

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø h7: 9,7 mm****Order data**

|              |               |
|--------------|---------------|
| Order number | 122440 9,7    |
| GTIN         | 4045197048578 |
| 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/mm<sup>2</sup>: 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    | 4×D               |
| Cutting direction    |                   |
| Hole tolerance       |                   |
| Coating              | TiAlN             |
| Helix angle          | degrees           |
| Schaft               | DIN 6535 HA to h6 |
| Series               |                   |
| Type of product      |                   |