



Solid carbide high performance drill plain shank DIN 6535 HA, TiN, Ø DC h7: 8,5mm



Order data

Order number	123106 8,5
GTIN	4045197448019
Item class	12E

Description

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Straight major cutting edges** with slightly honed edges and special flute profile produce **short chips**.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

NEW GENERATION AVAILABLE!

Recommended successor product is No. 123103.

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Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 123107**.

Form **HE**: order with **No. 123108**.

Technical description

Feed f in steel $< 1100 \text{ N/mm}^2$	0.15 mm/rev.
Shank tolerance	h6
Nominal $\varnothing D_c$	8.5 mm
Number of cutting edges Z	2
Flute length L_c	95 mm
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	10 mm

Overall length L	142 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L ₂	82.3 mm
Coating	TiN
Tool material	Solid carbide
Version	8xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	175 m/min	N
Alu > 10% Si	suitable only under restricted conditions	135 m/min	N
Steel < 500 N/mm ²	suitable only under restricted conditions	105 m/min	P
Steel < 750 N/mm ²	suitable	85 m/min	P
Steel < 900 N/mm ²	suitable	75 m/min	P
Steel < 1100 N/mm ²	suitable	45 m/min	P
Steel < 1400 N/mm ²	suitable	30 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	35 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	30 m/min	M
GG(G)	suitable	65 m/min	K
Uni	suitable		

wet maximum

suitable