



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



### Order data

Order number	122396 8,5
GTIN	4045197423603
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

Shank tolerance	h6
Feed $f$ in stainless steel < 900 N/mm <sup>2</sup>	0.1 mm/rev.
Flute length $L_c$	47 mm
Number of cutting edges $Z$	2
Nominal Ø $D_c$	8.5 mm
Tolerance nominal Ø	m7
Shank Ø $D_s$	10 mm
Overall length $L$	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	34.3 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 <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		

