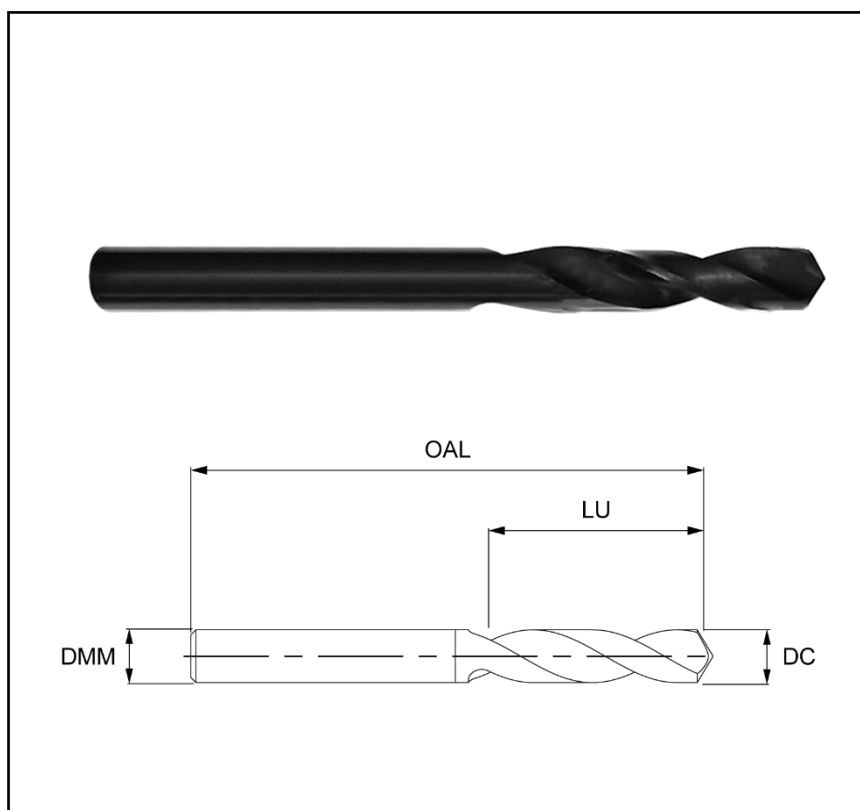


## Features

- Stub-length design gives greater rigidity and reduces deflection, ideal for accurate, straight holes.
- The 118° point angle supports good self-centering and lowers the axial thrust needed, helping start holes cleanly and reducing walking.
- The HSS build ensures strength across steels, cast iron and non-ferrous materials, making it a versatile general-purpose drill.

## RS PRO HSS Stub 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

*RS Pro HSS Stub Drill is a high-speed steel stub-length drill engineered for precision metal working. Its compact stub geometry delivers increased rigidity and stability, resulting in straight, accurate holes with minimal deflection, ideal for shallow holes or confined machining step-ups. The 118 degree point angle supports reliable self-centering, reducing the axial thrust required to start a hole and helping prevent walking. HSS Stub Drill is suitable for wide range of materials such as steels, cast iron and non-ferrous metals and the bright coating enhances resistance for longer tool life.*

## General Specifications

|                          |                                                                           |
|--------------------------|---------------------------------------------------------------------------|
| <b>Brand</b>             | RS PRO                                                                    |
| <b>Material</b>          | High Speed Steel (HSS)                                                    |
| <b>Drill Bit Size</b>    | 1mm – 12mm                                                                |
| <b>Product Type</b>      | Drill Bit                                                                 |
| <b>Overall Length</b>    | 26mm – 102mm                                                              |
| <b>Diameter</b>          | 1mm – 12mm                                                                |
| <b>Cut Length</b>        | 6mm – 51mm                                                                |
| <b>Number of Pieces</b>  | 1                                                                         |
| <b>Drill Bit Type</b>    | Stub Drill                                                                |
| <b>Drill Application</b> | Steel<br>Stainless steel<br>Cast iron<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                                            |

