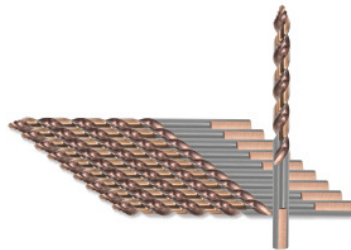


**Garant**
**Jobber drill with stepped tip HSS N, uncoated, Ø DC h8: 13mm**

**Order data**

Order number	GG4005 13
GTIN	4067263133728
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

Flute length $L_c$	101 mm
Nominal $\varnothing D_c$	13 mm
Feed $f$ in steel $< 750 \text{ N/mm}^2$	0.2 mm/rev.
Number of cutting edges $Z$	2
Overall length $L$	151 mm
Point angle	118 degrees
recommended maximum drilling depth $L_2$	81.5 mm
Tolerance nominal $\varnothing$	h8
Standard	DIN 338
Shank	Three drive flats shank
Shank $\varnothing D_s$	13 mm
Coating	uncoated
Tool material	HSS
Type	N
Through-coolant	no
Colour ring	without
Type of product	Twist 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	70 m/min	N
Alu $> 10\% \text{ Si}$	suitable only under restricted conditions	50 m/min	N
Steel $< 500 \text{ N/mm}^2$	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 13 mm

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