

Garant

**Jobber drill, extra long HSS-E FS, TiAlN, Ø DC h8 × overall length L:
6,8X225mm**



Order data

Order number	116280 6,8X225
GTIN	4045197029157
Item class	11B

Description

Version:

With point geometry shape C.

Advantage:

Particularly suitable for drilling under difficult conditions, e.g. insufficient cooling of the cutting edges due to poor chip evacuation.

Recommendation:**Maximum drilling depth:**

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

Note:

Suitable NC spotting drills No. 112120, 112140 and 112170 with **142° tip angle** for enhanced process reliability

Technical description

Flute length L_c	155 mm
Number of cutting edges Z	2
Nominal $\varnothing D_c$	6.8 mm
Feed f in steel < 750 N/mm ²	0.07 mm/rev.
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	6.8 mm
Overall length L	225 mm
Standard	DIN 1869

recommended maximum drilling depth L ₂	144.8 mm
Point angle	135 degrees
Shank	Plain shank
Coating	TiAlN
Tool material	HSS E
Type	FS
Helix angle	38 degrees
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	60 m/min	N
Alu > 10% Si	suitable only under restricted conditions	38 m/min	N
Steel < 500 N/mm ²	suitable	38 m/min	P
Steel < 750 N/mm ²	suitable	28 m/min	P
Steel < 900 N/mm ²	suitable	22 m/min	P
Oil	suitable		
wet maximum	suitable		