



## Solid carbide drill plain shank DIN 6535 HE, TiAlN, Ø DC m7 (mm or inch): 8,2 mm or inch



### Order data

|              |               |
|--------------|---------------|
| Order number | 122773 8,2    |
| GTIN         | 4062406150860 |
| 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  $L_2$ : 48.7 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 |
| Overall length L | 103 mm   |

|                                          |                   |
|------------------------------------------|-------------------|
| Flute length $L_c$                       | 61 mm             |
| Nominal $\varnothing D_c$                | 8.2 mm            |
| Tolerance nominal $\varnothing$          | m7                |
| recommended maximum drilling depth $L_2$ | 48.7 mm           |
| Feed $f$ in steel $< 900 \text{ N/mm}^2$ | 0.2 mm/rev.       |
| Shank $\varnothing D_s$                  | 10 mm             |
| Number of cutting edges $Z$              | 2                 |
| 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      |