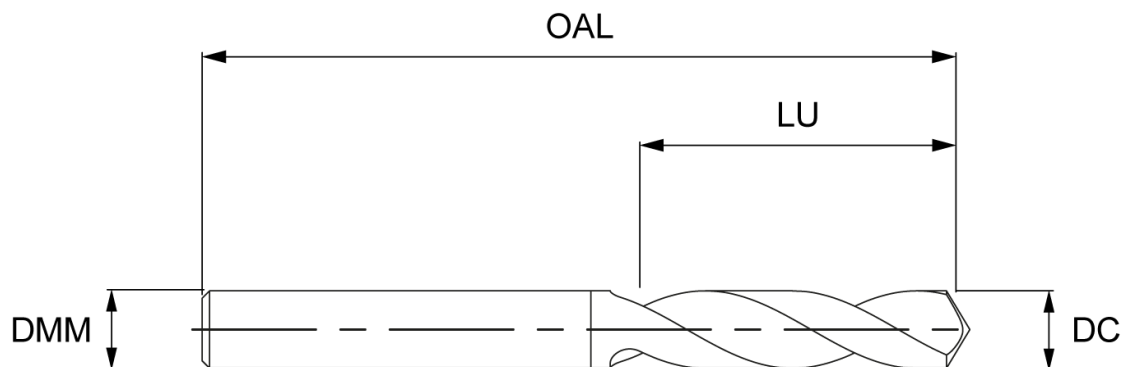
## Approvals

|                                     |          |
|-------------------------------------|----------|
| <b>Declarations</b>                 | N/A      |
| <b>Hazardous Area Certification</b> | N/A      |
| <b>Standards Met</b>                | DIN 1897 |

| Stock No.          | Brand  | Diameter<br>DC / DMM | FL.LTH<br>LU | O/ALL<br>OAL |
|--------------------|--------|----------------------|--------------|--------------|
| XXX-XXXX<br>905688 | RS PRO | 1.0                  | 6            | 26           |
| XXX-XXXX<br>905687 | RS PRO | 2.0                  | 12           | 38           |
| XXX-XXXX<br>905689 | RS PRO | 3.0                  | 16           | 46           |
| XXX-XXXX<br>905690 | RS PRO | 3.5                  | 20           | 52           |
| XXX-XXXX<br>905692 | RS PRO | 4.0                  | 22           | 55           |
| XXX-XXXX<br>905691 | RS PRO | 4.1                  | 22           | 55           |
| XXX-XXXX<br>905693 | RS PRO | 4.2                  | 22           | 55           |
| XXX-XXXX<br>905695 | RS PRO | 4.9                  | 26           | 62           |
| XXX-XXXX<br>905698 | RS PRO | 5.0                  | 26           | 62           |
| XXX-XXXX<br>905697 | RS PRO | 5.1                  | 26           | 62           |
| XXX-XXXX<br>905701 | RS PRO | 6.0                  | 28           | 66           |
| XXX-XXXX<br>905700 | RS PRO | 6.5                  | 31           | 70           |
| XXX-XXXX<br>905705 | RS PRO | 6.8                  | 34           | 74           |
| XXX-XXXX<br>905702 | RS PRO | 7.0                  | 34           | 74           |
| XXX-XXXX<br>905704 | RS PRO | 7.5                  | 34           | 74           |
| XXX-XXXX<br>905707 | RS PRO | 8.0                  | 37           | 79           |
| XXX-XXXX<br>905706 | RS PRO | 9.0                  | 40           | 84           |
| XXX-XXXX<br>905708 | RS PRO | 10.0                 | 43           | 89           |
| XXX-XXXX<br>905709 | RS PRO | 11.0                 | 47           | 95           |
| XXX-XXXX<br>905710 | RS PRO | 12.0                 | 51           | 102          |

