



## HSS jobber drill roll forged N, uncoated, Ø DC h8: 8,5mm



### Order data

Order number	114000 8,5
GTIN	4045197009258
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

Nominal Ø D <sub>c</sub>	8.5 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.
Number of cutting edges Z	2
Flute length L <sub>c</sub>	75 mm
Tolerance nominal Ø	h8
Shank Ø D <sub>s</sub>	8.5 mm
Overall length L	117 mm
recommended maximum drilling depth L <sub>2</sub>	62.3 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	$V_c$	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		