HOLEX

Solid carbide high performance drill plain shank DIN 6535 HB, TiN, ⌀ 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 ⌀ D_C	8.6 mm
Shank tolerance	h6
Number of cutting edges Z	2
Feed f in steel < 900 N/mm^2	0.18 mm/rev.
Flute length L_c	47 mm
Tolerance nominal ⌀	h7
Shank ⌀ 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_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/mm²	suitable	80 m/min	P
Steel < 750 N/mm²	suitable	75 m/min	P
Steel < 900 N/mm²	suitable	65 m/min	P
Steel < 1100 N/mm²	suitable only under restricted conditions	60 m/min	P
Steel < 1400 N/mm²	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		