



Solid carbide drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 1/4 mm or inch



Order data

Order number	122771 1/4
GTIN	4062406186739
Item class	12F

Description

Version:

Tool specially matched to drilling holes without through-coolant. **Concave major cutting edges** and a **special flute profile** ensure a good chip evacuation. The sturdy cutter geometry with **special point geometry** and 4 cutting edges ensures drilling with good process reliability. A wide range of applications in steel materials thanks to a combination of tough ultra-fine grain carbide and extremely **wear-resistant** and **heat-resistant coating**.

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. 122772**.

Form **HE**: order with **No. 122773**.

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

Through-coolant: no

Standard: DIN 6537

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

Tolerance nominal Ø: m7

recommended maximum drilling depth L_2 : 43.5 mm

Overall length L: 91 mm

Shank Ø D_s : 8 mm

Feed f in steel < 900 N/mm²: 0.18 mm/rev.

Technical description

Flute length L_c	53 mm
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Number of cutting edges Z	2
Shank $\varnothing D_s$	8 mm
Tolerance nominal \varnothing	m7
Inch nominal \varnothing corresponds to	6.35 mm
Overall length L	91 mm
Standard	DIN 6537
Feed f in steel < 900 N/mm ²	0.18 mm/rev.
recommended maximum drilling depth L ₂	43.5 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	green
Type of product	Jobber drill