



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



### Order data

|              |               |
|--------------|---------------|
| Order number | 123106 15     |
| GTIN         | 4045197448323 |
| 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. 123103.**

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Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 123107**.

Form **HE**: order with **No. 123108**.

### Technical description

|  |              |
|--|--------------|
| Flute length $L_c$                         | 152 mm       |
| Number of cutting edges $Z$                | 2            |
| Shank tolerance                            | h6           |
| Nominal $\varnothing D_c$                  | 15 mm        |
| Feed $f$ in steel < 1100 N/mm <sup>2</sup> | 0.26 mm/rev. |
| Tolerance nominal $\varnothing$            | h7           |
| Shank $\varnothing D_s$                    | 16 mm        |

|   |                         |
|---|-------------------------|
| Overall length L                                  | 203 mm                  |
| Standard  | Manufacturer's standard |
| recommended maximum drilling depth L <sub>2</sub> | 129.5 mm                |
| Coating   | TiN                     |
| Tool material                                     | Solid carbide           |
| Version   | 8xD                     |
| Point angle                                       | 135 degrees             |
| Shank   | DIN 6535 HA to h6       |
| Through-coolant                                   | yes, with 25 bar        |
| 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 | 175 m/min      | N        |
| Alu > 10% Si                   | suitable only under restricted conditions | 135 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable only under restricted conditions | 105 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 85 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 75 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 45 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 30 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 35 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 30 m/min       | M        |
| GG(G)                          | suitable                                  | 65 m/min       | K        |
| Uni                            | suitable                                  |                |          |

wet maximum

suitable