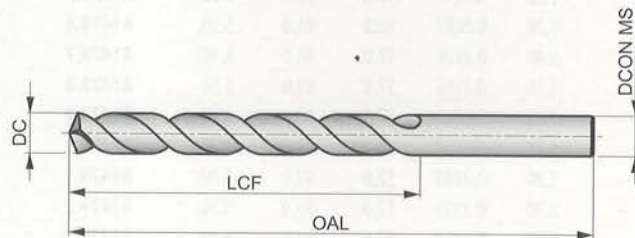


# A777



## HSS-E (8% Cobalt) Jobber Drill, Bronze Tempered Finish

A top performer, producing accurate sized holes with a quality finish in high strength materials. The 135° split point helps to self-center. The bronze finish is a thin oxide layer formed on the tool surface and is an indication for 8% Cobalt HSS-E Drill.



HSS-E	DIN 338	4xD
135°	Bronze	
λ 20-35°	R	DC h8

Workpiece material group suitability, starting values for cutting speed (m/min) and feed Alpha Code. Tables with feed per revolution can be found starting from page 175.

<b>P1.1</b> ■ 36 H	<b>P1.2</b> ■ 40 H	<b>P1.3</b> ■ 41 H	<b>P2.1</b> ■ 31 H	<b>P2.2</b> ■ 27 G	<b>P2.3</b> ■ 24 E	<b>P3.1</b> ■ 25 F	<b>P3.2</b> ■ 20 F	<b>P3.3</b> ■ 17 E	<b>P4.1</b> ■ 15 F	<b>P4.2</b> ■ 13 E	<b>P4.3</b> ■ 10 D	<b>M1.1</b> ■ 30 E	<b>M1.2</b> ■ 26 E
<b>M2.1</b> ■ 27 E	<b>M2.2</b> ■ 22 E	<b>M3.1</b> ■ 13 G	<b>M3.2</b> ■ 11 G	<b>M3.3</b> ■ 10 G	<b>M4.1</b> ■ 15 C	<b>K1.1</b> ■ 35 H	<b>K1.2</b> ■ 26 D	<b>K1.3</b> ■ 19 D	<b>K2.1</b> ■ 27 E	<b>K2.2</b> ■ 22 E	<b>K2.3</b> ■ 18 E	<b>K3.1</b> ■ 24 E	<b>K3.2</b> ■ 18 E
<b>K3.3</b> ■ 15 E	<b>K4.1</b> ■ 22 E	<b>K4.2</b> ■ 17 E	<b>K4.3</b> ■ 12 E	<b>K4.4</b> ■ 11 E	<b>K4.5</b> ■ 9 E	<b>K5.1</b> ■ 25 E	<b>K5.2</b> ■ 19 E	<b>K5.3</b> ■ 15 E	<b>N1.1</b> ■ 33 J	<b>N1.2</b> ■ 25 J	<b>N1.3</b> ■ 17 I	<b>N2.1</b> ■ 46 H	<b>N2.2</b> ■ 42 H
<b>N2.3</b> ■ 30 H	<b>N3.1</b> ■ 68 H	<b>N3.2</b> ■ 40 F	<b>N3.3</b> ■ 20 H	<b>S1.1</b> ■ 28 F	<b>S1.2</b> ■ 20 D	<b>S1.3</b> ■ 11 C	<b>S2.1</b> ■ 9 E	<b>S2.2</b> ■ 8 B	<b>S3.1</b> ■ 7 E	<b>S3.2</b> ■ 6 B	<b>S4.1</b> ■ 5 E	<b>S4.2</b> ■ 5 B	

NAS907J. DC ≤ 1.4mm 4 Facet Point.

Products from this series are also available in set. Please see A295.

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)			
A777.3	-	0.30	0.0118	3.0	19.0	0.30
A777.35	-	0.35	0.0138	4.0	19.0	0.35
A777.4	-	0.40	0.0157	5.0	20.0	0.40
A777.45	-	0.45	0.0177	5.0	20.0	0.45
A777.5	-	0.50	0.0197	6.0	22.0	0.50
A777.55	-	0.55	0.0217	7.0	24.0	0.55
A777.6	-	0.60	0.0236	7.0	24.0	0.60
A777.65	-	0.65	0.0256	8.0	26.0	0.65
A777.7	-	0.70	0.0276	9.0	28.0	0.70
A777.8	-	0.80	0.0315	10.0	30.0	0.80
A777.9	-	0.90	0.0354	11.0	32.0	0.90
A777.95	-	0.95	0.0374	11.0	32.0	0.95
A7771.0	-	1.00	0.0394	12.0	34.0	1.00
A7771.1	-	1.10	0.0433	14.0	36.0	1.10
A7771.2	-	1.20	0.0472	16.0	38.0	1.20
A7771.3	-	1.30	0.0512	16.0	38.0	1.30
A7771.4	-	1.40	0.0551	18.0	40.0	1.40
A7771.5	-	1.50	0.0591	18.0	40.0	1.50
A7771/16	1/16	1.59	0.0625	20.0	43.0	1.59
A7771.6	-	1.60	0.0630	20.0	43.0	1.60
A7771.7	-	1.70	0.0669	20.0	43.0	1.70
A7771.8	-	1.80	0.0709	22.0	46.0	1.80
A7771.9	-	1.90	0.0748	22.0	46.0	1.90
A7775/64	5/64	1.98	0.0781	24.0	49.0	1.98

