

**Jobber drill set HSS No. 114360 as refill set, TiN, Type: 1-13KB****Order data**

Order number	115265 1-13KB
GTIN	4045197657657
Item class	12B

Description**Version:**

Composed of jobber drills DIN 338.
Standard core without core taper.
Precision ground point.

Profile ground:

High concentricity and pitch accuracy, drills for series production use.
With point geometry shape C from size 2.4 mm.

Technical description

Incremental steps of drills	0.5 mm
Drill range	1 - 13 mm
Number of drills	29
Shank	Plain shank
Tapping hole Ø	3.3; 4.2; 6.8; 10.2 mm
Number of cutting edges Z	2
Coating	TiN
Tool material	HSS

Standard	DIN 338
Type	N
Tolerance nominal Ø	h8
Point angle	118 degrees
Helix angle	35-40 degrees
Through-coolant	no
with case	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	56 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm ²	suitable	50 m/min	P
Steel < 750 N/mm ²	suitable	37 m/min	P
Steel < 900 N/mm ²	suitable	31 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	12 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	10 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	15 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	10 m/min	M
Ti > 850 N/mm ²	suitable only under restricted conditions	6 m/min	S
GG(G)	suitable	31 m/min	K

CuZn	suitable only under restricted conditions	80 m/min	N
Oil	suitable		
wet maximum	suitable		

Accessories

Jobber drill HSSN Ø DC h8 4,2 mm	114360 4,2
Jobber drill HSSN Ø DC h8 5,5 mm	114360 5,5
Jobber drill HSSN Ø DC h8 12 mm	114360 12
Jobber drill HSSN Ø DC h8 1 mm	114360 1
Jobber drill HSSN Ø DC h8 11,5 mm	114360 11,5
Jobber drill HSSN Ø DC h8 9 mm	114360 9
Jobber drill HSSN Ø DC h8 3 mm	114360 3
Jobber drill HSSN Ø DC h8 10,5 mm	114360 10,5
Jobber drill HSSN Ø DC h8 13 mm	114360 13
Jobber drill HSSN Ø DC h8 3,5 mm	114360 3,5
Jobber drill HSSN Ø DC h8 7,5 mm	114360 7,5
Jobber drill HSSN Ø DC h8 6,5 mm	114360 6,5
Jobber drill HSSN Ø DC h8 10,2 mm	114360 10,2
Jobber drill HSSN Ø DC h8 6 mm	114360 6
Jobber drill HSSN Ø DC h8 7 mm	114360 7
Jobber drill HSSN Ø DC h8 1,5 mm	114360 1,5
Jobber drill HSSN Ø DC h8 5 mm	114360 5
Jobber drill HSSN Ø DC h8 4 mm	114360 4
Jobber drill HSSN Ø DC h8 8 mm	114360 8
Jobber drill HSSN Ø DC h8 11 mm	114360 11
Jobber drill HSSN Ø DC h8 4,5 mm	114360 4,5
Jobber drill HSSN Ø DC h8 8,5 mm	114360 8,5
Jobber drill HSSN Ø DC h8 9,5 mm	114360 9,5

Jobber drill HSSN Ø DC h8 2 mm	114360 2
Jobber drill HSSN Ø DC h8 12,5 mm	114360 12,5
Jobber drill HSSN Ø DC h8 3,3 mm	114360 3,3
Jobber drill HSSN Ø DC h8 2,5 mm	114360 2,5
Jobber drill HSSN Ø DC h8 6,8 mm	114360 6,8
Jobber drill HSSN Ø DC h8 10 mm	114360 10
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