

**Garant****Jobber drill with 3 clamping faces HSS-E, uncoated, Ø DC h8: 18mm****Order data**

Order number	114001 18
GTIN	4045197955241
Item class	11B

**Description****Version:**

Particularly sturdy and robust due to the **strengthened core diameter**. Ground flutes, with high concentricity. Precision ground point.

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

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

**Note:**

Shank Ø 12.5 mm.

Three **drive flats on the shank** for use in a 3-jaw chuck.

**Technical description**

Overall length L	191 mm
Standard	DIN 338
Tolerance nominal Ø	h8
Feed f in steel < 900 N/mm <sup>2</sup>	0.2 mm/rev.
Shank Ø D <sub>s</sub>	12.5 mm
Flute length L <sub>c</sub>	130 mm
Nominal Ø D <sub>c</sub>	18 mm
Number of cutting edges Z	2
recommended maximum drilling depth L <sub>2</sub>	103 mm
Point angle	135 degrees

Shank	Three drive flats shank
Coating	uncoated
Tool material	HSS E
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	10 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	8 m/min	P
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
GG(G)	suitable only under restricted conditions	25 m/min	K
CuZn	suitable only under restricted conditions	80 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		

