



Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 8,5 mm



Order data

| | |
|--------------|---------------|
| Order number | 122404 8,5 |
| GTIN | 4045197420534 |
| 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 : 34.3 mm

Overall length L: 89 mm

Shank Ø D_s : 10 mm

Feed f in stainless steel < 900 N/mm²: 0.1 mm/rev.

Technical description

| | |
|--------------------|-------|
| Shank tolerance | h6 |
| Flute length L_c | 47 mm |

| | |
|---|-------------------|
| Feed f in stainless steel < 900 N/mm ² | 0.1 mm/rev. |
| 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 HA to h6 |
| Through-coolant | yes, with 25 bar |
| Colour ring | blue |
| Type of product | Jobber drill |