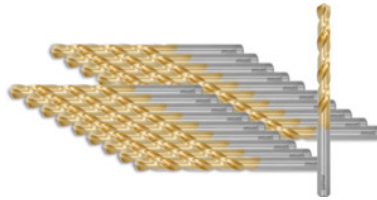




HSS jobber drill N, TiN, Ø DC h8: 4mm



Order data

Order number	GG1365 4
GTIN	4045197910813
Item class	GGN

Description

Version:

With point geometry shape C from size 2.4 mm.
Standard core without core taper.
Precision ground point.

Profile ground:

High concentricity and pitch accuracy.
Drills for series production use.

Same as No. 114360.

Recommendation:

Maximum drilling depth:

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

Technical description

Shank Ø D _s	4 mm
Nominal Ø D _c	4 mm
Number of cutting edges Z	2
Standard	DIN 338
Tolerance nominal Ø	h8
Flute length L _c	43 mm

Feed f in steel < 500 N/mm ²	0.09 mm/rev.
Overall length L	75 mm
Point angle	118 degrees
Shank	Plain shank
Contents	20
Coating	TiN
Tool material	HSS
Type	N
Helix angle	35-40 degrees
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	56 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm ²	suitable	50 m/min	P
Steel < 750 N/mm ²	suitable	37 m/min	P
Steel < 900 N/mm ²	suitable	31 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	12 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	10 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	15 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	10 m/min	M

Ti > 850 N/mm ²	suitable only under restricted conditions	6 m/min	S
GG(G)	suitable	31 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
Oil	suitable		
wet maximum	suitable		

Accessories

Jobber drill HSSN Ø DC h8 4 mm

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