



Solid carbide drill plain shank DIN 6535 HA, AlTiN-Si, Ø DC m7 (mm or inch): 3,8



Order data

| | |
|--------------|---------------|
| Order number | 122771 3,8 |
| GTIN | 4062406147372 |
| 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 : 30.3 mm

Tolerance nominal Ø: m7

Overall length L: 74 mm

Shank Ø D_s : 6 mm

Feed f in steel < 900 N/mm²: 0.16 mm/rev.

Technical description

| | |
|--|--------------|
| Feed f in steel < 900 N/mm ² | 0.16 mm/rev. |
| recommended maximum drilling depth L_2 | 30.3 mm |

| | |
|---------------------------------|-------------------|
| Shank $\varnothing D_s$ | 6 mm |
| Overall length L | 74 mm |
| Nominal $\varnothing D_c$ | 3.8 mm |
| Standard | DIN 6537 |
| Number of cutting edges Z | 2 |
| Flute length L_c | 36 mm |
| 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 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 | 70 m/min | P |
| Steel < 1400 N/mm ² | 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 | | |