


Jobber drill HSS-E N, uncoated, Ø DC h8: 8,6mm

Order data

Order number	114405 8,6
GTIN	4045197535313
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

Flute length L_c	81 mm
Feed f in steel $< 750 \text{ N/mm}^2$	0.1 mm/rev.
Nominal $\varnothing D_c$	8.6 mm
Number of cutting edges Z	2
Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	8.6 mm
Overall length L	125 mm
Standard	DIN 338
recommended maximum drilling depth L_2	68.1 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 _c	ISO code
Steel < 500 N/mm ²	suitable	35 m/min	P
Steel < 750 N/mm ²	suitable	28 m/min	P
Steel < 900 N/mm ²	suitable	22 m/min	P
Steel < 1100 N/mm ²	suitable	8 m/min	P
Steel < 1400 N/mm ²	suitable	6 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	8 m/min	M
Oil	suitable		
wet maximum	suitable		