

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAIN, Ø DC h7: 8,2 mm



Order data Order number 123115 8,2 GTIN 4045197401908 Item class 11E

Description

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry.**

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

Straight major cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.

Advantage:

High process reliability and surface quality of the hole.

Recommendation:

Maximum drilling depth:

Flute length (see table) less $1.5 \times \text{nominal } \emptyset$.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Machining strategy: HPC

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth L₂: 94.7 mm

Overall length L: 150 mm

Shank Ø D_s: 10 mm

Feed f in stainless steel < 900 N/mm²: 0.15 mm/rev.

Technical description

Feed f in stainless steel < 900 N/mm² 0.15 mm/rev.

Number of cutting edges Z Nominal Ø D _c 8.2 mm Tolerance nominal Ø h7 Shank Ø D _s 10 mm Overall length L 150 mm Standard Manufacturer's standard recommended maximum drilling depth L₂ 94.7 mm Semi-Standard yes Coating TiAIN Tool material Solid carbide Drill depth up to 10×D Point angle Shank DIN 6535 HB to h6 Through-coolant Meriting depth Up to 10×D HPC Colour ring blue	Flute length L _c	107 mm
Nominal Ø D _c Tolerance nominal Ø Shank Ø D _s Overall length L Standard Standard Manufacturer's standard recommended maximum drilling depth L₂ Semi-Standard Yes Coating TiAlN Tool material Solid carbide Drill depth up to Point angle Shank DIN 6535 HB to h6 Through-coolant Machining strategy HPC Colour ring 10 mm 8.2 mm 8.2 mm 8.2 mm 8.2 mm 8.2 mm 8.2 mm 10 mm 10 mm 10 mm Standard Manufacturer's standard Yes Standard 150 mm Solid carbide 10×D 10×D Point angle 135 degrees HPC Colour ring	Shank tolerance	h6
Tolerance nominal Ø Shank Ø D _s 10 mm Overall length L 150 mm Standard Manufacturer's standard recommended maximum drilling depth L ₂ 94.7 mm Semi-Standard yes Coating TiAIN Tool material Solid carbide Drill depth up to 10×D Point angle Shank DIN 6535 HB to h6 Through-coolant Machining strategy HPC Colour ring blue	Number of cutting edges Z	2
Shank Ø D₃10 mmOverall length L150 mmStandardManufacturer's standardrecommended maximum drilling depth L₂94.7 mmSemi-StandardyesCoatingTiAINTool materialSolid carbideDrill depth up to10×DPoint angle135 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringblue	Nominal Ø D _c	8.2 mm
Overall length L150 mmStandardManufacturer's standardrecommended maximum drilling depth L₂94.7 mmSemi-StandardyesCoatingTiAINTool materialSolid carbideDrill depth up to10×DPoint angle135 degreesShankDIN 6535 HB to h6Through-coolantyes, with 25 barMachining strategyHPCColour ringblue	Tolerance nominal Ø	h7
Standard Manufacturer's standard recommended maximum drilling depth L2 94.7 mm Semi-Standard yes Coating TiAIN Tool material Solid carbide Drill depth up to 10×D Point angle Shank DIN 6535 HB to h6 Through-coolant Machining strategy HPC Colour ring Manufacturer's standard Manufacturer's standard P4.7 mm Solid carbide TiAIN Solid carbide DIN 6535 HB to h6 HPC	Shank Ø D _s	10 mm
recommended maximum drilling depth L2 Semi-Standard yes Coating TiAIN Tool material Solid carbide Drill depth up to Point angle Shank DIN 6535 HB to h6 Through-coolant Machining strategy Colour ring 94.7 mm 94.7 mm 94.7 mm 94.7 mm Finally Solid carbide 10×D 10×D 10×D HPC blue	Overall length L	150 mm
Semi-Standard yes Coating TiAIN Tool material Solid carbide Drill depth up to 10×D Point angle 135 degrees Shank DIN 6535 HB to h6 Through-coolant yes, with 25 bar Machining strategy HPC Colour ring blue	Standard	Manufacturer's standard
Coating TiAIN Tool material Solid carbide Drill depth up to 10×D Point angle 135 degrees Shank DIN 6535 HB to h6 Through-coolant yes, with 25 bar Machining strategy HPC Colour ring blue	recommended maximum drilling depth L ₂	94.7 mm
Tool material Drill depth up to Point angle Shank DIN 6535 HB to h6 Through-coolant Machining strategy Colour ring Solid carbide 10×D 10×D 135 degrees HB to h6 Yes, with 25 bar HPC blue	Semi-Standard	yes
Drill depth up to 10×D Point angle 135 degrees Shank DIN 6535 HB to h6 Through-coolant yes, with 25 bar Machining strategy HPC Colour ring blue	Coating	TiAlN
Point angle 135 degrees Shank DIN 6535 HB to h6 Through-coolant yes, with 25 bar Machining strategy HPC Colour ring blue	Tool material	Solid carbide
Shank DIN 6535 HB to h6 Through-coolant Machining strategy HPC Colour ring blue	Drill depth up to	10×D
Through-coolant yes, with 25 bar Machining strategy HPC Colour ring blue	Point angle	135 degrees
Machining strategy HPC Colour ring blue	Shank	DIN 6535 HB to h6
Colour ring blue	Through-coolant	yes, with 25 bar
J	Machining strategy	HPC
Type of product Jobber drill	Colour ring	blue
	Type of product	Jobber drill