

Garant**Jobber drill with 3 clamping faces HSS-E, uncoated, Ø DC h8: 19mm****Order data**

Order number	114001 19
GTIN	4045197955258
Item class	11B

Description**Version:**

Particularly sturdy and robust due to the **strengthened core diameter**. Ground flutes, with high concentricity. Precision ground point.

Recommendation:**Maximum drilling depth:**

$$L_2 = L_c - 1.5 \times D_c$$

Note:

Shank Ø 12.5 mm.

Three **drive flats on the shank** for use in a 3-jaw chuck.

Technical description

Overall length L	198 mm
Number of cutting edges Z	2
recommended maximum drilling depth L_2	106.5 mm
Nominal Ø D_c	19 mm
Shank Ø D_s	12.5 mm
Flute length L_c	135 mm
Tolerance nominal Ø	h8
Feed f in steel < 900 N/mm ²	0.2 mm/rev.
Standard	DIN 338
Point angle	135 degrees

Shank	Three drive flats shank
Coating	uncoated
Tool material	HSS E
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	70 m/min	N
Aluminium (short chipping)	suitable only under restricted conditions	45 m/min	N
Alu > 10% Si	suitable only under restricted conditions	40 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	10 m/min	P
Steel < 1400 N/mm ²	suitable	8 m/min	P
INOX < 900 N/mm ²	suitable	12 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	8 m/min	M
GG(G)	suitable only under restricted conditions	25 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		

