

Garant
Jobber drill HSS-E-PM HPC, TiAlN, Ø DC h8: 6,8mm

Order data

Order number	114610 6,8
GTIN	4045197856524
Item class	11B

Description
Version:

High-performance HPC twist drills for high-alloy and high tensile materials. Particularly strong due to **strengthened core and a parabolic flute profile**. Point geometry with rake angle correction. Precise concentricity for exact holes.

With form S point.

Recommendation:
Maximum drilling depth:

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

Technical description

Flute length L_c	69 mm
Standard	DIN 338
Nominal $\varnothing D_c$	6.8 mm
Shank $\varnothing D_s$	6.8 mm
recommended maximum drilling depth L_2	58.8 mm
Feed f in steel $< 900 \text{ N/mm}^2$	0.08 mm/rev.
Overall length L	109 mm
Tolerance nominal \varnothing	h8
Number of cutting edges Z	2
Point angle	130 degrees
Shank	Plain shank

Coating	TiAlN
Tool material	HSS E PM
Helix angle	38 degrees
Through-coolant	no
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	80 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	70 m/min	N
Alu > 10% Si	suitable only under restricted conditions	60 m/min	N
Steel < 750 N/mm ²	suitable only under restricted conditions	50 m/min	P
Steel < 900 N/mm ²	suitable	40 m/min	P
Steel < 1100 N/mm ²	suitable	25 m/min	P
Steel < 1400 N/mm ²	suitable	14 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	20 m/min	M
INOX > 900 N/mm ²	suitable	15 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	12 m/min	S
GG(G)	suitable	50 m/min	K
CuZn	suitable only under restricted conditions	60 m/min	N
Uni	suitable		
Oil	suitable		

wet maximum

suitable