



Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 1,8 mm



Order data

Order number	122394 1,8
GTIN	4045197595720
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**.

Recommendation:

Maximum drilling depth:

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

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

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

Form **HB**: order with **No. 122396**.

Form **HE**: order with **No. 122398**.

Through-coolant: no

Standard: DIN 6537 K

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

Tolerance nominal Ø: m7

recommended maximum drilling depth L_2 : 8.3 mm

Overall length L: 50 mm

Shank Ø D_s : 4 mm

Feed f in stainless steel < 900 N/mm²: 0.02 mm/rev.

Technical description

Feed f in stainless steel < 900 N/mm ²	0.02 mm/rev.
Shank tolerance	h6

Number of cutting edges Z	2
Flute length L _c	11 mm
Nominal Ø D _c	1.8 mm
Tolerance nominal Ø	m7
Shank Ø D _s	4 mm
Overall length L	50 mm
Standard	DIN 6537 K
recommended maximum drilling depth L ₂	8.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	blue
Type of product	Jobber drill