



## Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 8,1 mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122404 8,1    |
| GTIN         | 4045197420497 |
| 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  $L_c = L_2 + 1.5 \times D_c$ .

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

Form **HB**: order with **No. 122406**.

Form **HE**: order with **No. 122408**.

Through-coolant: yes, with 25 bar

Standard: DIN 6537 K

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

Tolerance nominal Ø: m7

recommended maximum drilling depth  $L_2$ : 34.9 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.1 mm/rev.

### Technical description

|                           |       |
|---------------------------|-------|
| Number of cutting edges Z | 2     |
| Flute length $L_c$        | 47 mm |

|   |                   |
|---|-------------------|
| Nominal $\varnothing D_c$                         | 8.1 mm            |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.1 mm/rev.       |
| Shank tolerance                                   | h6                |
| Tolerance nominal $\varnothing$                   | m7                |
| Shank $\varnothing D_s$                           | 10 mm             |
| Overall length L                                  | 89 mm             |
| Standard  | DIN 6537 K        |
| recommended maximum drilling depth L <sub>2</sub> | 34.9 mm           |
| Coating   | TiAlN             |
| Tool material                                     | Solid carbide     |
| Drill depth up to                                 | 4xD               |
| Point angle                                       | 140 degrees       |
| Shank   | DIN 6535 HA to h6 |
| Through-coolant                                   | yes, with 25 bar  |
| Colour ring                                       | blue              |
| Type of product                                   | Jobber drill      |