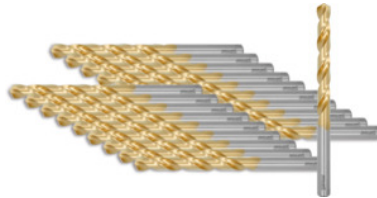




## HSS jobber drill N, TiN, Ø DC h8: 13mm



### Order data

Order number	GG1365 13
GTIN	4045197911025
Item class	GGN

### Description

#### Version:

With point geometry shape C from size 2.4 mm.  
Standard core without core taper.  
Precision ground point.

#### Profile ground:

High concentricity and pitch accuracy.  
Drills for series production use.

**Same as No. 114360.**

#### Recommendation:

#### Maximum drilling depth:

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

### Technical description

Shank Ø D <sub>s</sub>	13 mm
Number of cutting edges Z	2
Standard	DIN 338
Nominal Ø D <sub>c</sub>	13 mm
Feed f in steel < 500 N/mm <sup>2</sup>	0.2 mm/rev.
Tolerance nominal Ø	h8

Flute length $L_c$	101 mm
Overall length L	151 mm
Point angle	118 degrees
Shank	Plain shank
Contents	20
Coating	TiN
Tool material	HSS
Type	N
Helix angle	35-40 degrees
Through-coolant	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 <sup>2</sup>	suitable	50 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	37 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	31 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	10 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	15 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	10 m/min	M

Ti > 850 N/mm <sup>2</sup>	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		

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## Accessories

Jobber drill HSSN Ø DC h8 13 mm

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