



## Solid carbide high performance drill Weldon shank DIN 6535 HB, TiN, Ø DC h7: 7,8 mm



### Order data

Order number	123307 7,8
GTIN	4045197450050
Item class	12E

### Description

#### Version:

**Strong core and special point geometry** ensure the cutting chisel edges maintain **high self-centring accuracy**.

**Straight cutting edges** with slight edge hone and a special flute profile produce **short chips**.

#### Recommendation:

##### Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

##### Note:

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

For process reliability when using the 12×D deep-hole drill, an initial centre drilling with No. 121068 – 121130 or 3×D pilot drilling operation with No. 122736 is necessary.

Pilot drill required: yes, pilot drill

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 96.3 mm

Overall length L: 146 mm

Shank Ø  $D_s$ : 8 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.15 mm/rev.

### Technical description

Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.15 mm/rev.
Nominal Ø $D_c$	7.8 mm

Flute length $L_c$	108 mm
Number of cutting edges Z	2
Shank tolerance	h6
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	8 mm
Overall length L	146 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	96.3 mm
Coating	TiN
Tool material	Solid carbide
Drill depth up to	12×D
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Pilot drill required	yes, pilot drill
Colour ring	green
Type of product	Jobber drill