

**Garant**
**Solid carbide jobber drill, TiAlN, Ø DC h7: 1mm**

**Order data**

Order number	122251 1
GTIN	4045197748898
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  $L_2$ : 10.5 mm

Tolerance nominal Ø: h7

Overall length L: 34 mm

Shank Ø  $D_s$ : 1 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.03 mm/rev.

**Technical description**

Flute length $L_c$	12 mm
Standard	DIN 338
Number of cutting edges Z	2
Feed f in steel < 1100 N/mm <sup>2</sup>	0.03 mm/rev.
Nominal Ø $D_c$	1 mm
Overall length L	34 mm

Shank $\varnothing D_s$	1 mm
Shank tolerance	h7
Tolerance nominal $\varnothing$	h7
recommended maximum drilling depth $L_2$	10.5 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 <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 restricted conditions		