



HSS jobber drill N, uncoated, Ø DC h8: 18 mm



Order data

Order number	116320 18
GTIN	4045197029584
Item class	12C

Description

Version:

Special surface treatment, resulting in reduced tendency to edge build-up **and improved chip evacuation.**

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.**

Through-coolant: no

Standard: DIN 345

Tolerance nominal Ø: h8

Point angle: 118°

Shank: Morse taper

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 103 mm

Flute length L_c : 130 mm

Overall length L: 228 mm

Morse taper MT size: 2

Feed f in steel < 750 N/mm²: 0.2 mm/rev.

Technical description

Number of cutting edges Z	2
Nominal Ø D_c	18 mm
Feed f in steel < 750 N/mm ²	0.2 mm/rev.
Flute length L_c	130 mm

Data sheet

Tolerance nominal \varnothing	h8
Overall length L	228 mm
Morse taper MT size	2
Standard	DIN 345
recommended maximum drilling depth L_2	103 mm
Point angle	118°
Shank	Morse taper
Coating	uncoated
Tool material	HSS
Type	N
Helix angle	20-30°
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	40 m/min	P
Steel < 750 N/mm ²	suitable	30 m/min	P
Steel < 900 N/mm ²	suitable only under restricted conditions	25 m/min	P
GG(G)	suitable only under restricted conditions	25 m/min	K
Oil	suitable		
wet maximum	suitable		