



## Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 8,6mm



### Order data

Order number	122404 8,6
GTIN	4045197420541
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  $L_c = L_2 + 1.5 \times D_c$ .

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122406**.

Form **HE**: order with **No. 122408**.

Through-coolant: yes, with 25 bar

Standard: DIN 6537 K

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 34.1 mm

Tolerance nominal Ø: m7

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.1 mm/rev.

### Technical description

Nominal Ø $D_c$	8.6 mm
Shank tolerance	h6
Number of cutting edges Z	2

Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.1 mm/rev.
Flute length L <sub>c</sub>	47 mm
Tolerance nominal Ø	m7
Shank Ø D <sub>s</sub>	10 mm
Overall length L	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	34.1 mm
Coating	TiAlN
Tool material	Solid carbide
Version	4×D
Point angle	140 °
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
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	110 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	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	45 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	40 m/min	M

Ti > 850 N/mm <sup>2</sup>	suitable	30 m/min	S
GG	suitable only under restricted conditions	70 m/min	K
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		