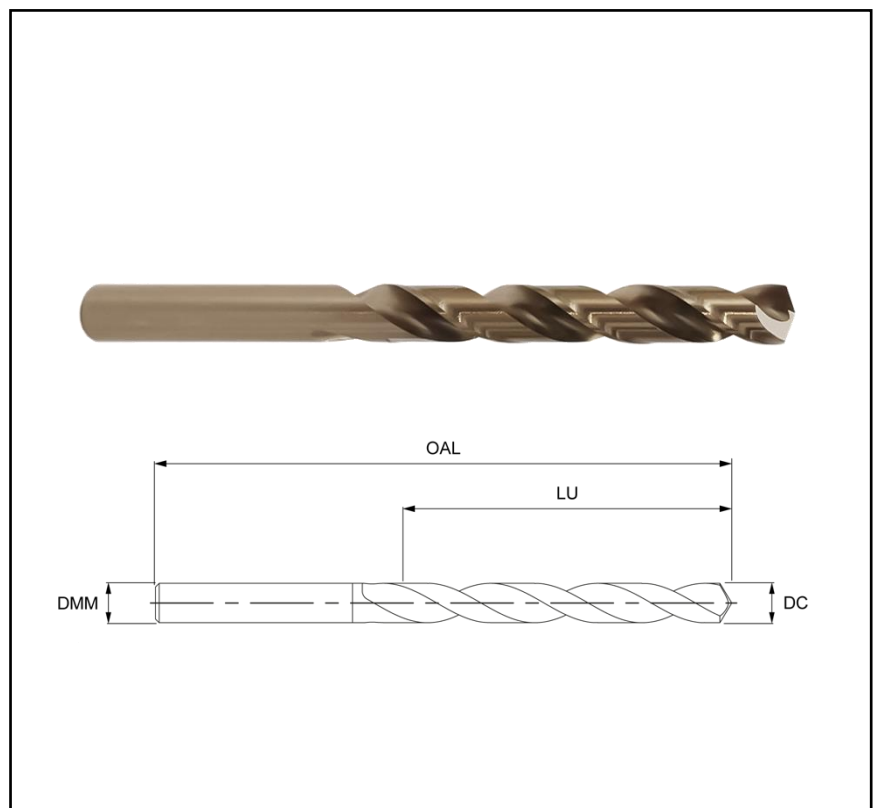


## Features

- HSS-Co construction, delivers higher hardness, heat resistance and wear-resistance, meaning longer tool life and copes better when drilling tougher metals.
- 118° point angle for reliable self-centring and smooth, accurate hole starts.
- Jobber length offers good reach for general through-holes and versatility across a wide range of hole depths, while retaining rigidity.

## RS PRO HSSCo Jobber Drill



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 HSSCo Jobber Drill is engineered for high-performance drilling in demanding materials. Made from Cobalt enhanced high speed steel (HSSCo), it delivers exceptional heat resistance and maintains cutting edge sharpness even under heavy loads. Its 118° point angle ensures smooth, accurate starts with reduced wandering, while the jobber length offers versatile reach for a wide range of drilling applications. Ideal for stainless steels, tough alloys and general drilling tasks where durability and reliability are essential.*

## General Specifications

|                          |                                                                                                          |
|--------------------------|----------------------------------------------------------------------------------------------------------|
| <b>Brand</b>             | RS PRO                                                                                                   |
| <b>Material</b>          | High Speed Steel - Cobalt (HSSCo)                                                                        |
| <b>Drill Bit Size</b>    | 1mm – 13mm                                                                                               |
| <b>Product Type</b>      | Drill Bit                                                                                                |
| <b>Overall Length</b>    | 34mm – 151mm                                                                                             |
| <b>Diameter</b>          | 1.0mm – 13.0mm                                                                                           |
| <b>Cut Length</b>        | 12mm – 101mm                                                                                             |
| <b>Number of Pieces</b>  | Packs of 10 up to 6mm<br>Pack of 5 from 6.1mm upwards                                                    |
| <b>Drill Bit Type</b>    | Jobber Drill                                                                                             |
| <b>Drill Application</b> | Steels<br>Stainless steel<br>Cast irons<br>Titanium & titanium Alloys<br>Aluminium<br>Plastics, Acrylics |

