



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



### Order data

|              |               |
|--------------|---------------|
| Order number | 122771 4,1    |
| GTIN         | 4062406147419 |
| 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  $L_2$ : 29.9 mm

Overall length L: 74 mm

Shank Ø  $D_s$ : 6 mm

Feed  $f$  in steel < 900 N/mm<sup>2</sup>: 0.16 mm/rev.

### Technical description

|                                                   |                   |
|---------------------------------------------------|-------------------|
| Feed f in steel < 900 N/mm <sup>2</sup>           | 0.16 mm/rev.      |
| recommended maximum drilling depth L <sub>2</sub> | 29.9 mm           |
| Standard                                          | DIN 6537          |
| Number of cutting edges Z                         | 2                 |
| Flute length L <sub>c</sub>                       | 36 mm             |
| Nominal Ø D <sub>c</sub>                          | 4.1 mm            |
| Tolerance nominal Ø                               | m7                |
| Shank Ø D <sub>s</sub>                            | 6 mm              |
| Overall length L                                  | 74 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      |