

**Garant****Jobber drill with 3 clamping faces HSS-E, uncoated, Ø DC h8: 12mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 114001 12     |
| GTIN         | 4045197750099 |
| 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:**

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

**Technical description**

|                                          |                         |
|------------------------------------------|-------------------------|
| Flute length $L_c$                       | 101 mm                  |
| Tolerance nominal $\varnothing$          | h8                      |
| Shank $\varnothing D_s$                  | 12 mm                   |
| Standard                                 | DIN 338                 |
| Nominal $\varnothing D_c$                | 12 mm                   |
| Overall length $L$                       | 151 mm                  |
| Number of cutting edges $Z$              | 2                       |
| Feed $f$ in steel $< 900 \text{ N/mm}^2$ | 0.16 mm/rev.            |
| recommended maximum drilling depth $L_2$ | 83 mm                   |
| Point angle                              | 130 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 <sub>c</sub> | 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 <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                                  | 10 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 8 m/min        | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 12 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | 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                                  |                |          |

