

**Garant**
**HSS-E jobber drill, TiAlN, Ø DC h8: 2,7mm**

**Order data**

Order number	114580 2,7
GTIN	4045197855091
Item class	11B

**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.

**Recommendation:**
**Maximum drilling depth:**

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

**Technical description**

Standard	DIN 338
Flute length $L_c$	33 mm
Overall length $L$	61 mm
Feed $f$ in stainless steel $> 900 \text{ N/mm}^2$	0.02 mm/rev.
Nominal $\varnothing D_c$	2.7 mm
recommended maximum drilling depth $L_2$	29 mm
Number of cutting edges $Z$	2
Shank $\varnothing D_s$	2.7 mm
Tolerance nominal $\varnothing$	h8
Point angle	118 degrees
Shank	Plain shank
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		