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)			
A7772.0	-	2.00	0.0787	24.0	49.0	2.00
A7772.1	-	2.10	0.0827	24.0	49.0	2.10
A7772.2	-	2.20	0.0866	27.0	53.0	2.20
A7772.3	-	2.30	0.0906	27.0	53.0	2.30
A7773/32	3/32	2.38	0.0938	30.0	57.0	2.38
A7772.4	-	2.40	0.0945	30.0	57.0	2.40
A7772.5	-	2.50	0.0984	30.0	57.0	2.50
A7772.6	-	2.60	0.1024	30.0	57.0	2.60
A7772.7	-	2.70	0.1063	33.0	61.0	2.70
A7777/64	7/64	2.78	0.1094	33.0	61.0	2.78
A7772.8	-	2.80	0.1102	33.0	61.0	2.80
A7772.9	-	2.90	0.1142	33.0	61.0	2.90
A7773.0	-	3.00	0.1181	33.0	61.0	3.00
A7773.1	-	3.10	0.1220	36.0	65.0	3.10
A7771/8	1/8	3.18	0.1250	36.0	65.0	3.18
A7773.2	-	3.20	0.1260	36.0	65.0	3.20
A7773.3	-	3.30	0.1299	36.0	65.0	3.30
A7773.4	-	3.40	0.1339	39.0	70.0	3.40
A7773.5	-	3.50	0.1378	39.0	70.0	3.50
A7779/64	9/64	3.57	0.1406	39.0	70.0	3.57
A7773.6	-	3.60	0.1417	39.0	70.0	3.60
A7773.7	-	3.70	0.1457	39.0	70.0	3.70
A7773.8	-	3.80	0.1496	43.0	75.0	3.80
A7773.9	-	3.90	0.1535	43.0	75.0	3.90

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A7775/32	5/32	3.97	0.1563	43.0	75.0	3.97
A7774.0	—	4.00	0.1575	43.0	75.0	4.00
A7774.1	—	4.10	0.1614	43.0	75.0	4.10
A7774.2	—	4.20	0.1654	43.0	75.0	4.20
A7774.3	—	4.30	0.1693	47.0	80.0	4.30
A77711/64	11/64	4.37	0.1719	47.0	80.0	4.37
A7774.4	—	4.40	0.1732	47.0	80.0	4.40
A7774.5	—	4.50	0.1772	47.0	80.0	4.50
A7774.6	—	4.60	0.1811	47.0	80.0	4.60
A7774.7	—	4.70	0.1850	47.0	80.0	4.70
A7773/16	3/16	4.76	0.1875	52.0	86.0	4.76
A7774.8	—	4.80	0.1890	52.0	86.0	4.80
A7774.9	—	4.90	0.1929	52.0	86.0	4.90
A7775.0	—	5.00	0.1969	52.0	86.0	5.00
A7775.1	—	5.10	0.2008	52.0	86.0	5.10
A77713/64	13/64	5.16	0.2031	52.0	86.0	5.16
A7775.2	—	5.20	0.2047	52.0	86.0	5.20
A7775.3	—	5.30	0.2087	52.0	86.0	5.30
A7775.4	—	5.40	0.2126	57.0	93.0	5.40
A7775.5	—	5.50	0.2165	57.0	93.0	5.50
A7777/32	7/32	5.56	0.2188	57.0	93.0	5.56
A7775.6	—	5.60	0.2205	57.0	93.0	5.60
A7775.7	—	5.70	0.2244	57.0	93.0	5.70
A7775.8	—	5.80	0.2283	57.0	93.0	5.80
A7775.9	—	5.90	0.2323	57.0	93.0	5.90
A77715/64	15/64	5.95	0.2344	57.0	93.0	5.95
A7776.0	—	6.00	0.2362	57.0	93.0	6.00
A7776.1	—	6.10	0.2402	63.0	101.0	6.10
A7776.2	—	6.20	0.2441	63.0	101.0	6.20
A7776.3	—	6.30	0.2480	63.0	101.0	6.30
A7771/4	1/4	6.35	0.2500	63.0	101.0	6.35
A7776.4	—	6.40	0.2520	63.0	101.0	6.40
A7776.5	—	6.50	0.2559	63.0	101.0	6.50
A7776.6	—	6.60	0.2598	63.0	101.0	6.60
A7776.7	—	6.70	0.2638	63.0	101.0	6.70
A77717/64	17/64	6.75	0.2656	69.0	109.0	6.75
A7776.8	—	6.80	0.2677	69.0	109.0	6.80
A7776.9	—	6.90	0.2717	69.0	109.0	6.90
A7777.0	—	7.00	0.2756	69.0	109.0	7.00
A7777.1	—	7.10	0.2795	69.0	109.0	7.10
A7779/32	9/32	7.14	0.2813	69.0	109.0	7.14
A7777.2	—	7.20	0.2835	69.0	109.0	7.20
A7777.3	—	7.30	0.2874	69.0	109.0	7.30
A7777.4	—	7.40	0.2913	69.0	109.0	7.40
A7777.5	—	7.50	0.2953	69.0	109.0	7.50
A77719/64	19/64	7.54	0.2969	75.0	117.0	7.54
A7777.6	—	7.60	0.2992	75.0	117.0	7.60
A7777.7	—	7.70	0.3031	75.0	117.0	7.70
A7777.8	—	7.80	0.3071	75.0	117.0	7.80
A7777.9	—	7.90	0.3110	75.0	117.0	7.90
A7775/16	5/16	7.94	0.3125	75.0	117.0	7.94
A7778.0	—	8.00	0.3150	75.0	117.0	8.00

