


**Solid carbide drill plain shank DIN 6535 HA, AlTiN-Si, Ø DC m7 (mm or inch): 8**

**Order data**

Order number	122771 8
GTIN	4062406147877
Item class	12F

**Description**
**Version:**

Tool specially matched to drilling holes without through-coolant. **Concave major cutting edges** and a **special flute profile** ensure a good chip evacuation. The sturdy cutter geometry with **special point geometry** and 4 cutting edges ensures drilling with good process reliability. A wide range of applications in steel materials thanks to a combination of tough ultra-fine grain carbide and extremely **wear-resistant** and **heat-resistant coating**.

**Note:**

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122772**.

Form **HE**: order with **No. 122773**.

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

Through-coolant: no

Standard: DIN 6537

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 41 mm

Tolerance nominal Ø: m7

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.18 mm/rev.

**Technical description**

Flute length $L_c$	53 mm
recommended maximum drilling depth $L_2$	41 mm

Feed f in steel < 900 N/mm <sup>2</sup>	0.18 mm/rev.
Tolerance nominal Ø	m7
Overall length L	91 mm
Number of cutting edges Z	2
Nominal Ø D <sub>c</sub>	8 mm
Standard	DIN 6537
Shank Ø D <sub>s</sub>	8 mm
Coating	AlTiN-Si
Tool material	Solid carbide
Version	6×D
Point angle	140 °
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	green
Type of product	Jobber drill

## User data

	Suitability	V <sub>c</sub>	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	200 m/min	N
Alu > 10% Si	suitable only under restricted conditions	160 m/min	N
Steel < 500 N/mm <sup>2</sup>	suitable	110 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable only under restricted conditions	60 m/min	P
GG	suitable	90 m/min	K

GGG	suitable only under restricted conditions	60 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		