



Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 8,5mm



Order data

| | |
|--------------|---------------|
| Order number | 122394 8,5 |
| GTIN | 4045197419453 |
| 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 $L_c = L_2 + 1.5 \times D_c$.

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

Form **HB**: order with **No. 122396**.

Form **HE**: order with **No. 122398**.

Through-coolant: no

Standard: DIN 6537 K

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 34.3 mm

Tolerance nominal Ø: m7

Overall length L: 89 mm

Shank Ø D_s : 10 mm

Feed f in stainless steel < 900 N/mm²: 0.1 mm/rev.

Technical description

| | |
|---|-------------|
| Feed f in stainless steel < 900 N/mm ² | 0.1 mm/rev. |
| Flute length L_c | 47 mm |
| Nominal Ø D_c | 8.5 mm |

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|---|-------------------|
| Number of cutting edges Z | 2 |
| Shank tolerance | h6 |
| Tolerance nominal \varnothing | m7 |
| Shank $\varnothing D_s$ | 10 mm |
| Overall length L | 89 mm |
| Standard | DIN 6537 K |
| recommended maximum drilling depth L ₂ | 34.3 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 4xD |
| Point angle | 140° |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | no |
| 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 ² | suitable | 80 m/min | P |
| Steel < 750 N/mm ² | suitable | 75 m/min | P |
| Steel < 900 N/mm ² | suitable | 65 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 60 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 35 m/min | P |
| INOX < 900 N/mm ² | suitable | 35 m/min | M |

| | | | |
|------------------------------|---|----------|---|
| INOX > 900 N/mm ² | suitable | 30 m/min | M |
| GG | suitable only under restricted conditions | 70 m/min | K |
| wet maximum | suitable | | |
| wet minimum | suitable only under restricted conditions | | |