

**Garant**
**Solid carbide jobber drill, TiAlN, Ø DC h7: 6,8mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122251 6,8    |
| GTIN         | 4045197749468 |
| 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  $L_2$ : 58.8 mm

Tolerance nominal Ø: h7

Overall length L: 109 mm

Shank Ø  $D_s$ : 6.8 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.11 mm/rev.

**Technical description**

|  |              |
|--|--------------|
| Overall length L                         | 109 mm       |
| Standard                                 | DIN 338      |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.11 mm/rev. |
| Number of cutting edges Z                | 2            |
| Flute length $L_c$                       | 69 mm        |
| Shank Ø $D_s$                            | 6.8 mm       |

|  |                      |
|--|----------------------|
| Tolerance nominal $\varnothing$          | h7                   |
| Shank tolerance                          | h7                   |
| Nominal $\varnothing D_c$                | 6.8 mm               |
| recommended maximum drilling depth $L_2$ | 58.8 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 <sup>2</sup>  | suitable                                  | 90 m/min  | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 90 m/min  | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 80 m/min  | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 60 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 35 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 35 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 25 m/min  | M        |
| Ti > 850 N/mm <sup>2</sup>     | 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<br>restricted conditions |           |   |