

**Garant****HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 13/32****Order data**

|              |               |
|--------------|---------------|
| Order number | 114150 13/32  |
| GTIN         | 4045197364456 |
| Item class   | 11B           |

**Description****Version:**

Profile ground: Jobber drill with high pitch accuracy and concentricity as well as precision ground point.

Steam tempered from Ø 2.4 mm.

With point geometry shape C from size 4 mm

**Recommendation:****Maximum drilling depth:**

$L_2 = L_c - 1.5 \times D_c$ .

**Note:**

Size 16 - 20: Drills with shank Ø 16 mm.

Through-coolant: no

Standard: DIN 338

Tolerance nominal Ø: h8

Point angle: 118 °

Shank: Plain shank

Number of cutting edges Z: 2

Inch nominal Ø corresponds to: 10.32 mm

recommended maximum drilling depth  $L_2$ : 71.5 mm

Flute length  $L_c$ : 87 mm

Overall length L: 133 mm

Shank Ø  $D_s$ : 10.32 mm

Feed f in steel < 750 N/mm<sup>2</sup>: 0.1 mm/rev.

**Technical description**

|                           |       |
|---------------------------|-------|
| Number of cutting edges Z | 2     |
| Flute length $L_c$        | 87 mm |

|                                                   |              |
|---------------------------------------------------|--------------|
| Inch nominal Ø corresponds to                     | 10.32 mm     |
| Feed f in steel < 750 N/mm <sup>2</sup>           | 0.1 mm/rev.  |
| Tolerance nominal Ø                               | h8           |
| Shank Ø D <sub>s</sub>                            | 10.32 mm     |
| Overall length L                                  | 133 mm       |
| Standard                                          | DIN 338      |
| recommended maximum drilling depth L <sub>2</sub> | 71.5 mm      |
| Point angle                                       | 118°         |
| Shank                                             | Plain shank  |
| Coating                                           | uncoated     |
| Tool material                                     | HSS          |
| Type                                              | N            |
| Through-coolant                                   | no           |
| Colour ring                                       | without      |
| Type of product                                   | Jobber drill |

## User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|-------------------------------------------|----------------|----------|
| Alu plastics                   | suitable only under restricted conditions | 80 m/min       | N        |
| Aluminium (short chipping)     | suitable only under restricted conditions | 45 m/min       | N        |
| Alu > 10% Si                   | suitable only under restricted conditions | 50 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 40 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 30 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 25 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 10 m/min       | P        |

|                                |                                              |          |   |
|--------------------------------|----------------------------------------------|----------|---|
| Steel < 1400 N/mm <sup>2</sup> | suitable only under<br>restricted conditions | 8 m/min  | P |
| GG(G)                          | suitable                                     | 25 m/min | K |
| CuZn                           | suitable                                     | 80 m/min | N |
| Oil                            | suitable                                     |          |   |
| wet maximum                    | suitable                                     |          |   |