

Garant**Value pack solid carbide jobber drill extra short, 5 pieces****Order data**

Order number	GG1251 8,5
GTIN	4067263106562
Item class	GGN

Description**Version:**

With the same nominal and shank $\varnothing$.
TiAlN coating for even better performance.
Similar to DIN 6539 (extra-short).

Same as number: 122151.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.
Non slip clamping in drill chuck No. 341050 with diamond coated clamping jaws.

Technical description

Shank $\varnothing D_s$	8.5 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.11 mm/rev.
recommended maximum drilling depth L_2	24.3 mm
Shank tolerance	h7
Flute length L_c	37 mm
Tolerance nominal $\varnothing$	h7

Data sheet

Number of cutting edges Z	2
Standard	DIN 6539
Overall length L	79 mm
Nominal Ø D _c	8.5 mm
Contents	5"
Coating	TiAlN
Tool material	Solid carbide
Type	N
Point angle	118 degrees
Helix angle	30 degrees
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		
Suitable products			

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