

**Jobber drill HSS N, TiN, Ø DC h8: 9,3mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 114360 9,3    |
| GTIN         | 4045197016997 |
| 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**

|                                          |              |
|------------------------------------------|--------------|
| Flute length $L_c$                       | 81 mm        |
| Nominal $\varnothing D_c$                | 9.3 mm       |
| Feed $f$ in steel $< 500 \text{ N/mm}^2$ | 0.16 mm/rev. |
| Number of cutting edges $Z$              | 2            |
| Tolerance nominal $\varnothing$          | h8           |
| Shank $\varnothing D_s$                  | 9.3 mm       |
| Overall length $L$                       | 125 mm       |
| Standard                                 | DIN 338      |
| recommended maximum drilling depth $L_2$ | 67.1 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 |