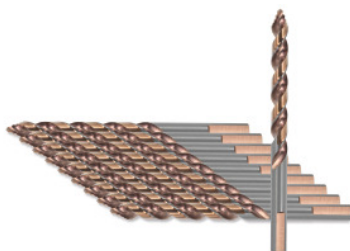


**Garant****Jobber drill with stepped tip HSS N, uncoated, Ø DC h8: 12mm****Order data**

Order number	GG4005 12
GTIN	4067263133704
Item class	GGN

**Description****Version:****Same as No. 114004.**

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.**

With special cutter geometry also for use in stainless steels.

**Recommendation:****Maximum drilling depth:**

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

## Technical description

Shank	Three drive flats shank
Overall length L	151 mm
Point angle	118 degrees
recommended maximum drilling depth L <sub>2</sub>	83 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h8
Standard	DIN 338
Shank Ø D <sub>s</sub>	12 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.2 mm/rev.
Nominal Ø D <sub>c</sub>	12 mm
Flute length L <sub>c</sub>	101 mm
Coating	uncoated
Tool material	HSS
Type	N
Through-coolant	no
Colour ring	without
Type of product	Twist 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	70 m/min	N
Alu > 10% Si	suitable only under restricted conditions	50 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	30 m/min	P

Steel < 750 N/mm <sup>2</sup>	suitable	27 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	22 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	50 m/min	N
Oil	suitable		
wet maximum	suitable		

## Accessories

Jobber drill with stepped tip HSSN Ø DC h8 12 mm

114004 12