



Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø h7: 13,8 mm



Order data

Order number	123102 13,8
GTIN	4045197458896
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:

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

Note:

NEW GENERATION AVAILABLE!

Recommended successor products are No. 123026 and 123036.

Machining strategy: HPC

Norm: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

Flute length: 131 mm

Overall length L_{tot} : 178 mm

Shank Ø: 14 mm

Feed f in steel < 1100 N/mm²: 0.26 mm/rev.

Technical description

Number of cutting edges Z	2
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Nominal Ø	13.8 mm
Flute length	131 mm
Feed f in steel < 1100 N/mm ²	0.26 mm/rev.
Shank tolerance	h6
Tolerance nominal Ø	h7
Shank Ø	14 mm
Overall length L _{tot}	178 mm
Norm	Manufacturer's standard
recommended maximum drilling depth	110.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	8×D
Point angle	135 degrees
Skaft	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	green