



## Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 3mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122664 3      |
| GTIN         | 4045197421050 |
| 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  $L_c = L_2 + 1.5 \times D_c$ .

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

Form **HB**: order with **No. 122666**.

Form **HE**: order with **No. 122668**.

Through-coolant: yes, with 25 bar

Standard: DIN 6537

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 23.5 mm

Tolerance nominal Ø: m7

Overall length L: 66 mm

Shank Ø  $D_s$ : 6 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.07 mm/rev.

### Technical description

|                           |      |
|---------------------------|------|
| Shank tolerance           | h6   |
| Nominal Ø $D_c$           | 3 mm |
| Number of cutting edges Z | 2    |

|   |                   |
|---|-------------------|
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.07 mm/rev.      |
| Flute length L <sub>c</sub>                       | 28 mm             |
| Tolerance nominal Ø                               | m7                |
| Shank Ø D <sub>s</sub>                            | 6 mm              |
| Overall length L                                  | 66 mm             |
| Standard  | DIN 6537          |
| recommended maximum drilling depth L <sub>2</sub> | 23.5 mm           |
| Coating   | TiAlN             |
| Tool material                                     | Solid carbide     |
| Version   | 6×D               |
| Point angle                                       | 140 °             |
| Shank   | DIN 6535 HA to h6 |
| Through-coolant                                   | yes, with 25 bar  |
| Colour ring                                       | blue              |
| Type of product                                   | Jobber drill      |

## User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 140 m/min      | N        |
| Alu > 10% Si                   | suitable only under restricted conditions | 120 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                                  | 60 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                                  | 45 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 40 m/min       | M        |

|                            |   |          |   |
|----------------------------|---|----------|---|
| Ti > 850 N/mm <sup>2</sup> | suitable                                  | 30 m/min | S |
| GG                         | suitable only under restricted conditions | 70 m/min | K |
| wet maximum                | suitable                                  |          |   |
| wet minimum                | suitable                                  |          |   |
| Air                        | suitable                                  |          |   |