

Garant
Solid carbide jobber drill extra short, TiAlN, Ø DC h7: 7,7mm

Order data

Order number	122151 7,7
GTIN	4045197748669
Item class	11E

Description
Version:

Similar to DIN 6539 (extra short).

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.

Technical description

Standard	DIN 6539
Nominal Ø D_c	7.7 mm
Flute length L_c	37 mm
Tolerance nominal Ø	h7
Feed f in steel < 1100 N/mm ²	0.11 mm/rev.
Overall length L	79 mm
Shank tolerance	h7
Shank Ø D_s	7.7 mm
Number of cutting edges Z	2
recommended maximum drilling depth L_2	25.5 mm
Coating	TiAlN
Tool material	solid carbide

Type	N
Point angle	118 degrees
Helix angle	30 degrees
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		

