



Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø h7: 9,4 mm

Order data

Order number	122440 9,4
GTIN	4045197048547
Item class	11E

Description

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

Recommendation:

Maximum drilling depth:

clamping slot length (see table) less 1.5×nominal Ø.

Note:

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

Form **HB**: order with **No. 122445/122505**.

Form **HE**: order with **No. 122440/122500** and **129100HE**.

NEW GENERATION AVAILABLE!

Recommended successor products are No. 122415; 122425 and 122435.

Tool material: Solid carbide

Drill depth up to: 4×D

Point angle: 140 degrees

Schaft: DIN 6535 HA to h6

Through-coolant: false

Machining strategy: HPC

Norm: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

Flute length: 47 mm

Overall length L_{tot} : 89 mm

Shank Ø: 10 mm

Feed f in steel < 1100 N/mm²: 0.27 mm/rev.

Technical description

Point angle	140 degrees
Tool material	Solid carbide
Type	
Machining strategy	HPC
Through-coolant	no
Colour ring	green
Use for drilling	
Pilot drill required	
Drill depth up to	4xD
Cutting direction	
Hole tolerance	
Coating	TiAlN
Helix angle	degrees
Schaft	DIN 6535 HA to h6
Series	
Type of product	