## Similar Products

| Stock No.          | Brand  | Diameter<br>DC / DMM | FL.LTH<br>LU | O/ALL<br>OAL |
|--------------------|--------|----------------------|--------------|--------------|
| XXX-XXXX<br>905574 | RS PRO | 1.0                  | 12           | 34           |
| XXX-XXXX<br>905563 | RS PRO | 1.2                  | 16           | 38           |
| XXX-XXXX<br>905564 | RS PRO | 1.3                  | 16           | 38           |
| XXX-XXXX<br>905565 | RS PRO | 1.4                  | 18           | 40           |
| XXX-XXXX<br>905575 | RS PRO | 1.5                  | 18           | 40           |
| XXX-XXXX<br>905576 | RS PRO | 1.6                  | 20           | 43           |
| XXX-XXXX<br>905566 | RS PRO | 1.7                  | 20           | 43           |
| XXX-XXXX<br>905577 | RS PRO | 1.8                  | 22           | 46           |
| XXX-XXXX<br>905568 | RS PRO | 1.9                  | 22           | 46           |
| XXX-XXXX<br>905578 | RS PRO | 2.0                  | 24           | 49           |
| XXX-XXXX<br>905718 | RS PRO | 2.1                  | 24           | 49           |
| XXX-XXXX<br>905723 | RS PRO | 2.2                  | 27           | 53           |
| XXX-XXXX<br>905720 | RS PRO | 2.3                  | 27           | 53           |
| XXX-XXXX<br>905569 | RS PRO | 2.4                  | 30           | 57           |
| XXX-XXXX<br>905721 | RS PRO | 2.5                  | 30           | 57           |
| XXX-XXXX<br>905722 | RS PRO | 2.6                  | 30           | 57           |
| XXX-XXXX<br>905570 | RS PRO | 2.7                  | 33           | 61           |
| XXX-XXXX<br>905571 | RS PRO | 2.8                  | 33           | 61           |
| XXX-XXXX<br>905572 | RS PRO | 2.9                  | 33           | 61           |



## Cutting Data

| VDI MATERIAL GROUP |       | HRc                | V <sub>c</sub> (m/min) | f <sub>n</sub> (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 | ø14.0<br>-15.5 | ø16.0<br>-17.5 | ø18.0<br>-19.5 | ø20.0 |
| <b>P</b>           | 1-5   | Non-alloy Steel    | <25<br>25 (22-27)      | 0.01                    | 0.025        | 0.05         | 0.055        | 0.063        | 0.08         | 0.10         | 0.13         | 0.145          | 0.16           | 0.18           | 0.20           | 0.23           | 0.24  |
|                    | 6-9   | Low alloy Steel    | 25-35<br>22 (20-25)    | 0.009                   | 0.02         | 0.045        | 0.05         | 0.06         | 0.075        | 0.095        | 0.125        | 0.14           | 0.15           | 0.17           | 0.21           | 0.22           | 0.23  |
| <b>M</b>           | 12-13 | Stainless Steel    | 18 (15-20)             | 0.01                    | 0.025        | 0.05         | 0.055        | 0.063        | 0.08         | 0.10         | 0.13         | 0.145          | 0.16           | 0.18           | 0.20           | 0.23           | 0.24  |
| <b>K</b>           | 15-16 | Grey Cast Iron     | 18 (15-20)             | 0.01                    | 0.025        | 0.05         | 0.055        | 0.063        | 0.08         | 0.10         | 0.13         | 0.145          | 0.16           | 0.18           | 0.20           | 0.23           | 0.24  |
| <b>N</b>           | 21-24 | Aluminium Si<12%   | 48 (45-50)             | 0.02                    | 0.038        | 0.063        | 0.07         | 0.076        | 0.12         | 0.16         | 0.18         | 0.20           | 0.225          | 0.25           | 0.275          | 0.30           | 0.325 |
|                    | 29.1  | Plastics, Acrylics | 23 (22-25)             | 0.01                    | 0.025        | 0.05         | 0.055        | 0.063        | 0.08         | 0.10         | 0.13         | 0.145          | 0.16           | 0.18           | 0.20           | 0.23           | 0.24  |

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<sub>c</sub> - cutting speed (m/min)  
n - RPM (rev/min)  
f<sub>n</sub> - feed rate (mm/rev)  
ø - drill diameter (mm)