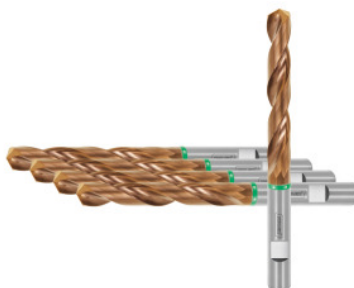


**Solid carbide drill plain shank DIN 6535 HB, AlTiN-Si, Ø DC m7 (mm or inch):  
13****Order data**

Order number	GG2772 13
GTIN	4062406989996
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**

Shank Ø $D_s$	14 mm
recommended maximum drilling depth $L_2$	57.5 mm
Flute length $L_c$	77 mm
Overall length $L$	124 mm
Tolerance nominal Ø	m7

Feed f in steel < 900 N/mm <sup>2</sup>	0.26 mm/rev.
Number of cutting edges Z	2
Standard	DIN 6537
Nominal Ø D <sub>c</sub>	13 mm
Contents	5
Coating	AlTiN-Si
Tool material	Solid carbide
Version	6×D
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 <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) 13	122771 13
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