

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

Order number	123101 4,9
GTIN	4045197451569
Item class	11E

Description**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

Convex cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.

Advantage:

High process reliability and surface quality of the hole.

Recommendation:**Maximum drilling depth:**

flute 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. 123102**.

Form **HE**: order with **No. 123101 + 129100 HE**.

NEW GENERATION AVAILABLE!

Recommended successor products are No. 123025 and 123035.

Tool material: Solid carbide

Drill depth up to: 8×D

Point angle: 135 degrees

Schaft: DIN 6535 HA to h6

Through-coolant: yes, with 25 bar

Machining strategy: HPC

Norm: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

Flute length: 57 mm

Overall length L_{tot} : 95 mm

Shank Ø: 6 mm

Feed f in steel < 1100 N/mm²: 0.1 mm/rev.

Technical description

Through-coolant	yes, with 25 bar
Point angle	135 degrees
Hole tolerance	
Machining strategy	HPC
Helix angle	degrees
Colour ring	green
Drill depth up to	8×D
Coating	TiAlN
Pilot drill required	
Use for drilling	
Type	
Tool material	Solid carbide
Cutting direction	
Skaft	DIN 6535 HA to h6
Series	
Type of product	