

Garant**Jobber drill, long, HSS-E VA, uncoated, Ø DC h8: 6,1mm****Order data**

Order number	116070 6,1
GTIN	4045197027603
Item class	11B

Description**Version:**

Profile ground. Standard core thickness and core taper. Bright finish.
With point geometry shape C.

Advantage:

For drilling with drill bushes or long reach applications.

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

Number of cutting edges Z	2
Flute length L_c	97 mm
Nominal $\varnothing D_c$	6.1 mm
Feed f in stainless steel < 900 N/mm ²	0.05 mm/rev.
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	6.1 mm
Overall length L	148 mm
Standard	DIN 340
recommended maximum drilling depth L_2	87.9 mm

Point angle	130 degrees
Shank	Plain shank
Coating	uncoated
Tool material	HSS E
Helix angle	35-40 degrees
Through-coolant	no
Colour ring	blue
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	40 m/min	P
Steel < 750 N/mm ²	suitable only under restricted conditions	20 m/min	P
INOX < 900 N/mm ²	suitable	12 m/min	M
INOX > 900 N/mm ²	suitable	8 m/min	M
Ti > 850 N/mm ²	suitable	5 m/min	S
Oil	suitable		
wet maximum	suitable		