


Jobber drill HSS N, TiN, Ø DC h8: 8,4mm

Order data

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| Order number | 114360 8,4 |
| GTIN | 4045197016904 |
| 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:

$L_2 = L_c - 1.5 \times D_c$

Technical description

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|--|--------------|
| Flute length L_c | 75 mm |
| Number of cutting edges Z | 2 |
| Feed f in steel < 500 N/mm ² | 0.16 mm/rev. |
| Nominal $\varnothing D_c$ | 8.4 mm |
| Tolerance nominal \varnothing | h8 |
| Shank $\varnothing D_s$ | 8.4 mm |
| Overall length L | 117 mm |
| Standard | DIN 338 |
| recommended maximum drilling depth L_2 | 62.4 mm |
| Point angle | 118 degrees |

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|-----------------|---------------|
| Shank | Plain shank |
| Coating | TiN |
| Tool material | HSS |
| Type | N |
| Helix angle | 35-40 degrees |
| 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 |

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|-------------|----------|
| Oil | suitable |
| wet maximum | suitable |