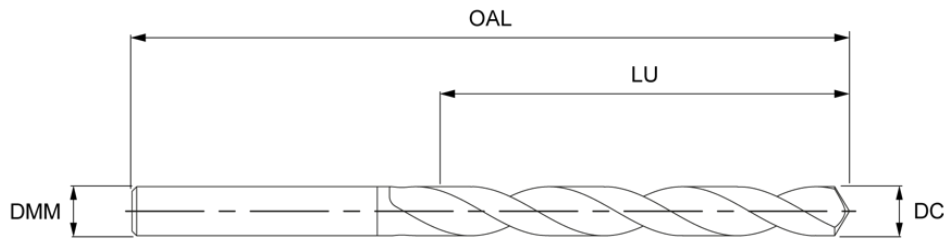
## Mechanical Specifications

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

## Approvals

|                                     |         |
|-------------------------------------|---------|
| <b>Declarations</b>                 | N/A     |
| <b>Hazardous Area Certification</b> | N/A     |
| <b>Standards Met</b>                | DIN 338 |

| Stock No.          | Brand  | Diameter<br>DC / DMM | FL.LTH<br>LU | O/ALL<br>OAL |
|--------------------|--------|----------------------|--------------|--------------|
| XXX-XXXX<br>905726 | RS PRO | 1.0                  | 12           | 34           |
| XXX-XXXX<br>905727 | RS PRO | 1.5                  | 18           | 40           |
| XXX-XXXX<br>905728 | RS PRO | 2.0                  | 24           | 49           |
| XXX-XXXX<br>905634 | RS PRO | 2.4                  | 30           | 57           |
| XXX-XXXX<br>905614 | RS PRO | 2.5                  | 30           | 57           |
| XXX-XXXX<br>905615 | RS PRO | 3.0                  | 33           | 61           |
| XXX-XXXX<br>905729 | RS PRO | 3.3                  | 36           | 65           |
| XXX-XXXX<br>905617 | RS PRO | 3.5                  | 39           | 70           |
| XXX-XXXX<br>905619 | RS PRO | 4.0                  | 43           | 75           |
| XXX-XXXX<br>905616 | RS PRO | 4.2                  | 43           | 75           |
| XXX-XXXX<br>905622 | RS PRO | 4.5                  | 47           | 80           |
| XXX-XXXX<br>905620 | RS PRO | 5.0                  | 52           | 86           |
| XXX-XXXX<br>905621 | RS PRO | 5.5                  | 57           | 93           |
| XXX-XXXX<br>905625 | RS PRO | 6.0                  | 57           | 93           |
| XXX-XXXX<br>905626 | RS PRO | 6.5                  | 63           | 101          |
| XXX-XXXX<br>905623 | RS PRO | 6.8                  | 69           | 109          |
| XXX-XXXX<br>905627 | RS PRO | 7.0                  | 69           | 109          |
| XXX-XXXX<br>905628 | RS PRO | 7.5                  | 69           | 109          |
| XXX-XXXX<br>905629 | RS PRO | 8.0                  | 75           | 117          |
| XXX-XXXX<br>905633 | RS PRO | 8.5                  | 75           | 117          |
| XXX-XXXX<br>905631 | RS PRO | 9.0                  | 81           | 125          |
| XXX-XXXX<br>905632 | RS PRO | 10.0                 | 87           | 133          |
| XXX-XXXX<br>905724 | RS PRO | 12.0                 | 101          | 151          |
| XXX-XXXX<br>905725 | RS PRO | 13.0                 | 101          | 151          |



