

Garant
Jobber drill with 3 clamping faces HSS-E, uncoated, Ø DC h8: 6,8mm

Order data

Order number	114001 6,8
GTIN	4045197749970
Item class	11B

Description
Version:

Particularly sturdy and robust due to the **strengthened core diameter**. Ground flutes, with high concentricity. Precision ground point.

Recommendation:
Maximum drilling depth:

$$L_2 = L_c - 1.5 \times D_c$$

Note:

Three **drive flats on the shank** for use in a 3-jaw chuck.

Technical description

Standard	DIN 338
Flute length L_c	69 mm
Overall length L	109 mm
Tolerance nominal \varnothing	h8
Nominal $\varnothing D_c$	6.8 mm
Number of cutting edges Z	2
Shank $\varnothing D_s$	6.8 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.07 mm/rev.
recommended maximum drilling depth L_2	58.8 mm
Point angle	130 degrees
Shank	Three drive flats shank

Coating	uncoated
Tool material	HSS E
Type	N
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	70 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	45 m/min	N
Alu > 10% Si	suitable only under restricted conditions	40 m/min	N
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
Steel < 1100 N/mm ²	suitable	10 m/min	P
Steel < 1400 N/mm ²	suitable	8 m/min	P
INOX < 900 N/mm ²	suitable	12 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	8 m/min	M
GG(G)	suitable only under restricted conditions	25 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		

