



**Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiN, Ø DC  
h7: 13,8mm**



## Order data

Order number	122315 13,8
GTIN	4045197387356
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  $L_c = L_2 + 1.5 \times D_c$ .

## Technical description

Number of cutting edges Z	2
Nominal Ø D <sub>c</sub>	13.8 mm
Shank tolerance	h6
Flute length L <sub>c</sub>	60 mm
Feed f in steel < 900 N/mm <sup>2</sup>	0.26 mm/rev.
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	14 mm
Overall length L	107 mm
Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	39.3 mm
Coating	TiN

Tool material	Solid carbide
Version	4xD
Point angle	140 degrees
Shank	DIN 6535 HB 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		