

Garant
HSS-Co8 jobber drill, TiAlN, Ø DC h8: 7,7mm

Order data

Order number	114550 7,7
GTIN	4045197021267
Item class	11B

Description
Version:

Extremely high heat resistance, very robust due to **strong core**.

With point geometry shape C.

Recommendation:
Maximum drilling depth:

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

Technical description

Nominal Ø D _c	7.7 mm
Number of cutting edges Z	2
Flute length L _c	75 mm
Feed f in stainless steel > 900 N/mm ²	0.05 mm/rev.
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	TiAlN

Tool material	HSS Co 8
Helix angle	35 degrees
Through-coolant	no
Colour ring	blue
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Steel < 750 N/mm ²	suitable only under restricted conditions	37 m/min	P
Steel < 900 N/mm ²	suitable	31 m/min	P
Steel < 1100 N/mm ²	suitable	12 m/min	P
Steel < 1400 N/mm ²	suitable	10 m/min	P
INOX < 900 N/mm ²	suitable	20 m/min	M
INOX > 900 N/mm ²	suitable	15 m/min	M
Ti > 850 N/mm ²	suitable	6 m/min	S
Oil	suitable		
wet maximum	suitable		