



## Solid carbide high performance drill Weldon shank DIN 6535 HB, TiN, Ø DC h7: 8,5mm



### Order data

Order number	123107 8,5
GTIN	4045197449443
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. 123104.**

### Technical description

Flute length $L_c$	95 mm
Nominal $\varnothing D_c$	8.5 mm
Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.15 mm/rev.
Shank tolerance	h6
Number of cutting edges $Z$	2
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 HB to h6
Through-coolant	yes, with 25 bar
Colour ring	green
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	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 <sup>2</sup>	suitable only under restricted conditions	105 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	85 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	75 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	45 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	30 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	30 m/min	M
GG(G)	suitable	65 m/min	K
Uni	suitable		
wet maximum	suitable		