



## Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiN, Ø DC h7: 8,1 mm



### Order data

Order number	122315 8,1
GTIN	4045197387011
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**.

#### Recommendation:

##### Maximum drilling depth:

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

##### Note:

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

Semi-Standard: yes

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 34.9 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

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

### Technical description

Number of cutting edges Z	2
Shank tolerance	h6
Nominal Ø $D_c$	8.1 mm
Flute length $L_c$	47 mm

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	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	34.9 mm
Coating	TiN
Tool material	Solid carbide
Drill depth up to	4×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
Semi-Standard	yes
Colour ring	without
Type of product	Jobber drill