>	0.03 mm/rev.
Shank tolerance	h6
Shank Ø D <sub>s</sub>	12 mm
Overall length L	70 mm
Shank	DIN 6535 HB to h6
Coating	TiAlN
Tool material	Solid carbide
Standard	Manufacturer's standard

Tolerance nominal $\varnothing$	h6
Point angle	90 degrees
Number of cutting edges Z	2
Through-coolant	no
Colour ring	without
Type of product	Spotting drill

### User data

	Suitability	$V_c$	ISO code
Alu plastics	suitable	260 m/min	N
Aluminium (short chipping)	suitable	240 m/min	N
Alu > 10% Si	suitable	200 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	55 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	35 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	30 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	40 m/min	S
GG(G)	suitable	90 m/min	K
CuZn	suitable	200 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		