



## Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiN, Ø DC h7: 15mm



### Order data

Order number	122345 15
GTIN	4045197388483
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  $L_c = L_2 + 1.5 \times D_c$ .

### Technical description

Nominal Ø $D_c$	15 mm
Flute length $L_c$	65 mm
Number of cutting edges $Z$	2
Shank tolerance	h6
Feed $f$ in steel < 900 N/mm <sup>2</sup>	0.26 mm/rev.
Tolerance nominal Ø	h7
Shank Ø $D_s$	16 mm
Overall length $L$	115 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	42.5 mm
Coating	TiN

Tool material	Solid carbide
Version	4xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Semi-Standard	yes
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	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	35 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		