



Solid carbide high performance drill Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC m7: 8,5mm



Order data

Order number	122398 8,5
GTIN	4045197426857
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: 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.
Shank tolerance	h6
Flute length L_c	47 mm
Number of cutting edges Z	2
Nominal Ø D_c	8.5 mm

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 HE 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		