



**Solid carbide high performance drill, plain shank DIN 6535 HA, TiN, Ø DC h7 (mm or inch): 9,4**



## Order data

|              |               |
|--------------|---------------|
| Order number | 122310 9,4    |
| GTIN         | 4045197043986 |
| 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  $L_c = L_2 + 1.5 \times D_c$ .

**NEW GENERATION AVAILABLE!**

**Recommended successor product is No. 122501.**

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

**Form HB:** order with **No. 122315**.

**Form HE:** order with **No. 122320**.

## Technical description

|   |              |
|---|--------------|
| Flute length $L_c$                      | 47 mm        |
| Shank tolerance                         | h6           |
| Number of cutting edges Z               | 2            |
| Nominal $\varnothing D_c$               | 9.4 mm       |
| Feed f in steel < 900 N/mm <sup>2</sup> | 0.22 mm/rev. |
| Tolerance nominal $\varnothing$         | h7           |
| Shank $\varnothing D_s$                 | 10 mm        |
| Overall length L                        | 89 mm        |

|   |                   |
|---|-------------------|
| Standard  | DIN 6537 K        |
| recommended maximum drilling depth L <sub>2</sub> | 32.9 mm           |
| Coating   | TiN               |
| Tool material                                     | Solid carbide     |
| Version   | 4×D               |
| Point angle                                       | 140 degrees       |
| Shank   | DIN 6535 HA to h6 |
| Through-coolant                                   | no                |
| Semi-Standard                                     | yes               |
| Colour ring                                       | without           |
| Type of product                                   | Jobber drill      |

## User data

|                                | Suitability                               | V <sub>c</sub> | 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 <sup>2</sup>  | suitable                                  | 80 m/min       | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 75 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 65 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 60 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 35 m/min       | P        |
| GG(G)                          | suitable only under restricted conditions | 70 m/min       | K        |
| wet maximum                    | suitable                                  |                |          |
| dry                            | suitable                                  |                |          |

