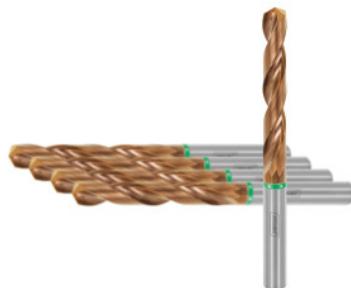




## Solid carbide drill plain shank DIN 6535 HA, AlTiN-Si, Ø DC m7 (mm or inch): 15



### Order data

Order number	GG2771 15
GTIN	4062406989637
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

Shank Ø $D_s$	16 mm
Standard	DIN 6537
Nominal Ø $D_c$	15 mm
Tolerance nominal Ø	m7

Flute length $L_c$	83 mm
Number of cutting edges $Z$	2
Overall length $L$	133 mm
Feed $f$ in steel < 900 N/mm <sup>2</sup>	0.26 mm/rev.
recommended maximum drilling depth $L_2$	60.5 mm
Contents	5
Coating	AlTiN-Si
Tool material	Solid carbide
Version	6xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	green
Type of product	Jobber drill

## User data

	<b>Suitability</b>	<b><math>V_c</math></b>	<b>ISO code</b>
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

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## Accessories

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122771 15