



## Solid carbide high performance drill plain shank DIN 6535 HA, TiN, Ø DC h7 (mm or inch): 1,8



### Order data

|              |               |
|--------------|---------------|
| Order number | 122630 1,8    |
| GTIN         | 4045197263025 |
| 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. 122635**.

Form **HE**: order with **No. 122640**.

**NEW GENERATION AVAILABLE!**

**Recommended successor product is No. 122776.**

### Technical description

|   |              |
|---|--------------|
| Nominal Ø $D_c$                           | 1.8 mm       |
| Flute length $L_c$                        | 16 mm        |
| Feed $f$ in steel < 900 N/mm <sup>2</sup> | 0.06 mm/rev. |
| Shank tolerance                           | h6           |
| Number of cutting edges $Z$               | 2            |
| Tolerance nominal Ø                       | h7           |
| Shank Ø $D_s$                             | 4 mm         |

|   |                   |
|---|-------------------|
| Overall length L                                  | 55 mm             |
| Standard  | DIN 6537          |
| recommended maximum drilling depth L <sub>2</sub> | 13.3 mm           |
| Coating   | TiN               |
| Tool material                                     | Solid carbide     |
| Version   | 6×D               |
| Point angle                                       | 140 degrees       |
| Shank   | DIN 6535 HA to h6 |
| Through-coolant                                   | yes, with 25 bar  |
| Semi-Standard                                     | yes               |
| Colour ring                                       | green             |
| Type of product                                   | Jobber drill      |

## User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 240 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 110 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 90 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 80 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable only under restricted conditions | 65 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 30 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 35 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 30 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable                                  | 30 m/min       | S        |
| Uni                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |
| wet minimum                    | suitable                                  |                |          |

Air

suitable only under  
restricted conditions