HOLEX

# Solid carbide drill plain shank DIN 6535 HB, TiAlN, ∅ DC m7 (mm or inch): 8,8

## Order data

| | |
|---|---|
| Order number | 122772 8,8 |
| GTIN | 4062406149499 |
| Item class | 12F |

## Description

**Version:**
Tool specially matched to drilling holes without through-coolant. **Concave major cutting edges** and a **special flute profile** ensure a good chip evacuation. The sturdy cutter geometry with **special point geometry** and 4 cutting edges ensures drilling with good process reliability. A wide range of applications in steel materials thanks to a combination of tough ultra-fine grain carbide and extremely **wear-resistant** and **heat-resistant coating.**
**Note:**
Flute length $L_C = L_2 + 1.5 \times D_C$.
Through-coolant: no
Standard: DIN 6537
Tolerance nominal ∅: m7
Number of cutting edges Z: 2
recommended maximum drilling depth $L_2$: 47.8 mm
Tolerance nominal ∅: m7
Overall length L: 103 mm
Shank ∅ $D_s$: 10 mm
Feed f in steel < 900 N/mm$^2$: 0.2 mm/rev.

## Technical description

| | |
|---|---|
| Number of cutting edges Z | 2 |
| Tolerance nominal ∅ | m7 |
| recommended maximum drilling depth $L_2$ | 47.8 mm |
| Standard | DIN 6537 |
| Overall length L | 103 mm |

| | |
|---|---|
| Flute length $L_c$ | 61 mm |
| Nominal Ø $D_C$ | 8.8 mm |
| Feed f in steel < 900 N/mm² | 0.2 mm/rev. |
| Shank Ø $D_s$ | 10 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 6×D |
| Point angle | 140 ° |
| Shank | DIN 6535 HB to h6 |
| Through-coolant | no |
| Colour ring | green |
| Type of product | Jobber drill |

## User data

| | Suitability | $V_c$ | ISO code |
|---|---|---|---|
| Aluminium (short chipping) | suitable only under restricted conditions | 200 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 160 m/min | N |
| Steel < 500 N/mm² | suitable | 110 m/min | P |
| Steel < 750 N/mm² | suitable | 90 m/min | P |
| Steel < 900 N/mm² | suitable | 80 m/min | P |
| Steel < 1100 N/mm² | suitable | 70 m/min | P |
| Steel < 1400 N/mm² | suitable only under restricted conditions | 60 m/min | P |
| GG | suitable | 90 m/min | K |
| GGG | suitable only under restricted conditions | 60 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |

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| dry | suitable only under restricted conditions |