



## Solid carbide drill plain shank DIN 6535 HE, TiAlN, Ø DC m7 (mm or inch): 6,8 mm or inch



### Order data

Order number	122773 6,8
GTIN	4062406150693
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  $L_2$ : 42.8 mm

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.18 mm/rev.

### Technical description

Feed f in steel < 900 N/mm <sup>2</sup>	0.18 mm/rev.
recommended maximum drilling depth $L_2$	42.8 mm

Standard	DIN 6537
Number of cutting edges Z	2
Nominal $\varnothing D_c$	6.8 mm
Flute length $L_c$	53 mm
Shank $\varnothing D_s$	8 mm
Tolerance nominal $\varnothing$	m7
Overall length L	91 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6xD
Point angle	140 degrees
Shank	DIN 6535 HE to h6
Through-coolant	no
Colour ring	green
Type of product	Jobber drill