


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

**Order data**

Order number	114405 6,8
GTIN	4045197535139
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 $L_c$	69 mm
Feed $f$ in steel $< 750 \text{ N/mm}^2$	0.07 mm/rev.
Nominal $\varnothing D_c$	6.8 mm
Number of cutting edges $Z$	2
Tolerance nominal $\varnothing$	h8
Shank $\varnothing D_s$	6.8 mm
Overall length $L$	109 mm
Standard	DIN 338
recommended maximum drilling depth $L_2$	58.8 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		