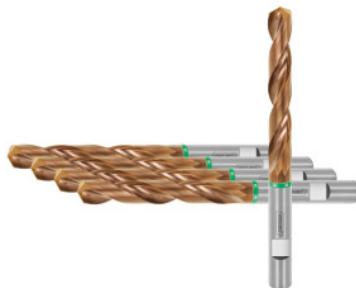




Solid carbide drill plain shank DIN 6535 HB, AlTiN-Si, Ø DC m7 (mm or inch): 6,8



Order data

Order number	GG2772 6,8
GTIN	4062406989866
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. 122772.

Note:

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

Technical description

Tolerance nominal Ø	m7
Nominal Ø D_c	6.8 mm
recommended maximum drilling depth L_2	42.8 mm
Shank Ø D_s	8 mm
Overall length L	91 mm

Standard	DIN 6537
Feed f in steel < 900 N/mm ²	0.18 mm/rev.
Flute length L_c	53 mm
Number of cutting edges Z	2
Contents	5
Coating	AlTiN-Si
Tool material	Solid carbide
Version	6xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	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 ²	suitable	110 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 N/mm ²	suitable	80 m/min	P
Steel < 1100 N/mm ²	suitable	70 m/min	P
Steel < 1400 N/mm ²	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) 6,8

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