

Garant**NC spotting drill HSS-E 142° N, TiAlN, Ø DC h6: 12mm****Order data**

| | |
|--------------|---------------|
| Order number | 112140 12 |
| GTIN | 4045197001481 |
| 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

| | |
|---|-------------------------|
| Feed f in steel < 900 N/mm ² | 0.06 mm/rev. |
| Flute length L _c | 30 mm |
| Nominal Ø D _c | 12 mm |
| Shank tolerance | h6 |
| Shank Ø D _s | 12 mm |
| Overall length L | 102 mm |
| Shank | DIN 1835 B to h6 |
| Coating | TiAlN |
| Tool material | HSS E |
| Standard | Manufacturer's standard |

| | |
|---------------------------------|----------------|
| Type | N |
| Tolerance nominal \varnothing | 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_c | 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 ² | suitable | 50 m/min | P |
| Steel < 750 N/mm ² | suitable | 37 m/min | P |
| Steel < 900 N/mm ² | suitable | 31 m/min | P |
| Steel < 1100 N/mm ² | suitable | 12 m/min | P |
| Steel < 1400 N/mm ² | suitable | 10 m/min | P |
| INOX < 900 N/mm ² | suitable | 15 m/min | M |
| INOX > 900 N/mm ² | suitable | 10 m/min | M |
| Ti > 850 N/mm ² | 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 | | |

