



## Solid carbide high performance drill, plain shank DIN 6535 HA, TiN, Ø DC h7 (mm or inch): 8,5



### Order data

Order number	122310 8,5
GTIN	4045197043900
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  $L_c = L_2 + 1.5 \times D_c$ .

**NEW GENERATION AVAILABLE!**

**Recommended successor product is No. 122501.**

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

**Form HB:** order with **No. 122315**.

**Form HE:** order with **No. 122320**.

### Technical description

Nominal Ø $D_c$	8.5 mm
Flute length $L_c$	47 mm
Shank tolerance	h6
Number of cutting edges Z	2
Feed f in steel < 900 N/mm <sup>2</sup>	0.18 mm/rev.
Tolerance nominal Ø	h7
Shank Ø $D_s$	10 mm
Overall length L	89 mm

Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	34.3 mm
Coating	TiN
Tool material	Solid carbide
Version	4×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Semi-Standard	yes
Colour ring	without
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	80 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	75 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	60 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	P
GG(G)	suitable only under restricted conditions	70 m/min	K
wet maximum	suitable		
dry	suitable		

