

**Garant**
**NC spotting drill HSS-E 142° N, TiAlN, Ø DC h6: 8mm**

**Order data**

Order number	112170 8
GTIN	4045197001566
Item class	11A

**Description**
**Version:**

≥ Ø 6 mm with **drive flat to DIN 1835-B**.

Precision centred ground point with thin chisel edge - gives easy spot drilling and high accuracy of the centre hole form. Very sturdy due to short flutes.

**Application:**

**Point angle 142°** so that the cutting edges of the following drill engage easily.

**Note:**

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

**Technical description**

Flute length $L_c$	25 mm
Nominal Ø $D_c$	8 mm
Feed $f$ in steel < 900 N/mm <sup>2</sup>	0.07 mm/rev.
Shank tolerance	h6
Shank Ø $D_s$	8 mm
Overall length $L$	140 mm
Shank	DIN 1835 B to h6
Coating	TiAlN
Tool material	HSS E
Standard	Manufacturer's standard
Type	N

Tolerance nominal Ø	h6
Point angle	142 degrees
Number of cutting edges Z	2
Through-coolant	no
Colour ring	without
Type of product	Spotting drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable	87 m/min	N
Aluminium (short chipping)	suitable	56 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	37 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	31 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	10 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	15 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	10 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	6 m/min	S
GG(G)	suitable	31 m/min	K
CuZn	suitable	100 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		