



Solid carbide high performance drill plain shank DIN 6535 HA, TiN, Ø DC h7: 6,8mm



Order data

Order number	123306 6,8
GTIN	4045197448590
Item class	12E

Description

Version:

Strong core and special point geometry –ensure the cutting chisel edges maintain **high self-centring accuracy**.

Straight cutting edges with slight edge hone and a special flute profile produce **short chips**.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

For process reliability when using the 12xD drill, an initial centre drilling with NC spotting drills No. 121068 - 121130 or HOLEX Pro Steel No. 122501 is necessary.

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

Form **HB**: order with **No. 123307**.

Form **HE**: order with **No. 123308**.

NEW GENERATION AVAILABLE!

Recommended successor product is No. 123303.

Technical description

Nominal Ø D_c	6.8 mm
Feed f in steel < 1100 N/mm ²	0.15 mm/rev.
Flute length L_c	108 mm
Number of cutting edges Z	2
Shank tolerance	h6
Tolerance nominal Ø	h7
Shank Ø D_s	8 mm

Overall length L	146 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L ₂	97.8 mm
Coating	TiN
Tool material	Solid carbide
Version	12xD
Point angle	135 degrees
Shank	DIN 6535 HA 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