



## Solid carbide high performance drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m7: 9,1mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122396 9,1    |
| GTIN         | 4045197423665 |
| 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

|   |              |
|---|--------------|
| Nominal Ø $D_c$                                     | 9.1 mm       |
| Feed $f$ in stainless steel < 900 N/mm <sup>2</sup> | 0.12 mm/rev. |
| Shank tolerance                                     | h6           |
| Flute length $L_c$                                  | 47 mm        |
| Number of cutting edges $Z$                         | 2            |
| Tolerance nominal Ø                                 | m7           |
| Shank Ø $D_s$                                       | 10 mm        |
| Overall length $L$                                  | 89 mm        |
| Standard  | DIN 6537 K   |
| recommended maximum drilling depth $L_2$            | 33.4 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 <sub>c</sub> | 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                                  | 80 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 75 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 65 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 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                                  | 35 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | 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 |                |          |

