



Solid carbide high performance drill Weldon shank DIN 6535 HB, TiN, Ø DC h7: 7mm



Order data

| | |
|--------------|---------------|
| Order number | 123307 7 |
| GTIN | 4045197450036 |
| 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 deep-hole drill, an initial centre drilling with No. 121068 – 121130 or 3xD pilot drilling operation with No. 122736 is necessary.

Technical description

| | |
|--|-------------------------|
| Nominal Ø D_c | 7 mm |
| Feed f in steel < 1100 N/mm ² | 0.15 mm/rev. |
| Number of cutting edges Z | 2 |
| Shank tolerance | h6 |
| Flute length L_c | 108 mm |
| 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 | 97.5 mm |

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|----------------------|-------------------|
| Coating | TiN |
| Tool material | Solid carbide |
| Version | 12xD |
| Point angle | 135 degrees |
| Shank | DIN 6535 HB to h6 |
| Through-coolant | yes, with 25 bar |
| Pilot drill required | yes, pilot drill |
| 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 | | |

