


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

**Order data**

|              |               |
|--------------|---------------|
| Order number | 114405 8,8    |
| GTIN         | 4045197535337 |
| 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       |
| Number of cutting edges $Z$              | 2           |
| Feed $f$ in steel $< 750 \text{ N/mm}^2$ | 0.1 mm/rev. |
| Nominal $\varnothing D_c$                | 8.8 mm      |
| Tolerance nominal $\varnothing$          | h8          |
| Shank $\varnothing D_s$                  | 8.8 mm      |
| Overall length $L$                       | 125 mm      |
| Standard                                 | DIN 338     |
| recommended maximum drilling depth $L_2$ | 67.8 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                                  |                |          |