


**Jobber drill HSS N, TiN, Ø DC h8: 8,5mm**

**Order data**

Order number	114360 8,5
GTIN	4045197016911
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**

Nominal Ø $D_c$	8.5 mm
Feed $f$ in steel < 500 N/mm <sup>2</sup>	0.16 mm/rev.
Number of cutting edges $Z$	2
Flute length $L_c$	75 mm
Tolerance nominal Ø	h8
Shank Ø $D_s$	8.5 mm
Overall length $L$	117 mm
Standard	DIN 338
recommended maximum drilling depth $L_2$	62.3 mm
Point angle	118 degrees

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 <sub>c</sub>	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 <sup>2</sup>	suitable	50 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	37 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	31 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	12 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	10 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	15 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	10 m/min	M
Ti > 850 N/mm <sup>2</sup>	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