



Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 3,9mm



Order data

Order number	122404 3,9
GTIN	4045197420077
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. 122406**.

Form **HE**: order with **No. 122408**.

Through-coolant: yes, with 25 bar

Standard: DIN 6537 K

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 18.2 mm

Tolerance nominal Ø: m7

Overall length L: 66 mm

Shank Ø D_s : 6 mm

Feed f in stainless steel < 900 N/mm²: 0.07 mm/rev.

Technical description

Number of cutting edges Z	2
Nominal Ø D_c	3.9 mm
Feed f in stainless steel < 900 N/mm ²	0.07 mm/rev.

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	18.2 mm
Coating	TiAlN
Tool material	Solid carbide
Version	4xD
Point angle	140°
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
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 ²	suitable	110 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 N/mm ²	suitable	80 m/min	P
Steel < 1100 N/mm ²	suitable	60 m/min	P
Steel < 1400 N/mm ²	suitable only under restricted conditions	35 m/min	P
INOX < 900 N/mm ²	suitable	45 m/min	M
INOX > 900 N/mm ²	suitable	40 m/min	M

Ti > 850 N/mm ²	suitable	30 m/min	S
GG	suitable only under restricted conditions	70 m/min	K
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		