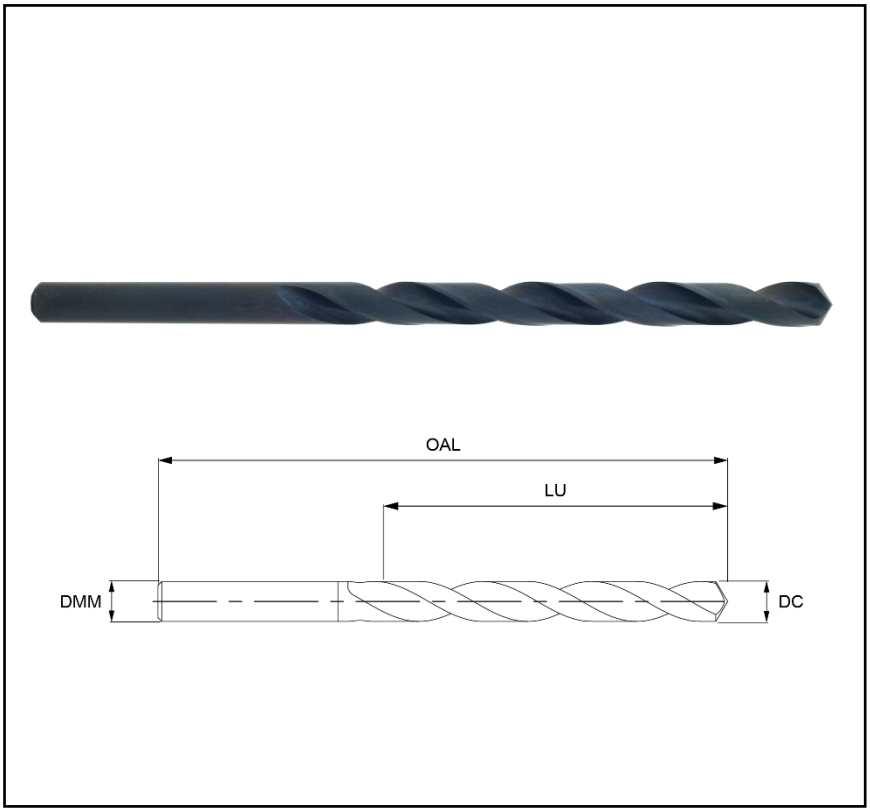
Features

- Made of High-Speed Steel (HSS) with black coating for durability and resistance.
- Long series drill designed for deep holes.
- 118° point angle, 2-flute design, straight cylindrical shank
- Suitable for steel, cast iron, and non-ferrous materials.

RS PRO HSS Long Series 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 Long Series Drill is a high speed steel (HSS) tool with a black coating, designed for precise deep hole drilling, featuring a long flute, 118 degree point angle, 20-30° flute helix angle that ensures accurate self-centering and chip evacuation. Suitable for steel, cast iron, and non-ferrous materials.

General Specifications

Brand	RS PRO
Material	High Speed Steel (HSS)
Drill Bit Size	1.5mm – 13mm
Product Type	Drill Bit
Overall Length	70mm – 205mm
Diameter	1.5mm – 13.0mm
Cut Length	45mm – 134mm
Number of Pieces	Packs of 10 up to 6mm Pack of 5 from 6.1mm upwards
Drill Bit Type	Long Series
Drill Application	Steel Stainless steel Cast iron Aluminium Plastics, Acrylics

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

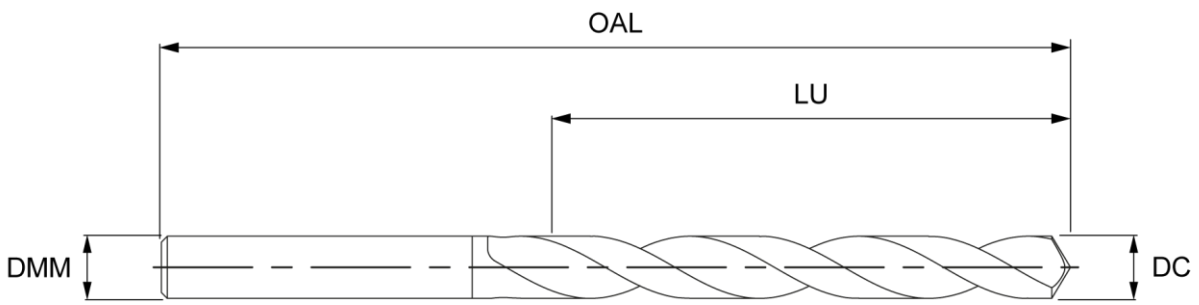
Approvals

Declarations	N/A
Hazardous Area Certification	N/A
Standards Met	DIN 340

Stock No.	Brand	Diameter **DC / DMM**	FL.LTH **LU**	O/ALL **OAL**
XXX-XXXX 905585	RS PRO	1.5	45	70
XXX-XXXX 905586	RS PRO	2.0	56	85
XXX-XXXX 905587	RS PRO	2.5	62	95
XXX-XXXX 905588	RS PRO	3.0	66	100
XXX-XXXX 905733	RS PRO	3.3	69	106
XXX-XXXX 905590	RS PRO	3.5	73	112
XXX-XXXX 905591	RS PRO	4.0	78	119
XXX-XXXX 905734	RS PRO	4.2	78	119
XXX-XXXX 905592	RS PRO	4.5	82	126
XXX-XXXX 905593	RS PRO	5.0	87	132
XXX-XXXX 905594	RS PRO	5.5	91	139
XXX-XXXX 905595	RS PRO	6.0	91	139
XXX-XXXX 905596	RS PRO	6.5	97	148
XXX-XXXX 905735	RS PRO	6.8	102	156
XXX-XXXX 905597	RS PRO	7.0	102	156
XXX-XXXX 905598	RS PRO	7.5	102	156
XXX-XXXX 905599	RS PRO	8.0	109	165
XXX-XXXX 905600	RS PRO	8.5	109	165
XXX-XXXX 905601	RS PRO	9.0	115	175
XXX-XXXX 905603	RS PRO	10.0	121	184
XXX-XXXX 905604	RS PRO	10.5	121	184
XXX-XXXX 905605	RS PRO	11.0	128	195
XXX-XXXX 905606	RS PRO	12.0	134	205
XXX-XXXX 905730	RS PRO	12.5	134	205
XXX-XXXX 905732	RS PRO	13.0	134	205

Similar Products

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



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	ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0
P	1-5	Non-alloy Steel	<25	**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
P	6-9	Low alloy Steel	25-35	**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
M	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
K	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
N	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
N	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

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

To calculate RPM from cutting speed: $n = \frac{v_c * 1000}{\pi * ø}$

To calculate cutting speed from RPM: $v_c = \frac{n * \pi * ø}{1000}$

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.