



## Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 13,5mm



### Order data

Order number	122404 13,5
GTIN	4045197420824
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  $L_2$ : 39.8 mm

Tolerance nominal Ø: m7

Overall length L: 107 mm

Shank Ø  $D_s$ : 14 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.15 mm/rev.

### Technical description

Shank tolerance	h6
Number of cutting edges Z	2
Nominal Ø $D_c$	13.5 mm

Flute length $L_c$	60 mm
Feed $f$ in stainless steel $< 900 \text{ N/mm}^2$	0.15 mm/rev.
Tolerance nominal $\varnothing$	m7
Shank $\varnothing D_s$	14 mm
Overall length $L$	107 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	39.8 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 $> 10\% \text{ Si}$	suitable only under restricted conditions	120 m/min	N
Steel $< 500 \text{ N/mm}^2$	suitable	110 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	90 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	80 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	60 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable only under restricted conditions	35 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	45 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	40 m/min	M

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