

**Solid carbide high performance drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m7: 2,5mm****Order data**

Order number	122396 2,5
GTIN	4045197423009
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 $L_c = L_2 + 1.5 \times D_c$.

Technical description

Number of cutting edges Z	2
Nominal Ø D_c	2.5 mm
Feed f in stainless steel < 900 N/mm ²	0.05 mm/rev.
Shank tolerance	h6
Flute length L_c	16 mm
Tolerance nominal Ø	m7
Shank Ø D_s	6 mm
Overall length L	58 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	12.3 mm
Coating	TiAlN

Tool material	Solid carbide
Version	4xD
Point angle	140 degrees
Shank	DIN 6535 HB 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
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable only under restricted conditions		

