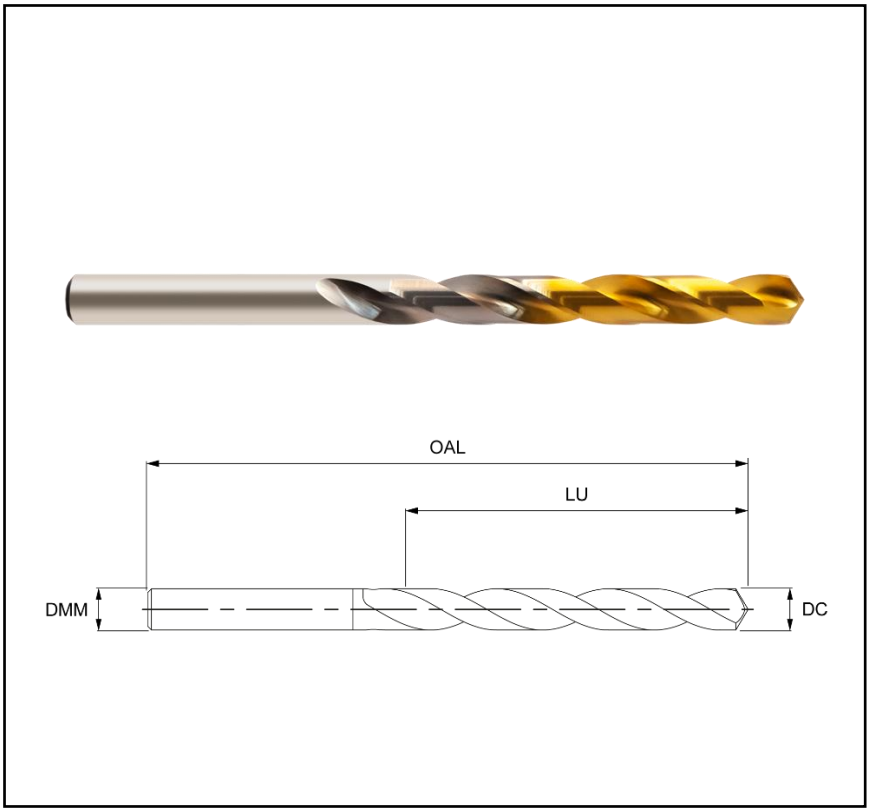
Features

- TiN-coated working area provides increased wear resistance, significantly extending tool life and improving overall drilling performance.
- Self-centring split point (from 1/16" and larger) removes the need for centre punching and minimises drill wandering for more accurate hole starts.
- Bright-finish body enhances chip evacuation for smoother, cleaner drilling and reduced heat build-up.

RS PRO HSS TiN Coated Jobber Drill, Imperial



RS Professionally Approved Products bring to you professional quality parts across all product categories. Our product range has been tested by engineers and provides a comparable quality to the leading brands without paying a premium price.

Product Description

The RS PRO HSS TiN Coated Jobber Drill is engineered for exceptional durability and precision. Its Titanium Nitride (TiN) coated working area delivers superior wear resistance, ensuring extended tool life and consistent high-performance drilling. Sizes **1/16" and above** feature a self-centring split point. A bright-finish body further enhances chip clearance, promoting smooth operation and reduced heat build-up. Designed for reliability and efficiency, the RS PRO HSS TiN Coated Jobber Drill is an ideal choice for drilling across a wide range of materials.

General Specifications

Brand	RS PRO
Material	High Speed Steel (HSS)
Drill Bit Size	19/64”
Product Type	Drill Bit
Overall Length	4.3/8”
Diameter	19/64”
Cut Length	3.1/16”
Number of Pieces	Packs of 10 up to 6mm Pack of 5 from 6.1mm upwards
Drill Bit Type	Jobber Drill
Drill Application	General application Alloy steels Cast irons Stainless steel Titanium & titanium Alloys Aluminium Non-ferrous materials (brass, bronze, copper)

Mechanical Specifications

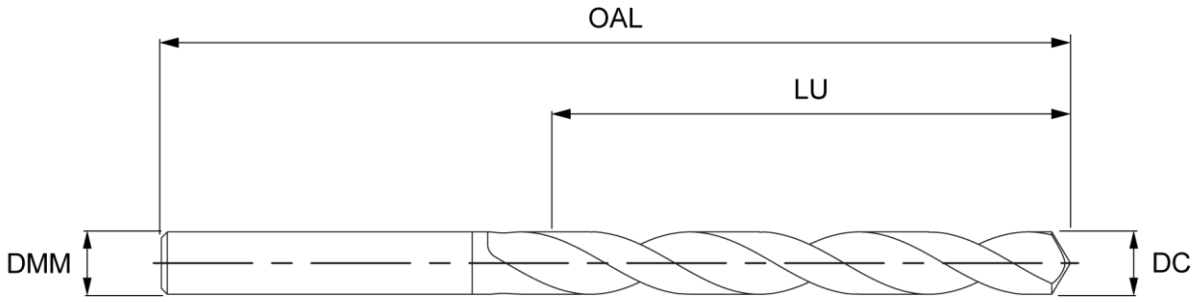
Cutter Diameter	DC– See table below and detailed image below
Cut Length	LU – See table below and detailed image below
Number of Flutes	2
Overall Length	OAL – See table below and detailed image below
Shank Type	Straight / Cylindrical Shank
Shank Diameter	DDM – See table below and detailed image below
Centre Cutting	Yes

Approvals

Declarations	N/A
Hazardous Area Certification	N/A
Standards Met	DIN 338

Stock No.	Brand	Diameter DC / DMM	FL.LTH LU	DMM	O/ALL OAL
879437	RS PRO	19/64"	3.1/16"	19/64"	4.3/8"

Connection Diagrams / Assembly Diagrams / Illustrations / Accessories



Cutting Data

VDI MATERIAL GROUP			HRc	v_c (m/min)	f_n (mm/rev)									
					ø1.0 -1.9	ø2.0 -2.9	ø3.0 -3.9	ø4.0 -4.9	ø5.0 -5.9	ø6.0 -6.9	ø7.0 -7.9	ø8.0 -9.9	ø10.0 -11.9	ø12.0 -13.5
P	1-5	Non-alloy Steel	<25	**40 (35-45)**	0.02	0.06	0.08	0.11	0.11	0.13	0.15	0.18	0.22	0.22
P	6-9	Low alloy Steel	25-35	**23 (20-25)**	0.02	0.06	0.08	0.10	0.10	0.12	0.14	0.15	0.18	0.20
M	12-13	Stainless Steel		**23 (20-25)**	0.02	0.06	0.08	0.10	0.10	0.12	0.14	0.15	0.18	0.20
S	36-37	Titanium & Titanium Alloys		**23 (20-25)**	0.02	0.06	0.08	0.09	0.10	0.12	0.14	0.15	0.18	0.20
N	21-24	Aluminium Si<12%		**90 (85-95)**	0.02	0.06	0.10	0.11	0.12	0.14	0.16	0.18	0.23	0.23

All recommendations are based on ideal machining conditions. Adjustments may need to be made according to your set-up.
The recommendations for speeds, feeds and other parameters presented in this chart are nominal recommendations and should be considered only as good starting points.

v_c - cutting speed (m/min)
n - RPM (rev/min)
f_n - feed rate (mm/rev)
ø - drill diameter (mm)