



## HSS jobber drill Precision roll forged N, uncoated, Ø DC h8: 8,6mm



### Order data

Order number	114020 8,6
GTIN	4045197010292
Item class	12B

### Description

#### Version:

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

Dimensions to DIN 338.

Robust jobber drill with strengthened core and small chisel point for easy spot drilling and accurate centring of the designated hole. **Precision roll forged flutes.**

#### Recommendation:

#### Maximum drilling depth:

$$L_2 = L_c - 1.5 \times D_c.$$

#### Note:

Size 14-20: Shank Ø 13 mm with 3 drive flats.

### Technical description

Flute length $L_c$	81 mm
Feed $f$ in steel $< 750 \text{ N/mm}^2$	0.1 mm/rev.
Number of cutting edges $Z$	2
Nominal Ø $D_c$	8.6 mm
Tolerance nominal Ø	h8
Shank Ø $D_s$	8.6 mm
Overall length $L$	125 mm
recommended maximum drilling depth $L_2$	68.1 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		