



## Solid carbide drill plain shank DIN 6535 HA, AlTiN-Si, Ø DC m7 (mm or inch): 4,2



### Order data

|              |               |
|--------------|---------------|
| Order number | 122771 4,2    |
| GTIN         | 4062406147426 |
| Item class   | 12F           |

### Description

#### Version:

Tool specially matched to drilling holes without through-coolant. **Concave major cutting edges** and a **special flute profile** ensure a good chip evacuation. The sturdy cutter geometry with **special point geometry** and 4 cutting edges ensures drilling with good process reliability. A wide range of applications in steel materials thanks to a combination of tough ultra-fine grain carbide and extremely **wear-resistant** and **heat-resistant coating**.

#### Note:

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

Form **HB**: order with **No. 122772**.

Form **HE**: order with **No. 122773**.

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

Through-coolant: no

Standard: DIN 6537

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 29.7 mm

Tolerance nominal Ø: m7

Overall length L: 74 mm

Shank Ø  $D_s$ : 6 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.16 mm/rev.

### Technical description

|                           |          |
|---------------------------|----------|
| Number of cutting edges Z | 2        |
| Standard                  | DIN 6537 |

|  |                   |
|--|-------------------|
| Shank $\varnothing D_s$                  | 6 mm              |
| Overall length L                         | 74 mm             |
| Flute length $L_c$                       | 36 mm             |
| Nominal $\varnothing D_c$                | 4.2 mm            |
| recommended maximum drilling depth $L_2$ | 29.7 mm           |
| Feed f in steel < 900 N/mm <sup>2</sup>  | 0.16 mm/rev.      |
| Tolerance nominal $\varnothing$          | m7                |
| Coating                                  | AlTiN-Si          |
| Tool material                            | Solid carbide     |
| Version                                  | 6xD               |
| Point angle                              | 140°              |
| Shank                                    | DIN 6535 HA to h6 |
| Through-coolant                          | no                |
| Colour ring                              | green             |
| Type of product                          | Jobber drill      |

## User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|---|-----------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 200 m/min | N        |
| Alu > 10% Si                   | suitable only under restricted conditions | 160 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                                  | 70 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 60 m/min  | P        |
| GG                             | suitable                                  | 90 m/min  | K        |

|             |   |          |   |
|-------------|---|----------|---|
| GGG         | suitable only under restricted conditions | 60 m/min | K |
| Uni         | suitable                                  |          |   |
| wet maximum | suitable                                  |          |   |
| dry         | suitable only under restricted conditions |          |   |