



## Solid carbide drill IC plain shank unidirectional DIN 6535 HA, Diamond, Ø m7: 8,1-8,9 mm



### Order data

Order number	122534 8,1-8,9
GTIN	4045197510747
Item class	10N

### Description

#### Version:

With the latest generation of **crystalline diamond coating sp<sup>3</sup>**, for process reliability in machining **fibre-reinforced composites, CRP, GRP, and graphite. With 90° point angle** and special geometry to **avoid delamination.**

Under optimum conditions of use, the **double flute face** can generate high precision holes (**roundness < 15 µm to base tolerance IT 7**). Low heat generation due to **internal cooling** permits **higher speeds and feeds.**

#### Recommendation:

##### Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

##### Note:

Available in **1/100 sizes** and according to the table.

Through-coolant: yes, with 25 bar

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

Ø range (1/100 size): 8.01 - 8.99 mm

Flute length: 61 mm

Overall length L<sub>tot</sub>: 103 mm

Shank Ø: 10 mm

Feed f in GRP CRP: 0.15 mm/rev.

### Technical description

Nominal Ø	8.01 - 8.99 mm
Ø range (1/100 size)	8.01 - 8.99 mm
Shank tolerance	h6

Flute length	61 mm
Feed f in GRP CRP	0.15 mm/rev.
Number of cutting edges Z	2
Tolerance nominal $\varnothing$	m7
Shank $\varnothing$	10 mm
Overall length $L_{tot}$	103 mm
Coating	Diamond
Tool material	Solid carbide
Norm	Manufacturer's standard
Drill depth up to	5×D
Point angle	90 degrees
Skaft	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Colour ring	black