



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



Order data

Order number	122534 9,1-9,9
GTIN	4045197510754
Item class	10N

Description

Version:

With the latest generation of **crystalline diamond coating sp³**, 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): 9.01 - 9.99 mm

Flute length: 61 mm

Overall length L_{tot}: 103 mm

Shank Ø: 10 mm

Feed f in GRP CRP: 0.15 mm/rev.

Technical description

Ø range (1/100 size)	9.01 - 9.99 mm
Nominal Ø	9.01 - 9.99 mm
Feed f in GRP CRP	0.15 mm/rev.

Shank tolerance	h6
Flute length	61 mm
Number of cutting edges Z	2
Tolerance nominal Ø	m7
Shank Ø	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