Solid carbide high performance drill Weldon shank DIN 6535 HB, TiN, Ø DC h7: 13,5mm

Order data

Order number	122635 13,5
GTIN	4045197395153
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 $L_C = L_2 + 1.5 \times D_C$.
NEW GENERATION AVAILABLE!
Recommended successor product is No. 122777.

Technical description

Number of cutting edges Z	2
Flute length L_c	77 mm
Shank tolerance	h6
Nominal Ø D_C	13.5 mm
Feed f in steel < 900 N/mm^2	0.26 mm/rev.
Tolerance nominal Ø	h7
Shank Ø D_s	14 mm
Overall length L	124 mm
Standard	DIN 6537

recommended maximum drilling depth L_2	56.8 mm
Coating	TiN
Tool material	Solid carbide
Version	6×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Colour ring	green
Type of product	Jobber drill

User data

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