

Garant
HSS-E jobber drill, TiAlN, Ø DC h8: 6,8mm

Order data

Order number	114580 6,8
GTIN	4045197855503
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
Nominal Ø D _c	6.8 mm
Feed f in stainless steel > 900 N/mm ²	0.05 mm/rev.
Flute length L _c	69 mm
Shank Ø D _s	6.8 mm
Number of cutting edges Z	2
Overall length L	109 mm
Tolerance nominal Ø	h8
recommended maximum drilling depth L ₂	58.8 mm
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 _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
CuZn	suitable	50 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		