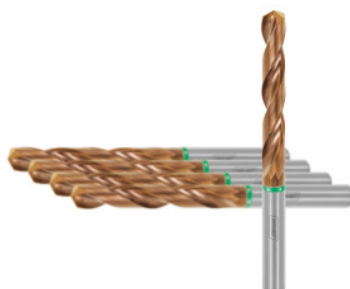


**Solid carbide drill plain shank DIN 6535 HA, AlTiN-Si, Ø DC m7 (mm or inch):
15****Order data**

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 ²	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

	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) 15

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