


**Jobber drill HSS-E N, uncoated, Ø DC h8: 8,4mm**

**Order data**

Order number	114405 8,4
GTIN	4045197535290
Item class	12B

**Description**
**Version:**

**Profile ground:** this ensures high concentricity and pitch accuracy. Precision ground point. Drill for production use.

With point geometry shape C from size 2 mm

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

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

**Technical description**

Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.
Number of cutting edges Z	2
Nominal Ø D <sub>c</sub>	8.4 mm
Flute length L <sub>c</sub>	75 mm
Tolerance nominal Ø	h8
Shank Ø D <sub>s</sub>	8.4 mm
Overall length L	117 mm
Standard	DIN 338
recommended maximum drilling depth L <sub>2</sub>	62.4 mm
Point angle	135 degrees
Shank	Plain shank
Coating	uncoated

Tool material	HSS E
Type	N
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	35 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	28 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	22 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	8 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	6 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	8 m/min	M
Oil	suitable		
wet maximum	suitable		