



## HSS jobber drill roll forged N, uncoated, Ø DC h8: 9,4mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 114000 9,4    |
| GTIN         | 4045197009340 |
| Item class   | 12B           |

### Description

#### Version:

**Roll forged**, standard helix angle, core thickness and core taper.

Dimensions to DIN 338.

No interruption in the material structure, so the drill is more resilient and suitable for arduous drilling tasks (e. g. with hand held drills). Economy version.

#### 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>                          | 9.4 mm      |
| Flute length L <sub>c</sub>                       | 81 mm       |
| Tolerance nominal Ø                               | h8          |
| Shank Ø D <sub>s</sub>                            | 9.4 mm      |
| Overall length L                                  | 125 mm      |
| recommended maximum drilling depth L <sub>2</sub> | 66.9 mm     |
| Point angle                                       | 118 degrees |
| Shank   | Plain shank |
| Coating   | uncoated    |

|                 |              |
|-----------------|--------------|
| Tool material   | HSS          |
| Type            | N            |
| Through-coolant | no           |
| Colour ring     | without      |
| Type of product | Jobber drill |

### User data

|                               | Suitability                               | V <sub>c</sub> | ISO code |
|-------------------------------|---|----------------|----------|
| Aluminium (short chipping)    | suitable only under restricted conditions | 45 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup> | suitable                                  | 40 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup> | suitable                                  | 30 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup> | suitable                                  | 25 m/min       | P        |
| GG(G)                         | suitable only under restricted conditions | 25 m/min       | K        |
| Oil                           | suitable                                  |                |          |
| wet maximum                   | suitable                                  |                |          |
| dry                           | suitable only under restricted conditions |                |          |