



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



### Order data

Order number	114000 8,6
GTIN	4045197009265
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:

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

Through-coolant: no

Tolerance nominal Ø: h8

Point angle: 118 degrees

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 68.1 mm

Flute length  $L_c$ : 81 mm

Overall length L: 125 mm

Shank Ø  $D_s$ : 8.6 mm

Feed f in steel < 750 N/mm<sup>2</sup>: 0.1 mm/rev.

### Technical description

Flute length $L_c$	81 mm
Feed f in steel < 750 N/mm <sup>2</sup>	0.1 mm/rev.
Nominal Ø $D_c$	8.6 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h8

Shank $\varnothing D_s$	8.6 mm
Overall length L	125 mm
recommended maximum drilling depth $L_2$	68.1 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