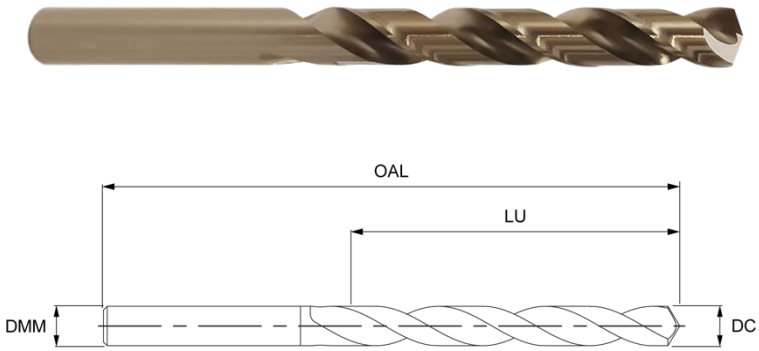
Features

- 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. It 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

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

Mechanical Specifications

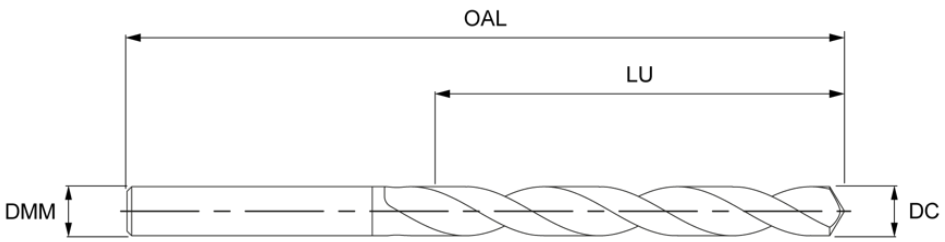
Cutter Diameter	DC– See table below and detailed image below
Cut Length	LU – See table below and detailed image below
Number of Flutes	2
Overall Length	OAL – See table below and detailed image below
Shank Type	Straight / Cylindrical Shank
Shank Diameter	DDM – See table below and detailed image below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

Approvals

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

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

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	25 (22-27)	0.01	0.025	0.05	0.055	0.063	0.08	0.10	0.13	0.145	0.16
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
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
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
S	36-37	Titanium & Titanium Alloys		10 (8-12)	0.08	0.02	0.025	0.031	0.038	0.045	0.06	0.075	0.09	0.10
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
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

VDI MATERIAL GROUP			HRc	v_c (m/min)	f_n (mm/rev)								
					ø14.0 -15.5	ø16.0 -17.5	ø18.0 -19.5	ø20.0 -21.5	ø22.0 -23.5	ø24.0 -25.5	ø26.0 -27.5	ø28.0 -29.5	ø30.0 -31.0
P	1-5	Non-alloy Steel	<25	25 (22-27)	0.18	0.20	0.23	0.24	0.25	0.26	0.27	0.275	0.28
P	6-9	Low alloy Steel	25-35	22 (20-25)	0.17	0.21	0.22	0.23	0.24	0.25	0.26	0.265	0.27
M	12-13	Stainless Steel		18 (15-20)	0.18	0.20	0.23	0.24	0.25	0.26	0.27	0.275	0.28
K	15-16	Grey Cast Iron		18 (15-20)	0.18	0.20	0.23	0.24	0.25	0.26	0.27	0.275	0.28
S	36-37	Titanium & Titanium Alloys		10 (8-12)	0.11	0.12	0.13	0.14	0.15	0.16	0.17	0.175	0.18
N	21-24	Aluminium Si<12%		48 (45-50)	0.25	0.275	0.30	0.325	0.35	0.36	0.37	0.375	0.38
N	29.1	Plastics, Acrylics		23 (22-25)	0.18	0.20	0.23	0.24	0.25	0.26	0.27	0.275	0.28

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.