



Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC m7: 8,5mm



Order data

Order number	122406 8,5
GTIN	4045197424679
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 $L_c = L_2 + 1.5 \times D_c$.

Technical description

Flute length L_c	47 mm
Nominal Ø D_c	8.5 mm
Feed f in stainless steel $< 900 \text{ N/mm}^2$	0.1 mm/rev.
Shank tolerance	h6
Number of cutting edges Z	2
Tolerance nominal Ø	m7
Shank Ø D_s	10 mm
Overall length L	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	34.3 mm
Coating	TiAlN

Tool material	Solid carbide
Version	4xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Colour ring	blue
Type of product	Jobber drill

User data

	Suitability	V _c	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 ²	suitable	110 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 N/mm ²	suitable	80 m/min	P
Steel < 1100 N/mm ²	suitable	60 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	35 m/min	P
INOX < 900 N/mm ²	suitable	45 m/min	M
INOX > 900 N/mm ²	suitable	40 m/min	M
Ti > 850 N/mm ²	suitable	30 m/min	S
GG	suitable only under restricted conditions	70 m/min	K
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		