


Solid carbide jobber drill, TiN, Ø DC h7: 8,6mm

Order data

Order number	122301 8,6
GTIN	4045197042910
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	81 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.11 mm/rev.
Shank tolerance	h7
Number of cutting edges Z	2
Nominal Ø D_c	8.6 mm
Tolerance nominal Ø	h7
Shank Ø D_s	8.6 mm
Overall length L	125 mm
Standard	DIN 338
recommended maximum drilling depth L_2	68.1 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 _c	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 ²	suitable	80 m/min	P
Steel < 750 N/mm ²	suitable	80 m/min	P
Steel < 900 N/mm ²	suitable	70 m/min	P
Steel < 1100 N/mm ²	suitable	50 m/min	P
Steel < 1400 N/mm ²	suitable	30 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	30 m/min	M
INOX > 900 N/mm ²	suitable only under restricted conditions	25 m/min	M
Ti > 850 N/mm ²	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