

**Garant**
**Jobber drill set HSS-E No. 114400 as refill set, uncoated, Type: 1-13KB**

**Order data**

Order number	115300 1-13KB
GTIN	4045197943064
Item class	11B

**Description**
**Version:**

Composed of jobber drills DIN 338.

**Profile ground:** high radial run-out and pitch accuracy, as well as precise point grinding. Drill for series production use.

**Reinforced core,** bright finish.

With point geometry shape C from size 2 mm.

Through-coolant: no

Shank: Plain shank

Number of cutting edges Z: 2

Drill range: 1 - 13 mm

Number of drills: 29

Tapping hole Ø: 3.3; 4.2; 6.8; 10.2 mm

Incremental steps of drills: 0.5 mm

**Technical description**

Tapping hole Ø	3.3; 4.2; 6.8; 10.2 mm
Shank	Plain shank
Number of drills	29
Incremental steps of drills	0.5 mm
Drill range	1 - 13 mm
Number of cutting edges Z	2
Coating	uncoated
Tool material	HSS E

Standard	DIN 338
Type	N
Tolerance nominal $\varnothing$	h8
Point angle	130 °
Through-coolant	no
with case	no
Colour ring	red
Type of product	Jobber drill

### User data

	Suitability	$V_c$	ISO code
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
TOOLOX 33	suitable	8 m/min	H
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
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	5 m/min	S
GG(G)	suitable	25 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		

## Accessories

Jobber drill HSS-E Ø DC h8 3 mm	114400 3
Jobber drill HSS-E Ø DC h8 3,3 mm	114400 3,3
Jobber drill HSS-E Ø DC h8 11,5 mm	114400 11,5
Jobber drill HSS-E Ø DC h8 6,5 mm	114400 6,5
Jobber drill HSS-E Ø DC h8 10,2 mm	114400 10,2
Jobber drill HSS-E Ø DC h8 12 mm	114400 12
Jobber drill HSS-E Ø DC h8 10 mm	114400 10
Jobber drill HSS-E Ø DC h8 4,2 mm	114400 4,2
Jobber drill HSS-E Ø DC h8 9,5 mm	114400 9,5
Jobber drill HSS-E Ø DC h8 7 mm	114400 7
Jobber drill HSS-E Ø DC h8 8,5 mm	114400 8,5
Jobber drill HSS-E Ø DC h8 4,5 mm	114400 4,5
Jobber drill HSS-E Ø DC h8 10,5 mm	114400 10,5
Jobber drill HSS-E Ø DC h8 2 mm	114400 2
Jobber drill HSS-E Ø DC h8 7,5 mm	114400 7,5
Jobber drill HSS-E Ø DC h8 8 mm	114400 8
Jobber drill HSS-E Ø DC h8 6 mm	114400 6
Jobber drill HSS-E Ø DC h8 13 mm	114400 13
Jobber drill HSS-E Ø DC h8 5,5 mm	114400 5,5
Jobber drill HSS-E Ø DC h8 12,5 mm	114400 12,5
Jobber drill HSS-E Ø DC h8 2,5 mm	114400 2,5
Jobber drill HSS-E Ø DC h8 6,8 mm	114400 6,8
Jobber drill HSS-E Ø DC h8 9 mm	114400 9
Jobber drill HSS-E Ø DC h8 1,5 mm	114400 1,5
Jobber drill HSS-E Ø DC h8 5 mm	114400 5
Jobber drill HSS-E Ø DC h8 1 mm	114400 1
Jobber drill HSS-E Ø DC h8 4 mm	114400 4
Jobber drill HSS-E Ø DC h8 3,5 mm	114400 3,5

Jobber drill HSS-E Ø DC h8 11 mm	114400 11
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