


**Solid carbide drill plain shank DIN 6535 HB, TiAlN, Ø DC m7 (mm or inch): 14,5**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122772 14,5   |
| GTIN         | 4062406149871 |
| 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:**

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  $L_2$ : 61.25 mm

Tolerance nominal Ø: m7

Overall length L: 133 mm

Shank Ø  $D_s$ : 16 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.26 mm/rev.

**Technical description**

|   |              |
|---|--------------|
| Standard                                | DIN 6537     |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.26 mm/rev. |
| Shank Ø $D_s$                           | 16 mm        |
| Nominal Ø $D_c$                         | 14.5 mm      |

|  |                   |
|--|-------------------|
| Tolerance nominal $\varnothing$          | m7                |
| Number of cutting edges Z                | 2                 |
| recommended maximum drilling depth $L_2$ | 61.25 mm          |
| Flute length $L_c$                       | 83 mm             |
| Overall length L                         | 133 mm            |
| Coating                                  | TiAlN             |
| Tool material                            | Solid carbide     |
| Version                                  | 6xD               |
| Point angle                              | 140°              |
| Shank                                    | DIN 6535 HB 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 |