



## Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 4,2mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122394 4,2    |
| GTIN         | 4045197419026 |
| 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  $L_c = L_2 + 1.5 \times D_c$ .

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

Form **HB**: order with **No. 122396**.

Form **HE**: order with **No. 122398**.

Through-coolant: no

Standard: DIN 6537 K

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth  $L_2$ : 17.7 mm

Tolerance nominal Ø: m7

Overall length L: 66 mm

Shank Ø  $D_s$ : 6 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.07 mm/rev.

### Technical description

|   |              |
|---|--------------|
| Nominal Ø $D_c$                                   | 4.2 mm       |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.07 mm/rev. |
| Number of cutting edges Z                         | 2            |

|  |                   |
|--|-------------------|
| Flute length $L_c$                       | 24 mm             |
| Shank tolerance                          | h6                |
| Tolerance nominal $\varnothing$          | m7                |
| Shank $\varnothing D_s$                  | 6 mm              |
| Overall length L                         | 66 mm             |
| Standard                                 | DIN 6537 K        |
| recommended maximum drilling depth $L_2$ | 17.7 mm           |
| Coating                                  | TiAlN             |
| Tool material                            | Solid carbide     |
| Version                                  | 4xD               |
| Point angle                              | 140°              |
| Shank                                    | DIN 6535 HA to h6 |
| Through-coolant                          | no                |
| Colour ring                              | blue              |
| Type of product                          | Jobber drill      |

## User data

|                                | Suitability                               | $V_c$     | ISO code |
|--------------------------------|---|-----------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 140 m/min | N        |
| Alu > 10% Si                   | suitable only under restricted conditions | 120 m/min | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 80 m/min  | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 75 m/min  | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 65 m/min  | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 60 m/min  | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 35 m/min  | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 35 m/min  | M        |

|                              |   |          |   |
|------------------------------|---|----------|---|
| INOX > 900 N/mm <sup>2</sup> | suitable                                  | 30 m/min | M |
| GG                           | suitable only under restricted conditions | 70 m/min | K |
| wet maximum                  | suitable                                  |          |   |
| wet minimum                  | suitable only under restricted conditions |          |   |