



Solid carbide high performance drill Whistle-Notch shank DIN 6535 HE, TiN, Ø DC h7: 12mm



Order data

| | |
|--------------|---------------|
| Order number | 123108 12 |
| GTIN | 4045197450852 |
| 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. 123109.

Technical description

| | |
|---|-------------------------|
| Feed f in steel $< 1100 \text{ N/mm}^2$ | 0.26 mm/rev. |
| Flute length L_c | 114 mm |
| Shank tolerance | h6 |
| Nominal $\varnothing D_c$ | 12 mm |
| Number of cutting edges Z | 2 |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 12 mm |
| Overall length L | 162 mm |
| Standard | Manufacturer's standard |
| recommended maximum drilling depth L_2 | 96 mm |

| | |
|-----------------|-------------------|
| Coating | TiN |
| Tool material | Solid carbide |
| Version | 8xD |
| Point angle | 135 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 | 175 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 135 m/min | N |
| Steel < 500 N/mm ² | suitable only under restricted conditions | 105 m/min | P |
| Steel < 750 N/mm ² | suitable | 85 m/min | P |
| Steel < 900 N/mm ² | suitable | 75 m/min | P |
| Steel < 1100 N/mm ² | suitable | 45 m/min | P |
| Steel < 1400 N/mm ² | suitable | 30 m/min | P |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 35 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 30 m/min | M |
| GG(G) | suitable | 65 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |