

Solid carbide drill IC plain shank unidirectional DIN 6535 HA, Diamond, Ø DC m7: 9,5 mm



Order data

Order number	122532 9,5
GTIN	4062406349202
Item class	11Y

Description

Version:

With the latest generation of **crystalline diamond coating sp**³, 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 μ m 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 $1.5 \times nominal \emptyset$.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

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

Tolerance nominal Ø: m7 Number of cutting edges Z: 2

Ø range (1/100 size): 9.01 - 9.99 mm

recommended maximum drilling depth L₂: 46.75 mm

Overall length L: 103 mm Shank Ø D_s: 10 mm

Feed f in GRP CRP: 0.15 mm/rev.

Technical description

Number of cutting edges Z	2
Feed f in GRP CRP	0.15 mm/rev.

Nominal Ø D _c Overall length L Ø range (1/100 size) recommended maximum drilling depth L₂ Shank Ø D _s Tolerance nominal Ø Tool material Standard Drill depth up to Point angle Cutting direction Shank DIN 6535 HA to h6 Through-coolant Colour ring P.5 mm 9.5 mm 9.61 - 9.99 mm 46.75 mm 10 mm m7 Coating Diamond Tool material Solid carbide Manufacturer's standard Manufacturer's standard DIN 6535 HA to h6 Through-coolant yes, with 25 bar Colour ring	Flute length L _c	61 mm
Overall length L Ø range (1/100 size) 9.01 - 9.99 mm recommended maximum drilling depth L₂ Shank Ø D₅ Tolerance nominal Ø Tool material Solid carbide Standard Manufacturer's standard Drill depth up to Point angle Cutting direction Shank DIN 6535 HA to h6 Through-coolant Colour ring 103 mm 103 mm 104 mm 46.75 mm M7 Di mm Tolerance nominal Ø M7 Solid carbide Manufacturer's standard FixD 90 degrees Cutting direction Fight-hand DIN 6535 HA to h6 Through-coolant Colour ring black	Shank tolerance	h6
Ø range (1/100 size) 9.01 - 9.99 mm recommended maximum drilling depth L₂ 46.75 mm Shank Ø D₃ 10 mm Tolerance nominal Ø m7 Coating Diamond Tool material Solid carbide Standard Manufacturer's standard Drill depth up to 5×D Point angle 90 degrees Cutting direction right-hand Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Colour ring black	Nominal Ø D _c	9.5 mm
recommended maximum drilling depth L ₂ Shank Ø D _s Tolerance nominal Ø Tool material Tool material Solid carbide Standard Manufacturer's standard Drill depth up to Point angle Cutting direction Shank DIN 6535 HA to h6 Through-coolant Colour ring Manufacturer's bar Black	Overall length L	103 mm
Shank Ø D _s Tolerance nominal Ø Tolerance nominal Ø Tool material Tool material Standard Standard Drill depth up to Point angle Cutting direction Shank Through-coolant Tool material Solid carbide Manufacturer's standard Manufacturer's standard Tool material Solid carbide Manufacturer's standard Tool material Solid carbide Manufacturer's standard Through-coolant Sys D S	Ø range (1/100 size)	9.01 - 9.99 mm
Tolerance nominal Ø Coating Diamond Tool material Solid carbide Standard Manufacturer's standard Drill depth up to Point angle Cutting direction Shank DIN 6535 HA to h6 Through-coolant Colour ring M7 Diamond Manufacturer's standard Manufacturer's standard Manufacturer's standard Manufacturer's standard Manufacturer's standard Manufacturer's standard Dix 5×D 90 degrees right-hand DIN 6535 HA to h6 yes, with 25 bar	recommended maximum drilling depth L ₂	46.75 mm
Coating Diamond Tool material Solid carbide Standard Manufacturer's standard Drill depth up to 5×D Point angle 90 degrees Cutting direction right-hand Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Colour ring black	Shank Ø D _s	10 mm
Tool material Solid carbide Standard Manufacturer's standard Drill depth up to 5×D Point angle 90 degrees Cutting direction right-hand Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Colour ring black	Tolerance nominal Ø	m7
Standard Manufacturer's standard Drill depth up to 5×D Point angle 90 degrees Cutting direction right-hand Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Colour ring black	Coating	Diamond
Drill depth up to 5×D Point angle 90 degrees Cutting direction right-hand Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Colour ring black	Tool material	Solid carbide
Point angle 90 degrees Cutting direction right-hand Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Colour ring black	Standard	Manufacturer's standard
Cutting direction right-hand Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Colour ring black	Drill depth up to	5×D
Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Colour ring black	Point angle	90 degrees
Through-coolant yes, with 25 bar Colour ring black	Cutting direction	right-hand
Colour ring black	Shank	DIN 6535 HA to h6
3	Through-coolant	yes, with 25 bar
Type of product Jobber drill	Colour ring	black
	Type of product	Jobber drill