

## Garant

### Jobber drill extra long HSS FS, uncoated, Ø DC h8 × overall length L: 4,5X185 mm



#### Order data

Order number	116240 4,5X185
GTIN	4045197028693
Item class	11B

#### Description

##### Version:

With precision ground point.

Significantly strengthened core without core taper. Bright finish flutes, nitrided chamfers.

With point geometry shape C.

##### Advantage:

**Special deep hole drills. For particularly deep or recessed holes.** Good chip evacuation due to parabolic flutes, resulting in fewer chip evacuations even in particularly deep holes.

##### 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

Through-coolant: no

Standard: DIN 1869

Tolerance nominal Ø: h8

Point angle: 130 degrees

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 118.3 mm

Flute length  $L_c$ : 125 mm

Overall length L: 185 mm

Shank Ø  $D_s$ : 4.5 mm

Feed  $f$  in steel < 750 N/mm<sup>2</sup>: 0.05 mm/rev.

#### Technical description

Nominal Ø $D_c$	4.5 mm
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Number of cutting edges Z	2
Feed f in steel < 750 N/mm <sup>2</sup>	0.05 mm/rev.
Flute length L <sub>c</sub>	125 mm
Tolerance nominal Ø	h8
Shank Ø D <sub>s</sub>	4.5 mm
Overall length L	185 mm
Standard	DIN 1869
recommended maximum drilling depth L <sub>2</sub>	118.3 mm
Point angle	130 degrees
Coating	uncoated
Tool material	HSS
Type	FS
Helix angle	38 degrees
Shank	Plain shank
Through-coolant	no
Colour ring	without
Type of product	Jobber drill