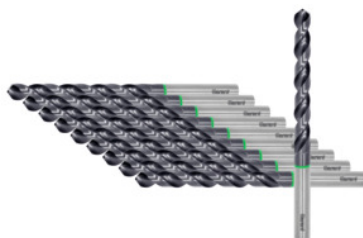


Garant**Value pack TiAlN-coated twist drills HSS-E, 10 pieces****Order data**

Order number	GG1117 6,8
GTIN	4069515043892
Item class	GGN

Description**Version:**

High performance drills for outstanding performance. Precision holes due to optimised diamond point geometry and 4-face grinding. The special flute profile yields a significant reduction in cutting forces.

Same as No. 114580.

Recommendation:**Maximum drilling depth:**

$$L_2 = L_c - 1.5 \times D_c$$

Technical description

Nominal $\varnothing D_c$	6.8 mm
Flute length L_c	69 mm
Feed f in stainless steel $> 900 \text{ N/mm}^2$	0.05 mm/rev.
Shank	Plain shank
Standard	DIN 338
recommended maximum drilling depth L_2	58.8 mm
Tolerance nominal $\varnothing$	h8

Data sheet

Point angle	118 degrees
Contents	10
Shank Ø D _s	6.8 mm
Overall length L	109 mm
Number of cutting edges Z	2
Coating	TiAlN
Tool material	HSS E
Helix angle	35 degrees
Through-coolant	no
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	75 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	65 m/min	N
Alu > 10% Si	suitable only under restricted conditions	60 m/min	N
Steel < 500 N/mm ²	suitable	50 m/min	P
Steel < 750 N/mm ²	suitable	40 m/min	P
Steel < 900 N/mm ²	suitable	35 m/min	P
Steel < 1100 N/mm ²	suitable	16 m/min	P
INOX < 900 N/mm ²	suitable	17 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	13 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	8 m/min	S
GG(G)	suitable	40 m/min	K

Data sheet

CuZn	suitable	50 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
Suitable products			

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