



**Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiN, Ø DC  
h7: 6,9mm**



## Order data

Order number	122315 6,9
GTIN	4045197386892
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

Feed f in steel < 900 N/mm <sup>2</sup>	0.18 mm/rev.
Flute length $L_c$	34 mm
Nominal Ø $D_c$	6.9 mm
Shank tolerance	h6
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Shank Ø $D_s$	8 mm
Overall length L	79 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	23.7 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		