



## Solid carbide drill plain shank DIN 6535 HB, TiAlN, Ø DC m7 (mm or inch): 8,4 mm or inch



### Order data

Order number	122772 8,4
GTIN	4062406149444
Item class	12F

### Description

#### Version:

Tool specially matched to drilling holes without through-coolant. **Concave major cutting edges** and a **special flute profile** ensure a good chip evacuation. The sturdy cutter geometry with **special point geometry** and 4 cutting edges ensures drilling with good process reliability. A wide range of applications in steel materials thanks to a combination of tough ultra-fine grain carbide and extremely **wear-resistant** and **heat-resistant coating**.

#### Recommendation:

##### Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

##### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Through-coolant: no

Standard: DIN 6537

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

Tolerance nominal Ø: m7

recommended maximum drilling depth  $L_2$ : 48.4 mm

Overall length L: 103 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.2 mm/rev.

### Technical description

Standard	DIN 6537
Tolerance nominal Ø	m7

Shank $\varnothing D_s$	10 mm
recommended maximum drilling depth $L_2$	48.4 mm
Number of cutting edges Z	2
Overall length L	103 mm
Nominal $\varnothing D_c$	8.4 mm
Flute length $L_c$	61 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.2 mm/rev.
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
Colour ring	green
Type of product	Jobber drill