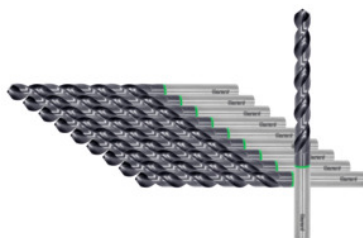


**Garant****Value pack TiAlN-coated twist drills HSS-E, 10 pieces****Order data**

|              |               |
|--------------|---------------|
| Order number | GG1117 4,9    |
| GTIN         | 4069515043717 |
| 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**

|                                          |             |
|------------------------------------------|-------------|
| Contents                                 | 10          |
| Number of cutting edges Z                | 2           |
| recommended maximum drilling depth $L_2$ | 44.7 mm     |
| Point angle                              | 118 degrees |
| Flute length $L_c$                       | 52 mm       |
| Nominal $\varnothing D_c$                | 4.9 mm      |
| Shank                                    | Plain shank |

## Data sheet

|                                                   |              |
|---------------------------------------------------|--------------|
| Overall length L                                  | 86 mm        |
| Shank Ø D <sub>s</sub>                            | 4.9 mm       |
| Standard                                          | DIN 338      |
| Tolerance nominal Ø                               | h8           |
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0.03 mm/rev. |
| 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 <sub>c</sub> | 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 <sup>2</sup>  | suitable                                  | 50 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 40 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 35 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 16 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 17 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 13 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable only under restricted conditions | 8 m/min        | S        |
| GG(G)                          | suitable                                  | 40 m/min       | K        |

|                          |          |          |   |
|--------------------------|----------|----------|---|
| CuZn                     | suitable | 50 m/min | N |
| Uni                      | suitable |          |   |
| Oil                      | suitable |          |   |
| wet maximum              | suitable |          |   |
| <b>Suitable products</b> |          |          |   |

No Shop URL available for: GG1117 4,9