



HSS jobber drill Precision roll forged N, uncoated, Ø DC h8: 9,8 mm



Order data

Order number	114020 9,8
GTIN	4045197010414
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 : 72.3 mm

Flute length L_c : 87 mm

Overall length L: 133 mm

Shank Ø D_s : 9.8 mm

Feed f in steel < 750 N/mm²: 0.1 mm/rev.

Technical description

Number of cutting edges Z	2
Feed f in steel < 750 N/mm ²	0.1 mm/rev.
Nominal Ø D_c	9.8 mm
Flute length L_c	87 mm

Tolerance nominal \varnothing	h8
Shank $\varnothing D_s$	9.8 mm
Overall length L	133 mm
recommended maximum drilling depth L_2	72.3 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