



## Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø h7: 17,5 mm



### Order data

Order number	123301 17,5
GTIN	4045197452641
Item class	11E

### Description

#### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

**Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

#### Advantage:

**High process reliability and surface quality of the hole.**

#### Recommendation:

##### Maximum drilling depth:

flute length (see table) less 1.5×nominal Ø.

#### Note:

For process reliability when using the 12×D drill, an initial centre drilling with NC spotting drills No. 121068 – 121130 is necessary.

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

Form **HB**: order with **No. 123302**.

Form **HE**: order with **No. 123301 + 129100HE**.

#### **NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 123225 and 123235.**

Machining strategy: HPC

Norm: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

Flute length: 234 mm

Overall length  $L_{tot}$ : 285 mm

Shank Ø: 18 mm

Feed  $f$  in steel < 1100 N/mm<sup>2</sup>: 0.28 mm/rev.

## Technical description

Nominal Ø	17.5 mm
Shank tolerance	h6
Flute length	234 mm
Number of cutting edges Z	2
Feed f in steel < 1100 N/mm <sup>2</sup>	0.28 mm/rev.
Tolerance nominal Ø	h7
Shank Ø	18 mm
Overall length L <sub>tot</sub>	285 mm
Norm	Manufacturer's standard
recommended maximum drilling depth	207.8 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12xD
Point angle	135 degrees
Skaft	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	green

## Services

Shank grinding Type HE	129100 HE
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