



## Solid carbide high performance drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m7: 8,5 mm



### Order data

Order number	122396 8,5
GTIN	4045197423603
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  $L_c = L_2 + 1.5 \times D_c$ .

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  $L_2$ : 34.3 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

Shank tolerance	h6
Feed f in stainless steel $< 900 \text{ N/mm}^2$	0.1 mm/rev.
Flute length $L_c$	47 mm
Number of cutting edges Z	2

Nominal $\varnothing D_c$	8.5 mm
Tolerance nominal $\varnothing$	m7
Shank $\varnothing D_s$	10 mm
Overall length L	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	34.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
Colour ring	blue
Type of product	Jobber drill