

Garant**HSS jobber drill N, uncoated, Ø DC h8 (mm or inch): 13,8****Order data**

Order number	114150 13,8
GTIN	4045197013767
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

recommended maximum drilling depth L_2 : 87.3 mm

Flute length L_c : 108 mm

Overall length L: 160 mm

Shank Ø D_s : 13.8 mm

Feed f in steel < 750 N/mm²: 0.16 mm/rev.

Technical description

Number of cutting edges Z	2
Flute length L_c	108 mm
Nominal Ø D_c	13.8 mm

Feed f in steel < 750 N/mm ²	0.16 mm/rev.
Tolerance nominal Ø	h8
Shank Ø D _s	13.8 mm
Overall length L	160 mm
Standard	DIN 338
recommended maximum drilling depth L ₂	87.3 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 _c	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 ²	suitable	40 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable	25 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	10 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	8 m/min	P

GG(G)	suitable	25 m/min	K
CuZn	suitable	80 m/min	N
Oil	suitable		
wet maximum	suitable		