



HSS jobber drill Precision roll forged N, uncoated, Ø DC h8: 18 mm



Order data

Order number	114020 18
GTIN	4045197010599
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.

Through-coolant: no

Tolerance nominal Ø: h8

Point angle: 118 degrees

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 103 mm

Flute length L_c : 130 mm

Overall length L: 191 mm

Shank Ø D_s : 18 mm

Feed f in steel < 750 N/mm²: 0.2 mm/rev.

Technical description

Feed f in steel < 750 N/mm ²	0.2 mm/rev.
Flute length L_c	130 mm
Number of cutting edges Z	2
Nominal Ø D_c	18 mm

Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	18 mm
Overall length L	191 mm
recommended maximum drilling depth L_2	103 mm
Point angle	118 degrees
Coating	uncoated
Tool material	HSS
Type	N
Shank	Plain shank
Through-coolant	no
Colour ring	without
Type of product	Jobber drill