

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

Order number	112140 8
GTIN	4045197001467
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
Shank tolerance	h6
Feed f in steel < 900 N/mm ²	0.05 mm/rev.
Nominal Ø D_c	8 mm
Shank Ø D_s	8 mm
Overall length L	79 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 _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		

