

Garant
HSS-E jobber drill, TiAlN, Ø DC h8: 7,8mm

Order data

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|--------------|---------------|
| Order number | 114580 7,8 |
| GTIN | 4045197855602 |
| 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

| | |
|---|--------------|
| Number of cutting edges Z | 2 |
| Standard | DIN 338 |
| Nominal Ø D _c | 7.8 mm |
| Feed f in stainless steel > 900 N/mm ² | 0.05 mm/rev. |
| Tolerance nominal Ø | h8 |
| Overall length L | 117 mm |
| recommended maximum drilling depth L ₂ | 63.3 mm |
| Shank Ø D _s | 7.8 mm |
| Flute length L _c | 75 mm |
| Point angle | 118 degrees |
| Shank | Plain shank |
| Coating | TiAlN |

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| 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 | | |