



Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC m7: 6,8 mm



Order data

Order number	122406 6,8
GTIN	4045197424501
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: yes, with 25 bar

Standard: DIN 6537 K

Tolerance nominal \varnothing : m7

Number of cutting edges Z: 2

Tolerance nominal \varnothing : m7

recommended maximum drilling depth L_2 : 23.8 mm

Overall length L: 79 mm

Shank $\varnothing D_s$: 8 mm

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

Technical description

Nominal $\varnothing D_c$	6.8 mm
Feed f in stainless steel $< 900 \text{ N/mm}^2$	0.1 mm/rev.
Shank tolerance	h6
Number of cutting edges Z	2

Flute length L_c	34 mm
Tolerance nominal \varnothing	m7
Shank $\varnothing D_s$	8 mm
Overall length L	79 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	23.8 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Colour ring	blue
Type of product	Jobber drill