



## Solid carbide drill plain shank DIN 6535 HB, TiAlN, Ø DC m7 (mm or inch): 8,5



### Order data

|              |               |
|--------------|---------------|
| Order number | 122772 8,5    |
| GTIN         | 4062406149451 |
| 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 Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 48.25 mm

Tolerance nominal Ø: m7

Overall length L: 103 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.2 mm/rev.

### Technical description

|                     |          |
|---------------------|----------|
| Standard            | DIN 6537 |
| Tolerance nominal Ø | m7       |
| Shank Ø $D_s$       | 10 mm    |
| Nominal Ø $D_c$     | 8.5 mm   |
| Overall length L    | 103 mm   |

|   |                   |
|---|-------------------|
| Feed f in steel < 900 N/mm <sup>2</sup>           | 0.2 mm/rev.       |
| recommended maximum drilling depth L <sub>2</sub> | 48.25 mm          |
| Number of cutting edges Z                         | 2                 |
| Flute length L <sub>c</sub>                       | 61 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 <sub>c</sub> | 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/mm <sup>2</sup>  | suitable                                  | 110 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 90 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 80 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 70 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | 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                                  |                |          |

dry

suitable only under  
restricted conditions