



## Solid carbide high performance drill, plain shank DIN 6535 HA, TiN, Ø DC h7 (mm or inch): 8,5



### Order data

Order number	122340 8,5
GTIN	4045197044846
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. 122504.**

Versions with HB and HE shank available at the same price as HA.

**HB shank:** use order **No. 122345**.

**HE shank:** use order **No. 122355**.

### Technical description

Flute length $L_c$	47 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.18 mm/rev.
Number of cutting edges $Z$	2
Nominal $\varnothing D_c$	8.5 mm
Shank tolerance	h6
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	10 mm
Overall length $L$	89 mm

Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	34.3 mm
Coating	TiN
Tool material	Solid carbide
Version	4×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	240 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable only under restricted conditions	65 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	35 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	30 m/min	M
Ti > 850 N/mm <sup>2</sup>	suitable	30 m/min	S
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		

Air

suitable only under  
restricted conditions