



Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 6,5mm



Order data

| | |
|--------------|---------------|
| Order number | 122404 6,5 |
| GTIN | 4045197420336 |
| 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 : 24.3 mm

Tolerance nominal Ø: m7

Overall length L: 79 mm

Shank Ø D_s : 8 mm

Feed f in stainless steel < 900 N/mm²: 0.1 mm/rev.

Technical description

| | |
|---|-------------|
| Feed f in stainless steel < 900 N/mm ² | 0.1 mm/rev. |
| Flute length L_c | 34 mm |
| Number of cutting edges Z | 2 |

| | |
|--|-------------------|
| Nominal $\varnothing D_c$ | 6.5 mm |
| Shank tolerance | h6 |
| Tolerance nominal \varnothing | m7 |
| Shank $\varnothing D_s$ | 8 mm |
| Overall length L | 79 mm |
| Standard | DIN 6537 K |
| recommended maximum drilling depth L_2 | 24.3 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 | | |