

Garant
Solid carbide jobber drill, TiAlN, Ø DC h7: 12mm

Order data

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|--------------|---------------|
| Order number | 122251 12 |
| GTIN | 4045197749666 |
| Item class | 11E |

Description
Version:
Similar to DIN 338.

Nominal Ø and shank Ø equal.

TiAlN coating for even better performance.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Non slip clamping in drill chuck No. 341050 with diamond coated jaws.

Through-coolant: no

Standard: DIN 338

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 83 mm

Tolerance nominal Ø: h7

Overall length L: 151 mm

Shank Ø D_s : 12 mm

Feed f in steel < 1100 N/mm²: 0.18 mm/rev.

Technical description

| | |
|--|--------------|
| Overall length L | 151 mm |
| Feed f in steel < 1100 N/mm ² | 0.18 mm/rev. |
| Number of cutting edges Z | 2 |
| Shank tolerance | h7 |
| Standard | DIN 338 |
| Tolerance nominal Ø | h7 |

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|--|----------------------|
| Shank $\varnothing D_s$ | 12 mm |
| Nominal $\varnothing D_c$ | 12 mm |
| Flute length L_c | 101 mm |
| recommended maximum drilling depth L_2 | 83 mm |
| Coating | TiAlN |
| Tool material | solid carbide |
| Type | N |
| Point angle | 118 ° |
| Helix angle | 30 ° |
| Shank | Parallel shank to h7 |
| 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 | 260 m/min | N |
| Aluminium (short chipping) | suitable | 180 m/min | N |
| Alu > 10% Si | suitable | 180 m/min | N |
| Steel < 500 N/mm ² | suitable | 90 m/min | P |
| Steel < 750 N/mm ² | suitable | 90 m/min | P |
| Steel < 900 N/mm ² | suitable | 80 m/min | P |
| Steel < 1100 N/mm ² | suitable | 60 m/min | P |
| Steel < 1400 N/mm ² | suitable | 35 m/min | P |
| INOX < 900 N/mm ² | suitable | 35 m/min | M |
| INOX > 900 N/mm ² | suitable | 25 m/min | M |
| Ti > 850 N/mm ² | suitable | 25 m/min | S |

| | | | |
|-------------|--|-----------|---|
| GG(G) | suitable | 90 m/min | K |
| CuZn | suitable | 180 m/min | N |
| Uni | suitable | | |
| Oil | suitable | | |
| wet maximum | suitable | | |
| dry | suitable only under restricted conditions | | |