

Twist drill bit assortment HSS DIN 338 Type RN 130° 19 pcs

Steel precision drill bit for general, broad applications in steel up to 1,000 N/mm² and in cast iron. Available in the ORSY® system cassette.

20% lower infeed force compared to conventional drill bits as well as quicker progress and a more gentle way of working

Optimised drill-point cross thinning

Precise tapping without centring, even on curved surfaces

Optimised split point

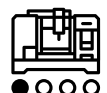
Ideal for core drill holes

Very precise point grinding for precise boreholes

Excellent adhesive properties of cooling lubricants and a reduced tendency towards the build-up of material deposits

Vaporised surface

Suitable for the ORSY® system, compact and practical system cassette with useful details, such as stackability, optimised joint and simple opening



Included in delivery	1.0–10 mm, graduation 0.5 mm
Number of pieces in assortment/set	19 PCS
Quality	ZEBRA-Premium
Standard/drilling depth	DIN 338/5xD
Shank style	Cylindrical
Material to be processed	Steel, Cast iron
Material of sub-group	General structural steels, Non-alloyed tempering steels, Cast iron, Ductile iron, Malleable cast iron, Magnesium alloys, Copper, low-alloyed, Brass, long-chipping, Brass, short-chipping, Plastics, thermoset, Plastics, thermoplastic
Surface	Vaporised
Cutting material	HSS
Type	RN
Suitable for drill	●●●○
Suitable for cordless drills	●●●○
Suitable for upright drilling machine	●●●○
Suitable for milling-drilling centre	●○○○
Service life	●●●○
Drilling speed (point system)	●●●○
Bore hole quality (point system)	●●●●
Versatility	●●○○

Drilling behaviour (point system)	●●●○
Self-centring	Yes
Color Coding System	Steel

Art. no. 0624 000 019

P. Qty.: 1

Cutting values

For dia. 1.0-2.5												
Material designation	Tensile strength	v _c		from dia. 1.0			from dia. 2.0			from dia. 2.5		
		n		f		n		f		n		f
		from	to	from	to		from	to		from	to	
Steels												
General structural steels	≤ 850 N/mm ²	25	30	7958	9549	0,016	3979	4775	0,050	3183	3820	0,063
Unalloyed quenched and tempered steels	≤ 850 N/mm ²	25	30	7958	9549	0,016	3979	4775	0,050	3183	3820	0,063
Low-alloy quenched and tempered steels	≤ 850 N/mm ²	25	30	7958	9549	0,016	3979	4775	0,050	3183	3820	0,063
Unalloyed quenched and tempered steels	≤ 1,000 N/mm ²	22	25	7003	7958	0,014	3501	3979	0,040	2801	3183	0,050
Low-alloy quenched and tempered steels	≤ 1,000 N/mm ²	22	25	7003	7958	0,014	3501	3979	0,040	2801	3183	0,050
Alloyed quenched and tempered steels	≤ 1,200 N/mm ²	10	16	3183	5093	0,012	1592	2546	0,032	1273	2037	0,040
Nitriding steels	≤ 1,200 N/mm ²	10	16	3183	5093	0,012	1592	2546	0,032	1273	2037	0,040
Tool steels	≤ 1,200 N/mm ²	10	16	3183	5093	0,012	1592	2546	0,032	1273	2037	0,040
High-speed steels	≤ 1,200 N/mm ²	10	16	3183	5093	0,012	1592	2546	0,032	1273	2037	0,040
Cast metals												
Cast iron	≤ 350 HB	28	32	8913	10186	0,018	4456	5093	0,063	3565	4074	0,080
Spheroidal graphite and malleable iron	≤ 350 HB	22	25	7003	7958	0,018	3501	3979	0,063	2801	3183	0,080
Plastics												
Plastics	≤ 200 N/mm ²	20	30	6366	9549	0,016	3183	4775	0,050	2546	3820	0,063

Cutting values

For dia. 3.15-5.0												
Material designation	Tensile strength	v _c		from dia. 3.15			from dia. 4.0			from dia. 5.0		
		n		f		n		f		n		f
		from	to	from	to		from	to		from	to	
Steels												
General structural steels	≤ 850 N/mm ²	25	30	2526	3032	0,080	1989	2387	0,100	3183	3820	0,100
Unalloyed quenched and tempered steels	≤ 850 N/mm ²	25	30	2526	3032	0,080	1989	2387	0,100	3183	3820	0,100
Low-alloy quenched and tempered steels	≤ 850 N/mm ²	25	30	2526	3032	0,080	1989	2387	0,100	3183	3820	0,100
Unalloyed quenched and tempered steels	≤ 1,000 N/mm ²	22	25	2223	2526	0,063	1751	1989	0,080	2801	3183	0,080
Low-alloy quenched and tempered steels	≤ 1,000 N/mm ²	22	25	2223	2526	0,063	1751	1989	0,080	2801	3183	0,080
Alloyed quenched and tempered steels	≤ 1,200 N/mm ²	10	16	1011	1617	0,050	796	1273	0,063	1273	2037	0,063
Nitriding steels	≤ 1,200 N/mm ²	10	16	1011	1617	0,050	796	1273	0,063	1273	2037	0,063
Tool steels	≤ 1,200 N/mm ²	10	16	1011	1617	0,050	796	1273	0,063	1273	2037	0,063
High-speed steels	≤ 1,200 N/mm ²	10	16	1011	1617	0,050	796	1273	0,063	1273	2037	0,063
Cast metals												
Cast iron	≤ 350 HB	28	32	2829	3234	0,100	2228	2546	0,125	3565	4074	0,080
Spheroidal graphite and malleable iron	≤ 350 HB	22	25	2223	2526	0,100	1751	1989	0,125	2801	3183	0,080
Plastics												
Plastics	≤ 200 N/mm ²	20	30	2021	3032	0,080	1592	2387	0,100	2546	3820	0,100

