



Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 8,4 mm



Order data

Order number	122394 8,4
GTIN	4045197419446
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:

clamping slot length (see table) less $1.5 \times \text{nominal } \varnothing$.

Note:

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

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122396**.

Form **HE**: order with **No. 122398**.

Through-coolant: no

Standard: DIN 6537 K

Tolerance nominal \varnothing : m7

Number of cutting edges Z: 2

Tolerance nominal \varnothing : m7

recommended maximum drilling depth L_2 : 34.4 mm

Overall length L: 89 mm

Shank $\varnothing D_s$: 10 mm

Feed f in stainless steel $< 900 \text{ N/mm}^2$: 0.1 mm/rev.

Technical description

Number of cutting edges Z	2
Flute length L_c	47 mm

Shank tolerance	h6
Feed f in stainless steel < 900 N/mm ²	0.1 mm/rev.
Nominal Ø D _c	8.4 mm
Tolerance nominal Ø	m7
Shank Ø D _s	10 mm
Overall length L	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth L ₂	34.4 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	blue
Type of product	Jobber drill