



## Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 12mm



### Order data

Order number	122394 12
GTIN	4045197419682
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  $L_2$ : 37 mm

Tolerance nominal Ø: m7

Overall length L: 102 mm

Shank Ø  $D_s$ : 12 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.15 mm/rev.

### Technical description

Nominal Ø $D_c$	12 mm
Shank tolerance	h6
Number of cutting edges Z	2

Flute length $L_c$	55 mm
Feed $f$ in stainless steel $< 900 \text{ N/mm}^2$	0.15 mm/rev.
Tolerance nominal $\varnothing$	m7
Shank $\varnothing D_s$	12 mm
Overall length $L$	102 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	37 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 $> 10\% \text{ Si}$	suitable only under restricted conditions	120 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	80 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	75 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	65 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable only under restricted conditions	60 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable only under restricted conditions	35 m/min	P
INOX $< 900 \text{ N/mm}^2$	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		