



## Solid carbide jobber drill, TiN, Ø DC h7: 8,5mm



### Order data

Order number	122301 8,5
GTIN	4045197042903
Item class	12E

### Description

#### Version:

#### Similar to DIN 338.

Nominal Ø and shank Ø equal.

TiN coating.

#### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Non slip clamping in drill chuck No. 341050 with diamond coated jaws.

### Technical description

Flute length $L_c$	75 mm
Nominal Ø $D_c$	8.5 mm
Shank tolerance	h7
Number of cutting edges Z	2
Feed f in steel < 1100 N/mm <sup>2</sup>	0.11 mm/rev.
Tolerance nominal Ø	h7
Shank Ø $D_s$	8.5 mm
Overall length L	117 mm
Standard	DIN 338
recommended maximum drilling depth $L_2$	62.3 mm
Coating	TiN
Tool material	Solid carbide

Type	N
Point angle	118 degrees
Helix angle	30 degrees
Shank	Parallel shank to h7
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

### User data

	Suitability	V <sub>c</sub>	ISO code
Alu plastics	suitable only under restricted conditions	230 m/min	N
Aluminium (short chipping)	suitable	160 m/min	N
Alu > 10% Si	suitable	160 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	50 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	30 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable only under restricted conditions	30 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable only under restricted conditions	25 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	20 m/min	S
GG(G)	suitable	85 m/min	K
CuZn	suitable	160 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		

dry

suitable only under  
restricted conditions