Cutting values

For dia. 6.3-10.0												
Material designation	Tensile strength	v_c		from dia. 6.3		from dia. 8.0		from dia. 10.0				
		from	to	n	f	n	f	n	f			
										from	to	
Steels												
General structural steels	$\leq 850 \text{ N/mm}^2$	25	30	1263	1516	0,125	995	1194	0,160	796	955	0,200
Unalloyed quenched and tempered steels	$\leq 850 \text{ N/mm}^2$	25	30	1263	1516	0,125	995	1194	0,160	796	955	0,200
Low-alloy quenched and tempered steels	$\leq 850 \text{ N/mm}^2$	25	30	1263	1516	0,125	995	1194	0,160	796	955	0,200
Unalloyed quenched and tempered steels	$\leq 1,000 \text{ N/mm}^2$	22	25	1112	1263	0,100	875	995	0,125	700	796	0,160
Low-alloy quenched and tempered steels	$\leq 1,000 \text{ N/mm}^2$	22	25	1112	1263	0,100	875	995	0,125	700	796	0,160
Alloyed quenched and tempered steels	$\leq 1,200 \text{ N/mm}^2$	10	16	505	808	0,080	398	637	0,100	318	509	0,125
Nitriding steels	$\leq 1,200 \text{ N/mm}^2$	10	16	505	808	0,080	398	637	0,100	318	509	0,125
Tool steels	$\leq 1,200 \text{ N/mm}^2$	10	16	505	808	0,080	398	637	0,100	318	509	0,125
High-speed steels	$\leq 1,200 \text{ N/mm}^2$	10	16	505	808	0,080	398	637	0,100	318	509	0,125
Cast metals												
Cast iron	$\leq 350 \text{ HB}$	28	32	1415	1617	0,160	1114	1273	0,200	891	1019	0,250
Spheroidal graphite and malleable iron	$\leq 350 \text{ HB}$	22	25	1112	1263	0,160	875	995	0,200	700	796	0,250
Plastics												
Plastics	$\leq 200 \text{ N/mm}^2$	20	30	1011	1516	0,125	796	1194	0,160	637	955	0,200

Key

v_c = cutting speed [m/min]

f = feed [mm/r]

n = rotation speed [rpm]

The suggested cutting values are reference values and must be adapted to the respective conditions.

Details/Application



Contents for art. no. 0624 000 019

Designation	Art. no.	Quantity
Twist drill bit HSS DIN 338 type RN 130° 1.0 mm Length 34 mm Type RN	0624 000 100	1
Twist drill bit HSS DIN 338 type RN 130° 1.5 mm Length 40 mm Type RN	0624 000 150	1
Twist drill bit HSS DIN 338 type RN 130° 2.0 mm Length 49 mm Type RN	0624 000 200	1

Contents for art. no. 0624 000 019

Designation	Art. no.	Quantity
Twist drill bit HSS DIN 338 type RN 130° 2.5 mm Length 57 mm Type RN	0624 000 250	1
Twist drill bit HSS DIN 338 type RN 130° 3.0 mm Length 61 mm Type RN	0624 000 300	1
Twist drill bit HSS DIN 338 type RN 130° 3.5 mm Length 70 mm Type RN	0624 000 350	1
Twist drill bit HSS DIN 338 type RN 130° 4.0 mm Length 75 mm Type RN	0624 000 400	1
Twist drill bit HSS DIN 338 type RN 130° 4.5 mm Length 80 mm Type RN	0624 000 450	1
Twist drill bit HSS DIN 338 type RN 130° 5.0 mm Length 86 mm Type RN	0624 000 500	1
Twist drill bit HSS DIN 338 type RN 130° 5.5 mm Length 93 mm Type RN	0624 000 550	1
Twist drill bit HSS DIN 338 type RN 130° 6.0 mm Length 93 mm Type RN	0624 000 600	1
Twist drill bit HSS DIN 338 type RN 130° 6.5 mm Length 101 mm Type RN	0624 000 650	1
Twist drill bit HSS DIN 338 type RN 130° 7.0 mm Length 109 mm Type RN	0624 000 700	1
Twist drill bit HSS DIN 338 type RN 130° 7.5 mm Length 109 mm Type RN	0624 000 750	1
Twist drill bit HSS DIN 338 type RN 130° 8.0 mm Length 117 mm Type RN	0624 000 800	1
Twist drill bit HSS DIN 338 type RN 130° 8.5 mm Length 117 mm Type RN	0624 000 850	1
Twist drill bit HSS DIN 338 type RN 130° 9 mm Length 125 mm Type RN	0624 000 900	1
Twist drill bit HSS DIN 338 type RN 130° 9.5 mm Length 125 mm Type RN	0624 000 950	1
Twist drill bit HSS DIN 338 type RN 130° 10.0 mm Length 133 mm Type RN	0624 001 000	1
Empty box for DIN 338 twist drill bit Suitable for Twist drill diameter 1.0 - 10.0 x 0.5 mm Number of slots 19 PCS	0633 002 001	1

Related products

	Art. no.
CUT+COOL drilling and cutting oil Aerosol can 400 ml	0893 050 004
CUT+COOL drilling and cutting oil Canister 5 l	0893 050 1
CUT+COOL Perfect drilling and cutting oil Aerosol can 400 ml	0893 050 008
CUT+COOL Perfect drilling and cutting oil Canister 5 l	0893 050 009
Cut and Cool Perfect drilling/cutting paste 500 ml	0893 050 010