

## Garant

### Jobber drill with stepped tip HSS N, uncoated, Ø DC h8: 1 mm



#### Order data

Order number	114004 1
GTIN	4062406877279
Item class	11Q

#### Description

##### Version:

Chamfers are nitrided. Particularly sturdy and robust due to the **strengthened core diameter**. Ground flutes, with high concentricity. Precision ground point. Three **drive flats on the shank** for use in a 3-jaw chuck.

- **Ideal for producing precise holes in sheet metal, pipes, and profiles.**
- **Reliable spot drilling without centring or centre punching – even on curved surfaces – thanks to innovative ground point.**
- **Oblique drilling possible without any problems after the first level of the drill tip has penetrated the material.**
- **Drilling with significantly less force required than with conventional DIN338 HSS drills – up to a diameter of 13 mm directly in the cordless drill/driver.**
- **Stable and secure form fit in the 3-jaw chuck.**
- **General use across a wide spectrum of materials including plastic, wood and acrylic without tearing or splintering.**
- **The drill does not rattle or dig in – even in the case of thin-walled materials.**
- **Burr-free drill exit.**
- **Ideal for drilling out bolts and rivets.**

##### Recommendation:

##### Maximum drilling depth:

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

##### Note:

Drills with plain shank, **without drive flat**.

#### Technical description

Nominal Ø D <sub>c</sub>	1 mm
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Overall length L	34 mm
recommended maximum drilling depth L <sub>2</sub>	10.5 mm
Flute length L <sub>c</sub>	12 mm
Point angle	118°
Feed f in steel < 750 N/mm <sup>2</sup>	0.02 mm/rev.
Tolerance nominal Ø	h8
Standard	DIN 338
Number of cutting edges Z	2
Shank Ø D <sub>s</sub>	1 mm
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	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 only under restricted conditions	10 m/min	P

GG(G)	suitable	25 m/min	K
CuZn	suitable only under restricted conditions		
Oil	suitable		
wet maximum	suitable		