



## Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiN, Ø DC h7: 9,9 mm



### Order data

Order number	122315 9,9
GTIN	4045197387196
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  $L_c = L_2 + 1.5 \times D_c$

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 32.2 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.22 mm/rev.

### Technical description

Feed f in steel < 900 N/mm <sup>2</sup>	0.22 mm/rev.
Shank tolerance	h6
Nominal Ø $D_c$	9.9 mm

Flute length $L_c$	47 mm
Number of cutting edges Z	2
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	10 mm
Overall length L	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	32.2 mm
Semi-Standard	yes
Coating	TiN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
Colour ring	without
Type of product	Jobber drill