



Jobber drill HSS N, TiN, Ø DC h8: 4,5mm



Order data

Order number	114360 4,5
GTIN	4045197016515
Item class	12B

Description

Version:

Standard core without core taper.
Precision ground point.

Profile ground:

High concentricity and pitch accuracy, drills for series production use.
With point geometry shape C from size 2.4 mm

Recommendation:

Maximum drilling depth:

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

Through-coolant: no

Standard: DIN 338

Tolerance nominal Ø: h8

Point angle: 118 °

Shank: Plain shank

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 40.3 mm

Flute length L_c : 47 mm

Overall length L: 80 mm

Shank Ø D_s : 4.5 mm

Feed f in steel < 500 N/mm²: 0.09 mm/rev.

Technical description

Flute length L_c	47 mm
Number of cutting edges Z	2
Nominal Ø D_c	4.5 mm

Feed f in steel < 500 N/mm ²	0.09 mm/rev.
Tolerance nominal Ø	h8
Shank Ø D _s	4.5 mm
Overall length L	80 mm
Standard	DIN 338
recommended maximum drilling depth L ₂	40.3 mm
Point angle	118 °
Shank	Plain shank
Coating	TiN
Tool material	HSS
Type	N
Helix angle	35-40 °
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 ²	suitable	50 m/min	P
Steel < 750 N/mm ²	suitable	37 m/min	P
Steel < 900 N/mm ²	suitable	31 m/min	P
Steel < 1100 N/mm ²	suitable only under restricted conditions	12 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	10 m/min	P

INOX < 900 N/mm ²	suitable only under restricted conditions	15 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	10 m/min	M
Ti > 850 N/mm ²	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		