Product	DC	DC	DC	LCF	OAL	DCON MS
	(inch)	(mm)	(inch)	(mm)	(mm)	(mm)
A7778.1	—	8.10	0.3189	75.0	117.0	8.10
A7778.2	—	8.20	0.3228	75.0	117.0	8.20
A7778.3	—	8.30	0.3268	75.0	117.0	8.30
A77721/64	21/64	8.33	0.3281	75.0	117.0	8.33
A7778.4	—	8.40	0.3307	75.0	117.0	8.40
A7778.5	—	8.50	0.3346	75.0	117.0	8.50
A7778.6	—	8.60	0.3386	81.0	125.0	8.60
A7778.7	—	8.70	0.3425	81.0	125.0	8.70
A77711/32	11/32	8.73	0.3438	81.0	125.0	8.73
A7778.8	—	8.80	0.3465	81.0	125.0	8.80
A7778.9	—	8.90	0.3504	81.0	125.0	8.90
A7779.0	—	9.00	0.3543	81.0	125.0	9.00
A7779.1	—	9.10	0.3583	81.0	125.0	9.10
A77723/64	23/64	9.13	0.3594	81.0	125.0	9.13
A7779.2	—	9.20	0.3622	81.0	125.0	9.20
A7779.3	—	9.30	0.3661	81.0	125.0	9.30
A7779.4	—	9.40	0.3701	81.0	125.0	9.40
A7779.5	—	9.50	0.3740	81.0	125.0	9.50
A7773/8	3/8	9.52	0.3750	87.0	133.0	9.52
A7779.6	—	9.60	0.3780	87.0	133.0	9.60
A7779.7	—	9.70	0.3819	87.0	133.0	9.70
A7779.8	—	9.80	0.3858	87.0	133.0	9.80
A7779.9	—	9.90	0.3898	87.0	133.0	9.90
A77725/64	25/64	9.92	0.3906	87.0	133.0	9.92
A77710.0	—	10.00	0.3937	87.0	133.0	10.00
A77710.1	—	10.10	0.3976	87.0	133.0	10.10
A77710.2	—	10.20	0.4016	87.0	133.0	10.20
A77713/32	13/32	10.32	0.4063	87.0	133.0	10.32
A77710.5	—	10.50	0.4134	87.0	133.0	10.50
A77727/64	27/64	10.72	0.4219	94.0	142.0	10.72
A77710.8	—	10.80	0.4252	94.0	142.0	10.80
A77711.0	—	11.00	0.4331	94.0	142.0	11.00
A7777/16	7/16	11.11	0.4375	94.0	142.0	11.11
A77711.2	—	11.20	0.4409	94.0	142.0	11.20
A77711.5	—	11.50	0.4528	94.0	142.0	11.50
A77729/64	29/64	11.51	0.4531	94.0	142.0	11.51
A77711.8	—	11.80	0.4646	94.0	142.0	11.80
A77715/32	15/32	11.91	0.4688	101.0	151.0	11.91
A77712.0	—	12.00	0.4724	101.0	151.0	12.00
A77712.2	—	12.20	0.4803	101.0	151.0	12.20
A77731/64	31/64	12.30	0.4844	101.0	151.0	12.30
A77712.5	—	12.50	0.4921	101.0	151.0	12.50
A7771/2	1/2	12.70	0.5000	101.0	151.0	12.70
A77712.8	—	12.80	0.5039	101.0	151.0	12.80
A77713.0	—	13.00	0.5118	101.0	151.0	13.00
A77713.5	—	13.50	0.5315	108.0	160.0	13.50
A77714.0	—	14.00	0.5512	108.0	160.0	14.00
A77714.5	—	14.50	0.5709	114.0	169.0	14.50
A77715.0	—	15.00	0.5906	114.0	169.0	15.00
A77715.5	—	15.50	0.6102	120.0	178.0	15.50
A77716.0	—	16.00	0.6299	120.0	178.0	16.00