

Garant**Solid carbide jobber drill, TiAlN, Ø DC h7: 7,7mm****Order data**

Order number	122251 7,7
GTIN	4045197749529
Item class	11E

Description**Version:****Similar to DIN 338.**

Nominal Ø and shank Ø equal.

TiAlN coating for even better performance.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Non slip clamping in drill chuck No. 341050 with diamond coated jaws.

Through-coolant: no

Standard: DIN 338

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 63.5 mm

Tolerance nominal Ø: h7

Overall length L: 117 mm

Shank Ø D_s : 7.7 mm

Feed f in steel < 1100 N/mm²: 0.11 mm/rev.

Technical description

Shank Ø D_s	7.7 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Flute length L_c	75 mm
Overall length L	117 mm
Nominal Ø D_c	7.7 mm

Shank tolerance	h7
Standard	DIN 338
Feed f in steel < 1100 N/mm ²	0.11 mm/rev.
recommended maximum drilling depth L ₂	63.5 mm
Coating	TiAlN
Tool material	solid carbide
Type	N
Point angle	118 °
Helix angle	30 °
Shank	Parallel shank to h7
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	260 m/min	N
Aluminium (short chipping)	suitable	180 m/min	N
Alu > 10% Si	suitable	180 m/min	N
Steel < 500 N/mm ²	suitable	90 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 N/mm ²	suitable	80 m/min	P
Steel < 1100 N/mm ²	suitable	60 m/min	P
Steel < 1400 N/mm ²	suitable	35 m/min	P
INOX < 900 N/mm ²	suitable	35 m/min	M
INOX > 900 N/mm ²	suitable	25 m/min	M
Ti > 850 N/mm ²	suitable	25 m/min	S

GG(G)	suitable	90 m/min	K
CuZn	suitable	180 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		