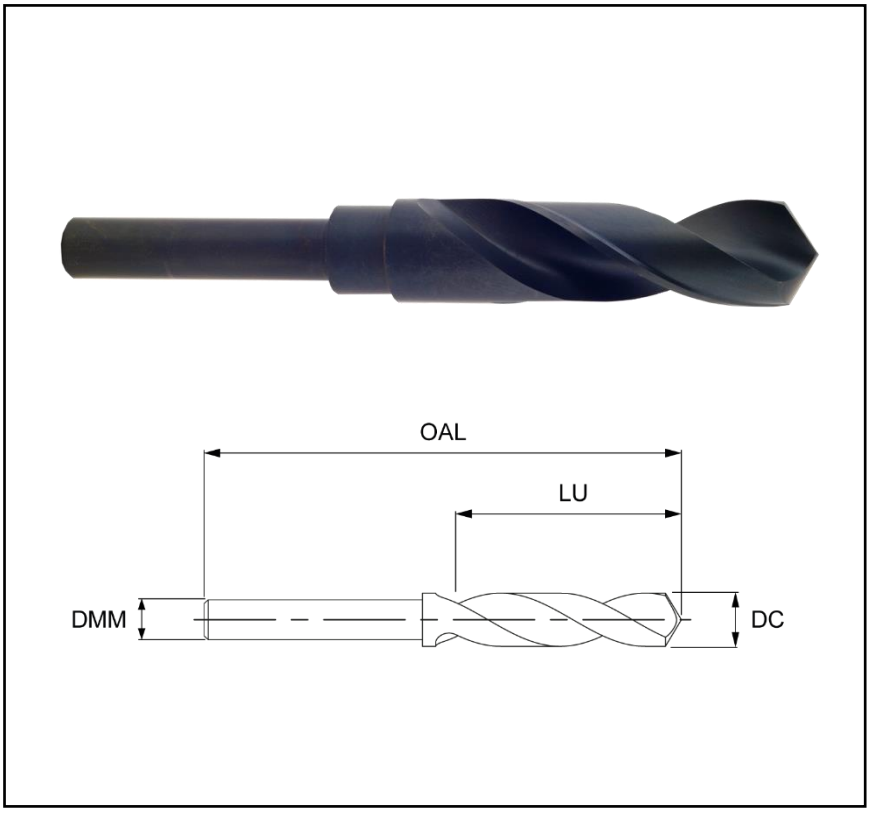
Features

- Made from High-Speed Steel (HSS) for durability and resistance.
- Blue steam-tempered finish: Gives a black/blue oxide surface that improves toughness.
- 118° point angle, 2-flute design.
- Suitable for steel, cast iron, non-ferrous materials

RS PRO HSS Blacksmith 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 Blacksmith Drill is designed for reliable performance in general engineering and fabrication applications. Manufactured from high speed steel (HSS), it offers excellent durability, heat resistance, and long tool life. The blue steam-tempered finish creates a black/blue oxide surface that enhances toughness and reduces wear during drilling. Featuring a 118° point angle and a 2 flute design, this drill provides smooth cutting action and efficient chip removal. Suitable for drilling steel, cast iron, and a wide range of non-ferrous material, it is a versatile and dependable choice for workshop and site use.

General Specifications

Brand	RS PRO
Material	High Speed Steel (HSS)
Drill Bit Size	13.5mm – 24mm
Product Type	Drill Bit
Overall Length	150mm
Diameter	12.7mm
Cut Length	75mm
Number of Pieces	1
Drill Bit Type	Twist
Drill Application	Steel Stainless steel Cast iron Aluminium Plastics, Acrylics

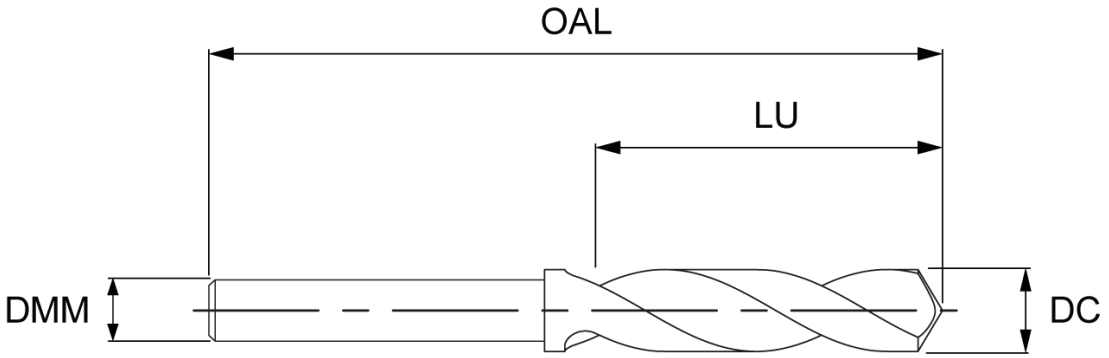
Mechanical Specifications

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	-

Stock No.	Brand	Diameter **DC / DMM**	FL.LTH **LU**	O/ALL **OAL**	Shank Dia **DMM**
XXX-XXXX 905736	RS PRO	13.5	75	150	1/2"
XXX-XXXX 905737	RS PRO	14.5	75	150	1/2"
XXX-XXXX 905740	RS PRO	16.0	75	150	1/2"
XXX-XXXX 905738	RS PRO	16.5	75	150	1/2"
XXX-XXXX 905739	RS PRO	17.0	75	150	1/2"
XXX-XXXX 905740	RS PRO	18.0	75	150	1/2"
XXX-XXXX 905741	RS PRO	23.0	75	150	1/2"
XXX-XXXX 905742	RS PRO	24.0	75	150	1/2"



Cutting Data

VDI MATERIAL GROUP			HRc	v_c (m/min)	f_n (mm/rev)													
					ø13.0 -15.5	ø16.0 -18.5	ø19.0 -21.5	ø22.0 -24.5	ø25.0 -28.5	ø28.0 -31.5	ø32.0 -35.5	ø36.0 -39.5	ø40.0 -43.5	ø44.0 -47.5	ø48.0 -51.5	ø52.0 -55.5	ø56.0 -59.5	ø60.0
P	1-5	Non-alloy Steel	<25	20 (18-22)	0.17	0.20	0.23	0.24	0.25	0.26	0.28	0.30	0.31	0.32	0.33	0.35	0.38	0.40
	6-9	Low alloy Steel	25-35	15 (13-18)	0.15	0.18	0.21	0.22	0.23	0.24	0.26	0.28	0.29	0.30	0.31	0.33	0.36	0.38
M	12-13	Stainless Steel		18 (15-20)	0.17	0.20	0.23	0.24	0.25	0.26	0.28	0.30	0.31	0.32	0.33	0.35	0.38	0.40
K	15-16	Grey Cast Iron		18 (15-20)	0.17	0.20	0.23	0.24	0.25	0.26	0.28	0.30	0.31	0.32	0.33	0.35	0.38	0.40
N	21-24	Aluminium Si<12%		45 (40-50)	0.26	0.28	0.30	0.32	0.34	0.36	0.38	0.40	0.42	0.44	0.46	0.48	0.49	0.50
	29.1	Plastics, Acrylics		22 (20-25)	0.26	0.28	0.30	0.32	0.34	0.36	0.38	0.40	0.42	0.44	0.46	0.48	0.49	0.50

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)