



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



### Order data

|              |               |
|--------------|---------------|
| Order number | 114020 4,9    |
| GTIN         | 4045197009920 |
| 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

|   |              |
|---|--------------|
| Nominal Ø D <sub>c</sub>                          | 4.9 mm       |
| Flute length L <sub>c</sub>                       | 52 mm        |
| Number of cutting edges Z                         | 2            |
| Feed f in steel < 750 N/mm <sup>2</sup>           | 0.05 mm/rev. |
| Tolerance nominal Ø                               | h8           |
| Shank Ø D <sub>s</sub>                            | 4.9 mm       |
| Overall length L                                  | 86 mm        |
| recommended maximum drilling depth L <sub>2</sub> | 44.7 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                                  |                |          |