


**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø h7: 8,2 mm**

**Order data**

Order number	123102 8,2
GTIN	4045197458605
Item class	11E

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

**Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**Advantage:**

**High process reliability and surface quality of the hole.**

**Recommendation:**
**Maximum drilling depth:**

clamping slot length (see table) less 1.5×nominal Ø.

**Note:**

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 123026 and 123036.**

Machining strategy: HPC

Norm: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

Flute length: 95 mm

Overall length  $L_{tot}$ : 142 mm

Shank Ø: 10 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.15 mm/rev.

**Technical description**

Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.15 mm/rev.
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Shank tolerance	h6
Flute length	95 mm
Nominal Ø	8.2 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Shank Ø	10 mm
Overall length L <sub>tot</sub>	142 mm
Norm	Manufacturer's standard
recommended maximum drilling depth	82.7 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	8×D
Point angle	135 degrees
Skaft	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	green