


**Jobber drill HSS-E N, uncoated, Ø DC h8: 9,1mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 114405 9,1    |
| GTIN         | 4045197535368 |
| 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. |
| Nominal Ø D <sub>c</sub>                          | 9.1 mm      |
| Flute length L <sub>c</sub>                       | 81 mm       |
| Number of cutting edges Z                         | 2           |
| Tolerance nominal Ø                               | h8          |
| Shank Ø D <sub>s</sub>                            | 9.1 mm      |
| Overall length L                                  | 125 mm      |
| Standard  | DIN 338     |
| recommended maximum drilling depth L <sub>2</sub> | 67.4 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                               | $V_c$    | 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                                  |          |          |