



Solid carbide high performance drill, plain shank DIN 6535 HA, TiN, Ø DC h7 (mm or inch): 8,9



Order data

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|--------------|---------------|
| Order number | 122310 8,9 |
| GTIN | 4045197043948 |
| 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

| | |
|---|--------------|
| Feed f in steel < 900 N/mm ² | 0.18 mm/rev. |
| Flute length L_c | 47 mm |
| Nominal Ø D_c | 8.9 mm |
| Shank tolerance | h6 |
| Number of cutting edges Z | 2 |
| Tolerance nominal Ø | h7 |
| Shank Ø D_s | 10 mm |
| Overall length L | 89 mm |

| | |
|---|-------------------|
| Standard | DIN 6537 K |
| recommended maximum drilling depth L ₂ | 33.7 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 _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 | 80 m/min | P |
| Steel < 750 N/mm ² | suitable | 75 m/min | P |
| Steel < 900 N/mm ² | suitable | 65 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 60 m/min | P |
| Steel < 1400 N/mm ² | 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 | | |

