

**Garant**
**Jobber drill extra long HSS N, uncoated, Ø DC h8: 13R1mm**

**Order data**

Order number	116760 13R1
GTIN	4045197035301
Item class	11C

**Description**
**Version:**

High concentricity. Core thickness and core taper are standard.

Special surface treatment.

Precision ground point. When drilling deep holes, evacuate chips from the hole frequently, and ensure adequate cooling.

Economy version with standard flutes.

With point geometry shape A.

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

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

**Note:**

For suitable reducing adapters for tools with MT shanks see **No. 343000-343530**.

**Technical description**

Nominal Ø D <sub>c</sub>	13 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.16 mm/rev.
Flute length L <sub>c</sub>	205 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h8
Overall length L	310 mm
Morse taper MT size	1
Standard	DIN 1870 R1
recommended maximum drilling depth L <sub>2</sub>	185.5 mm

Point angle	118 degrees
Shank	Morse taper
Coating	uncoated
Tool material	HSS
Type	N
Helix angle	16-30 degrees
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	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
GG(G)	suitable	25 m/min	K
Oil	suitable		
wet maximum	suitable		