

Garant
Solid carbide jobber drill extra short, uncoated, Ø DC h7: 1,55mm

Order data

Order number	122100 1,55
GTIN	4045197771230
Item class	11E

Description
Version:
Similar to DIN 6539 (extra short).

Nominal Ø and shank Ø equal.

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

Overall length L	32 mm
Tolerance nominal Ø	h7
Number of cutting edges Z	2
Feed f in steel < 1100 N/mm ²	0.03 mm/rev.
Standard	DIN 6539
Shank Ø D _s	1.55 mm
Nominal Ø D _c	1.55 mm
Flute length L _c	9 mm
recommended maximum drilling depth L ₂	6.7 mm
Coating	uncoated
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	200 m/min	N
Aluminium (short chipping)	suitable	140 m/min	N
Alu > 10% Si	suitable only under restricted conditions	140 m/min	N
Steel < 500 N/mm ²	suitable	70 m/min	P
Steel < 750 N/mm ²	suitable	70 m/min	P
Steel < 900 N/mm ²	suitable	60 m/min	P
Steel < 1100 N/mm ²	suitable	40 m/min	P
Steel < 1400 N/mm ²	suitable	25 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	20 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	20 m/min	M
Ti > 850 N/mm ²	suitable	15 m/min	S
CuZn	suitable	140 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		

