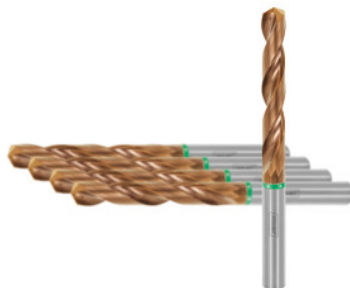




## Solid carbide drill plain shank DIN 6535 HA, AlTiN-Si, Ø DC m7 (mm or inch): 3,5



### Order data

|              |               |
|--------------|---------------|
| Order number | GG2771 3,5    |
| GTIN         | 4062406989316 |
| Item class   | GGN           |

### 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**.

**Same as No. 122771.**

**Form HB available with No. GG2772 at the same price.**

#### Note:

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

### Technical description

|  |              |
|--|--------------|
| Overall length L                         | 66 mm        |
| Flute length $L_c$                       | 28 mm        |
| recommended maximum drilling depth $L_2$ | 22.8 mm      |
| Feed f in steel < 900 N/mm <sup>2</sup>  | 0.16 mm/rev. |

|                           |                   |
|---------------------------|-------------------|
| Number of cutting edges Z | 2                 |
| Tolerance nominal Ø       | m7                |
| Shank Ø D <sub>s</sub>    | 6 mm              |
| Nominal Ø D <sub>c</sub>  | 3.5 mm            |
| Standard                  | DIN 6537          |
| Contents                  | 5                 |
| Coating                   | AlTiN-Si          |
| Tool material             | Solid carbide     |
| Version                   | 6×D               |
| Point angle               | 140 degrees       |
| 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 |

**Accessories**

|   |            |
|---|------------|
| Solid carbide drill plain shankDIN 6535 HA Ø DC m7 (mm or inch) 3,5 | 122771 3,5 |
|---|------------|