

**Garant**
**Jobber drill, long, HSS-E VA, uncoated, Ø DC h8: 6,8mm**

**Order data**

Order number	116070 6,8
GTIN	4045197027672
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
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.05 mm/rev.
Flute length L <sub>c</sub>	102 mm
Nominal Ø D <sub>c</sub>	6.8 mm
Tolerance nominal Ø	h8
Shank Ø D <sub>s</sub>	6.8 mm
Overall length L	156 mm
Standard	DIN 340
recommended maximum drilling depth L <sub>2</sub>	91.8 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 <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	40 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable only under restricted conditions	20 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	12 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	8 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	5 m/min	S
Oil	suitable		
wet maximum	suitable		