Solid carbide HPC drill, plain shank DIN 6535 HB, TiAlN, ∅ DC h7: 8,06-Xmm

Order data

Order number	122765 8,06-X
GTIN	4062406522667
Item class	11E

Description

Version:
Cutting chisel edge with high centring accuracy due to strong core and special point geometry. Convex cutting edges with honed edges and special flute profile for short chips, even on long chipping materials.
Note:
Flute length LC = L2 + 1.5 × DC. NEW GENERATION AVAILABLE! Recommended successor products are No. 122761 and 122762. Delivery time: 12 working weeks Minimum order quantity: 3 pcs Items made to order for a specific customer: Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement. Items cannot be returned. We reserve the right to over-deliver or under-deliver by ±10% (minimum 1 piece).

Technical description

Number of cutting edges Z	2
Standard	DIN 6537
Shank tolerance	h6
Flute length L_c	61 mm
Feed f in steel < 1100 N/mm^2	0.2 mm/rev.
Overall length L	103 mm
Tolerance nominal ∅	h7
Shank ∅ D_s	10 mm
∅ range	8.06 - 10.05 mm
Coating	TiAlN

Tool material	Solid carbide
Version	6×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm²	suitable only under restricted conditions	120 m/min	P
Steel < 750 N/mm²	suitable	100 m/min	P
Steel < 900 N/mm²	suitable	85 m/min	P
Steel < 1100 N/mm²	suitable	65 m/min	P
Steel < 1400 N/mm²	suitable	35 m/min	P
Steel < 55 HRC	suitable	28 m/min	H
INOX < 900 N/mm²	suitable only under restricted conditions	30 m/min	M
Ti > 850 N/mm²	suitable only under restricted conditions	35 m/min	S
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		
Air	suitable		