



## Solid carbide high performance drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m7: 8,5mm



### Order data

Order number	122666 8,5
GTIN	4045197425744
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  $L_c = L_2 + 1.5 \times D_c$ .

Through-coolant: yes, with 25 bar

Standard: DIN 6537

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 48.3 mm

Tolerance nominal Ø: m7

Overall length L: 103 mm

Shank Ø  $D_s$ : 10 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.1 mm/rev.

### Technical description

Flute length $L_c$	61 mm
Nominal Ø $D_c$	8.5 mm
Number of cutting edges Z	2
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.1 mm/rev.
Shank tolerance	h6

Tolerance nominal $\varnothing$	m7
Shank $\varnothing D_s$	10 mm
Overall length L	103 mm
Standard	DIN 6537
recommended maximum drilling depth $L_2$	48.3 mm
Coating	TiAlN
Tool material	Solid carbide
Version	6xD
Point angle	140°
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Colour ring	blue
Type of product	Jobber drill

## User data

	Suitability	$V_c$	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	140 m/min	N
Alu > 10% Si	suitable only under restricted conditions	120 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	60 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	45 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	40 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	32 m/min	S

GG	suitable only under restricted conditions	70 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		