



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



### Order data

Order number	122771 4,4
GTIN	4062406147440
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  $L_2$ : 29.4 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

Flute length $L_c$	36 mm
Shank $\varnothing D_s$	6 mm
Tolerance nominal $\varnothing$	m7
Feed $f$ in steel $< 900 \text{ N/mm}^2$	0.16 mm/rev.
Overall length $L$	74 mm
Nominal $\varnothing D_c$	4.4 mm
recommended maximum drilling depth $L_2$	29.4 mm
Standard	DIN 6537
Number of cutting edges $Z$	2
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