



**Solid carbide high performance drill, Whistle-Notch shank DIN 6535 HE, TiN,  
Ø DC h7: 12,8mm**



## Order data

Order number	122320 12,8
GTIN	4045197391209
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

Flute length $L_c$	60 mm
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.26 mm/rev.
Nominal $\varnothing D_c$	12.8 mm
Number of cutting edges $Z$	2
Shank tolerance	h6
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	14 mm
Overall length $L$	107 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	40.8 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		