



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



### Order data

Order number	122635 8,6
GTIN	4045197394699
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. 122777.**

### Technical description

Nominal Ø D <sub>c</sub>	8.6 mm
Shank tolerance	h6
Flute length L <sub>c</sub>	61 mm
Number of cutting edges Z	2
Feed f in steel < 900 N/mm <sup>2</sup>	0.18 mm/rev.
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	10 mm
Overall length L	103 mm
Standard	DIN 6537

recommended maximum drilling depth $L_2$	48.1 mm
Coating	TiN
Tool material	Solid carbide
Version	6×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Colour ring	green
Type of product	Jobber drill

### User data

	Suitability	$V_c$	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	30 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		

