



## Solid carbide high performance drill, Whistle-Notch shank DIN 6535 HE, TiN, Ø DC h7: 4,8mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122320 4,8    |
| GTIN         | 4045197389565 |
| 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. 122503.**

### Technical description

|   |              |
|---|--------------|
| Nominal Ø $D_c$                           | 4.8 mm       |
| Flute length $L_c$                        | 28 mm        |
| Shank tolerance                           | h6           |
| Feed $f$ in steel < 900 N/mm <sup>2</sup> | 0.14 mm/rev. |
| Number of cutting edges $Z$               | 2            |
| Tolerance nominal Ø                       | h7           |
| Shank Ø $D_s$                             | 6 mm         |
| Overall length $L$                        | 66 mm        |
| Standard                                  | DIN 6537 K   |
| recommended maximum drilling depth $L_2$  | 20.8 mm      |

|                 |                   |
|-----------------|-------------------|
| Coating         | TiN               |
| Tool material   | Solid carbide     |
| Version         | 4xD               |
| Point angle     | 140 degrees       |
| Shank           | DIN 6535 HE to h6 |
| Through-coolant | no                |
| 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                                  |                |          |