



Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø h7: 13,8 mm



Order data

Order number	122500 13,8
GTIN	4045197050748
Item class	11E

Description

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

Recommendation:

Maximum drilling depth:

clamping slot length (see table) less 1.5×nominal Ø.

Note:

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

Form **HB**: order with **No. 122445/122505**.

Form **HE**: order with **No. 122440/122500** and **129100HE**.

NEW GENERATION AVAILABLE!

Recommended successor products are No. 122415; 122425 and 122435.

Machining strategy: HPC

Norm: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

Flute length: 60 mm

Overall length L_{tot} : 107 mm

Shank Ø: 14 mm

Feed f in steel < 1100 N/mm²: 0.32 mm/rev.

Technical description

Feed f in steel < 1100 N/mm ²	0.32 mm/rev.
Shank tolerance	h6

Flute length	60 mm
Nominal Ø	13.8 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Shank Ø	14 mm
Overall length L _{tot}	107 mm
Norm	DIN 6537 K
recommended maximum drilling depth	39.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 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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