



Jobber drill HSS-E N, uncoated, Ø DC h8: 7,7mm



Order data

Order number	114405 7,7
GTIN	4045197535221
Item class	12B

Description

Version:

Profile ground: this ensures high concentricity and pitch accuracy. Precision ground point. Drill for production use.

With point geometry shape C from size 2 mm

Recommendation:

Maximum drilling depth:

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

Technical description

Feed f in steel < 750 N/mm ²	0.07 mm/rev.
Flute length L _c	75 mm
Number of cutting edges Z	2
Nominal Ø D _c	7.7 mm
Tolerance nominal Ø	h8
Shank Ø D _s	7.7 mm
Overall length L	117 mm
Standard	DIN 338
recommended maximum drilling depth L ₂	63.5 mm
Point angle	135 degrees
Shank	Plain shank
Coating	uncoated

Tool material	HSS E
Type	N
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	35 m/min	P
Steel < 750 N/mm ²	suitable	28 m/min	P
Steel < 900 N/mm ²	suitable	22 m/min	P
Steel < 1100 N/mm ²	suitable	8 m/min	P
Steel < 1400 N/mm ²	suitable	6 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	8 m/min	M
Oil	suitable		
wet maximum	suitable		