

**Jobber drill HSS N, TiN, Ø DC h8: 4,6mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 114360 4,6    |
| GTIN         | 4045197016522 |
| Item class   | 12B           |

**Description****Version:**

Standard core without core taper.

Precision ground point.

**Profile ground:**

High concentricity and pitch accuracy, drills for series production use.

With point geometry shape C from size 2.4 mm

**Recommendation:****Maximum drilling depth:**

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

**Technical description**

|                                                   |              |
|---------------------------------------------------|--------------|
| Feed f in steel < 500 N/mm <sup>2</sup>           | 0.09 mm/rev. |
| Flute length L <sub>c</sub>                       | 47 mm        |
| Number of cutting edges Z                         | 2            |
| Nominal Ø D <sub>c</sub>                          | 4.6 mm       |
| Tolerance nominal Ø                               | h8           |
| Shank Ø D <sub>s</sub>                            | 4.6 mm       |
| Overall length L                                  | 80 mm        |
| Standard                                          | DIN 338      |
| recommended maximum drilling depth L <sub>2</sub> | 40.1 mm      |
| Point angle                                       | 118 degrees  |

|                 |               |
|-----------------|---------------|
| Shank           | Plain shank   |
| Coating         | TiN           |
| Tool material   | HSS           |
| Type            | N             |
| Helix angle     | 35-40 degrees |
| 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 | 56 m/min       | N        |
| Alu > 10% Si                   | suitable only under restricted conditions | 50 m/min       | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 50 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 37 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 31 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 12 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 10 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 15 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 10 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable only under restricted conditions | 6 m/min        | S        |
| GG(G)                          | suitable                                  | 31 m/min       | K        |
| CuZn                           | suitable only under restricted conditions | 80 m/min       | N        |

|             |          |
|-------------|----------|
| Oil         | suitable |
| wet maximum | suitable |