



Solid carbide high performance drill, Whistle-Notch shank DIN 6535 HE, TiN, Ø DC h7: 3,9mm



Order data

| | |
|--------------|---------------|
| Order number | 122355 3,9 |
| GTIN | 4045197392046 |
| 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. 122508.

Technical description

| | |
|--|--------------|
| Shank tolerance | h6 |
| Nominal Ø D_c | 3.9 mm |
| Flute length L_c | 24 mm |
| Number of cutting edges Z | 2 |
| Feed f in steel < 900 N/mm ² | 0.11 mm/rev. |
| Tolerance nominal Ø | h7 |
| Shank Ø D_s | 6 mm |
| Overall length L | 66 mm |
| Standard | DIN 6537 K |
| recommended maximum drilling depth L_2 | 18.2 mm |

| | |
|-----------------|-------------------|
| Coating | TiN |
| Tool material | Solid carbide |
| Version | 4xD |
| 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 ² | suitable | 110 m/min | P |
| Steel < 750 N/mm ² | suitable | 90 m/min | P |
| Steel < 900 N/mm ² | suitable | 80 m/min | P |
| Steel < 1100 N/mm ² | suitable only under restricted conditions | 65 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 35 m/min | P |
| INOX < 900 N/mm ² | suitable | 35 m/min | M |
| INOX > 900 N/mm ² | suitable | 30 m/min | M |
| Ti > 850 N/mm ² | suitable | 30 m/min | S |
| Uni | suitable | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| Air | suitable only under restricted conditions | | |