



Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiN, Ø DC h7: 8,5mm



Order data

| | |
|--------------|---------------|
| Order number | 122315 8,5 |
| GTIN | 4045197387059 |
| 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

| | |
|---|--------------|
| Number of cutting edges Z | 2 |
| Shank tolerance | h6 |
| Feed f in steel < 900 N/mm ² | 0.18 mm/rev. |
| Nominal Ø D _c | 8.5 mm |
| Flute length L _c | 47 mm |
| 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 | 34.3 mm |
| Coating | TiN |

| | |
|-----------------|-------------------|
| Tool material | Solid carbide |
| Version | 4×D |
| Point angle | 140 degrees |
| Shank | DIN 6535 HB 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 | | |