## Cutting Data

| VDI MATERIAL GROUP |                                  | HRC   | Vc (m/min)    | fn (mm/rev)    |                |                |                |                |                |                |                |                |                |
|--------------------|----------------------------------|-------|---------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|----------------|
|                    |                                  |       |               | ø1.0<br>-1.9   | ø2.0<br>-2.9   | ø3.0<br>-3.9   | ø4.0<br>-4.9   | ø5.0<br>-5.9   | ø6.0<br>-6.9   | ø7.0<br>-7.9   | ø8.0<br>-9.9   | ø10.0<br>-11.9 | ø12.0<br>-13.5 |
| <b>P</b>           | 1-5 Non-alloy Steel              | <25   | 25<br>(22-27) | 0.01           | 0.025          | 0.05           | 0.055          | 0.063          | 0.08           | 0.10           | 0.13           | 0.145          | 0.16           |
|                    | 6-9 Low alloy Steel              | 25-35 | 22<br>(20-25) | 0.009          | 0.02           | 0.045          | 0.05           | 0.06           | 0.075          | 0.095          | 0.125          | 0.14           | 0.15           |
| <b>M</b>           | 12-13 Stainless Steel            |       | 18<br>(15-20) | 0.01           | 0.025          | 0.05           | 0.055          | 0.063          | 0.08           | 0.10           | 0.13           | 0.145          | 0.16           |
| <b>K</b>           | 15-16 Grey Cast Iron             |       | 18<br>(15-20) | 0.01           | 0.025          | 0.05           | 0.055          | 0.063          | 0.08           | 0.10           | 0.13           | 0.145          | 0.16           |
| <b>S</b>           | 36-37 Titanium & Titanium Alloys |       | 10<br>(8-12)  | 0.08           | 0.02           | 0.025          | 0.031          | 0.038          | 0.045          | 0.06           | 0.075          | 0.09           | 0.10           |
| <b>N</b>           | 21-24 Aluminium Si<12%           |       | 48<br>(45-50) | 0.02           | 0.038          | 0.063          | 0.07           | 0.076          | 0.12           | 0.16           | 0.18           | 0.20           | 0.225          |
|                    | 29.1 Plastics, Acrylics          |       | 23<br>(22-25) | 0.01           | 0.025          | 0.05           | 0.055          | 0.063          | 0.08           | 0.10           | 0.13           | 0.145          | 0.16           |
| VDI MATERIAL GROUP |                                  | HRC   | Vc (m/min)    | fn (mm/rev)    |                |                |                |                |                |                |                |                |                |
|                    |                                  |       |               | ø14.0<br>-15.5 | ø16.0<br>-17.5 | ø18.0<br>-19.5 | ø20.0<br>-21.5 | ø22.0<br>-23.5 | ø24.0<br>-25.5 | ø26.0<br>-27.5 | ø28.0<br>-29.5 | ø30.0<br>-31.0 |                |
| <b>P</b>           | 1-5 Non-alloy Steel              | <25   | 25<br>(22-27) | 0.18           | 0.20           | 0.23           | 0.24           | 0.25           | 0.26           | 0.27           | 0.275          | 0.28           |                |
|                    | 6-9 Low alloy Steel              | 25-35 | 22<br>(20-25) | 0.17           | 0.21           | 0.22           | 0.23           | 0.24           | 0.25           | 0.26           | 0.265          | 0.27           |                |
| <b>M</b>           | 12-13 Stainless Steel            |       | 18<br>(15-20) | 0.18           | 0.20           | 0.23           | 0.24           | 0.25           | 0.26           | 0.27           | 0.275          | 0.28           |                |
| <b>K</b>           | 15-16 Grey Cast Iron             |       | 18<br>(15-20) | 0.18           | 0.20           | 0.23           | 0.24           | 0.25           | 0.26           | 0.27           | 0.275          | 0.28           |                |
| <b>S</b>           | 36-37 Titanium & Titanium Alloys |       | 10<br>(8-12)  | 0.11           | 0.12           | 0.13           | 0.14           | 0.15           | 0.16           | 0.17           | 0.175          | 0.18           |                |
| <b>N</b>           | 21-24 Aluminium Si<12%           |       | 48<br>(45-50) | 0.25           | 0.275          | 0.30           | 0.325          | 0.35           | 0.36           | 0.37           | 0.375          | 0.38           |                |
|                    | 29.1 Plastics, Acrylics          |       | 23<br>(22-25) | 0.18           | 0.20           | 0.23           | 0.24           | 0.25           | 0.26           | 0.27           | 0.275          | 0.28           |                |

Vc - cutting speed (m/min)

n - RPM (rev/min)

fn - feed rate (mm/rev)

ø - drill diameter (mm)

$$\text{To calculate RPM from cutting speed: } n = \frac{V_c \cdot 1000}{\pi \cdot \phi}$$

$$\text{To calculate cutting speed from RPM: } V_c = \frac{n \cdot \pi \cdot \phi}{1000}$$

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 these charts are nominal recommendations and should be considered only as good starting points.