



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



### Order data

|              |               |
|--------------|---------------|
| Order number | 122773 1/4    |
| GTIN         | 4062406186920 |
| 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:

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  $L_2$ : 43.475 mm

Overall length L: 91 mm

Shank Ø  $D_s$ : 8 mm

Feed f in steel < 900 N/mm<sup>2</sup>: 0.18 mm/rev.

### Technical description

|                     |          |
|---------------------|----------|
| Overall length L    | 91 mm    |
| Tolerance nominal Ø | m7       |
| Standard            | DIN 6537 |

|   |                   |
|---|-------------------|
| Feed f in steel < 900 N/mm <sup>2</sup>           | 0.18 mm/rev.      |
| Number of cutting edges Z                         | 2                 |
| recommended maximum drilling depth L <sub>2</sub> | 43.475 mm         |
| Flute length L <sub>c</sub>                       | 53 mm             |
| Shank Ø D <sub>s</sub>                            | 8 mm              |
| Inch nominal Ø corresponds to                     | 6.35 mm           |
| Coating   | TiAlN             |
| Tool material                                     | Solid carbide     |
| Drill depth up to                                 | 6×D               |
| Point angle                                       | 140 degrees       |
| Shank   | DIN 6535 HE to h6 |
| Through-coolant                                   | no                |
| Colour ring                                       | green             |
| Type of product                                   | Jobber drill      |