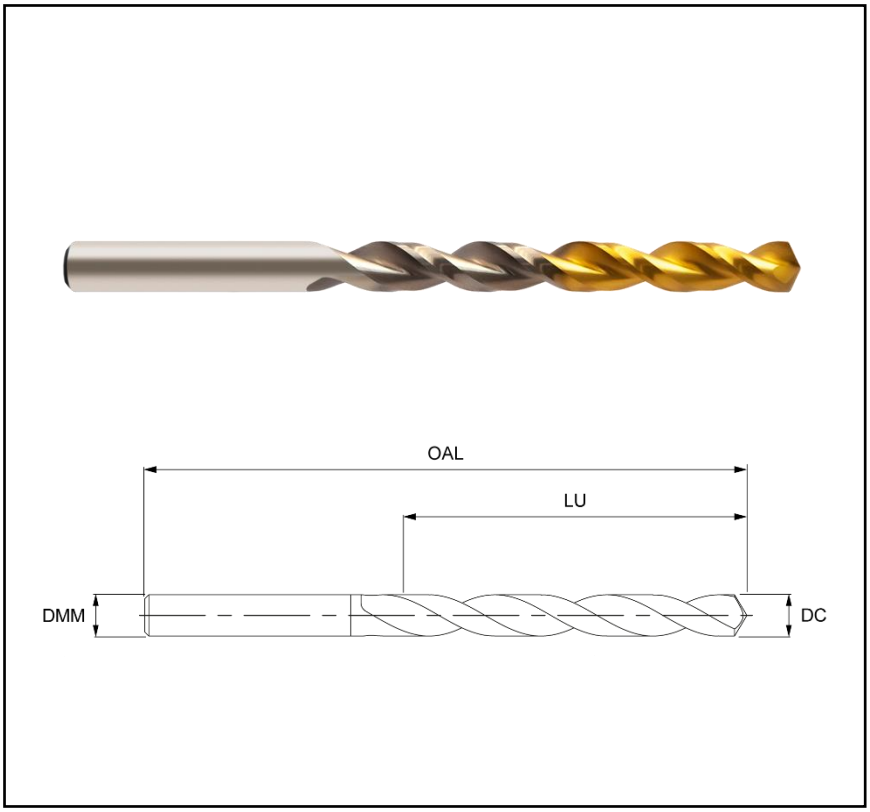
Features

- Engineered from enhanced high-speed steel (HSS-E) providing superior hardness and maintaining cutting performance even at elevated temperatures for demanding drilling tasks.
- Innovative worm-style flutes efficiently remove chips from the hole, and reduce heat buildup.
- Titanium nitride (TiN) coating enhances surface hardness and wear resistance, while the split point design ensures quick penetration, precise centering, and reduced walking on the material surface.

RS PRO HSS-E Worm Pattern 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 HSS-E Worm Patter Jobber Drill is a durable enhanced high speed steel drill bit designed for metalworking. It's worm-pattern flute clear chips efficiently, while the TiN-coated split point tip ensures accurate, self-centering. Ideal for drilling steel, stainless, cast iron, aluminium and other alloys.

General Specifications

Brand	RS PRO
Material	High Speed Steel - Enhanced (HSS-E)
Drill Bit Size	2mm – 13mm
Product Type	Drill Bit
Overall Length	49mm – 151mm
Diameter	2mm – 13mm
Cut Length	24mm – 101mm
Number of Pieces	Packs of 10 up to 6mm Pack of 5 from 6.1mm upwards
Drill Bit Type	Worm Pattern Jobber Drill
Drill Application	General application Steel Stainless steel Cast iron Titanium & alloys Aluminium

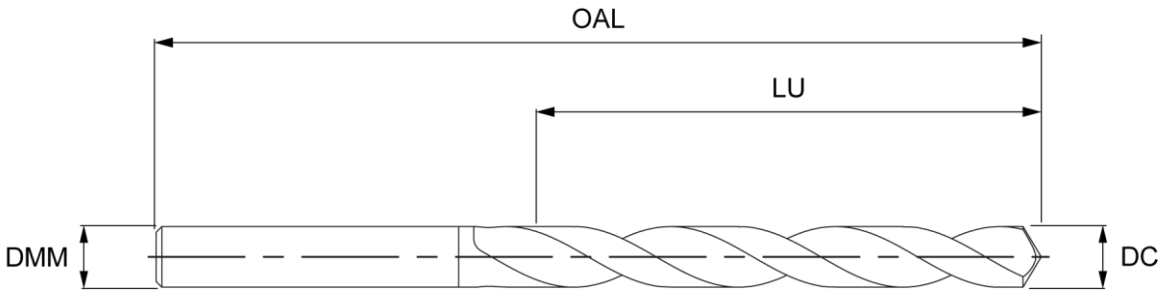
Mechanical Specifications

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 905662	RS PRO	2.0	24	49
XXX-XXXX 905663	RS PRO	2.5	30	57
XXX-XXXX 905664	RS PRO	3.0	33	61
XXX-XXXX 905665	RS PRO	3.5	39	70
XXX-XXXX 905667	RS PRO	4.0	43	75
XXX-XXXX 905666	RS PRO	4.2	43	75
XXX-XXXX 905669	RS PRO	4.5	47	80
XXX-XXXX 905670	RS PRO	5.0	52	86
XXX-XXXX 905672	RS PRO	5.5	57	93
XXX-XXXX 905671	RS PRO	6.0	57	93
XXX-XXXX 905675	RS PRO	6.5	63	101
XXX-XXXX 905673	RS PRO	6.8	69	109
XXX-XXXX 905677	RS PRO	7.0	69	109
XXX-XXXX 905676	RS PRO	7.5	69	109
XXX-XXXX 905661	RS PRO	8.0	75	117
XXX-XXXX 905678	RS PRO	8.5	75	117
XXX-XXXX 905679	RS PRO	9.0	81	125
XXX-XXXX 905681	RS PRO	9.5	81	125
XXX-XXXX 905683	RS PRO	10.0	87	133
XXX-XXXX 905682	RS PRO	10.2	87	133
XXX-XXXX 905684	RS PRO	11.0	94	142
XXX-XXXX 905686	RS PRO	12.0	101	151
XXX-XXXX 905685	RS PRO	13.0	101	151



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 (23-28)**	0.02	0.06	0.08	0.09	0.10	0.12	0.14	0.15	0.18	0.20
P	6-9	Low alloy Steel	25-35	**18 (15-20)**	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		**18 (15-20)**	0.02	0.06	0.08	0.10	0.10	0.12	0.14	0.15	0.18	0.20
K	15-16	Grey Cast Iron		**45 (40-50)**	0.02	0.07	0.11	0.14	0.14	0.18	0.20	0.22	0.28	0.28
K	17-20	Nodular/ Malleable Cast Iron		**28 (25-30)**	0.02	0.07	0.11	0.14	0.14	0.18	0.20	0.22	0.28	0.28
S	36-37	Titanium & Titanium Alloys		**18 (15-20)**	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%		**70 (65-75)**	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)