



## Solid carbide high performance drill Whistle-Notch shank DIN 6535 HE, TiN, Ø DC h7: 6,9mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122640 6,9    |
| GTIN         | 4045197395429 |
| Item class   | 12E           |

### Description

#### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

**Straight major cutting edges** with slightly honed edges and special flute profile produce **short chips**.

#### Note:

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

**NEW GENERATION AVAILABLE!**

**Recommended successor product is No. 122778.**

### Technical description

|  |              |
|--|--------------|
| Nominal Ø $D_c$                          | 6.9 mm       |
| Shank tolerance                          | h6           |
| Flute length $L_c$                       | 53 mm        |
| Feed $f$ in steel $< 900 \text{ N/mm}^2$ | 0.18 mm/rev. |
| Number of cutting edges $Z$              | 2            |
| Tolerance nominal Ø                      | h7           |
| Shank Ø $D_s$                            | 8 mm         |
| Overall length $L$                       | 91 mm        |
| Standard                                 | DIN 6537     |

|  |                   |
|--|-------------------|
| recommended maximum drilling depth $L_2$ | 42.7 mm           |
| Coating                                  | TiN               |
| Tool material                            | Solid carbide     |
| Version                                  | 6×D               |
| Point angle                              | 140 degrees       |
| Shank                                    | DIN 6535 HE to h6 |
| Through-coolant                          | yes, with 25 bar  |
| Colour ring                              | green             |
| Type of product                          | Jobber drill      |

### User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|---|-----------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 240 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 only under restricted conditions | 65 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 30 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 35 m/min  | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 30 m/min  | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable                                  | 30 m/min  | S        |
| Uni                            | suitable                                  |           |          |
| wet maximum                    | suitable                                  |           |          |
| wet minimum                    | suitable                                  |           |          |
| Air                            | suitable only under restricted conditions |           |          |

