



**Solid carbide high performance drill, Whistle-Notch shank DIN 6535 HE,  
TiAlN, Ø DC m7: 6,8 mm**



## Order data

Order number	122408 6,8
GTIN	4045197427755
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
Number of cutting edges Z	2
Flute length $L_c$	34 mm
Shank tolerance	h6

Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.1 mm/rev.
Tolerance nominal Ø	m7
Shank Ø D <sub>s</sub>	8 mm
Overall length L	79 mm
Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	23.8 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4×D
Point angle	140 degrees
Shank	DIN 6535 HE to h6
Through-coolant	yes, with 25 bar
Colour ring	blue
Type of product	Jobber drill