



## Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiN, Ø DC h7: 8,6mm



### Order data

Order number	122315 8,6
GTIN	4045197387066
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

Nominal Ø $D_c$	8.6 mm
Shank tolerance	h6
Number of cutting edges Z	2
Feed f in steel < 900 N/mm <sup>2</sup>	0.18 mm/rev.
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 $L_2$	34.1 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 <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		