



Solid carbide high performance drill, plain shank DIN 6535 HA, TiN, Ø DC h7 (mm or inch): 12,2 mm or inch



Order data

Order number	122340 12,2
GTIN	4045197045065
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:

Flute length (see table) less 1.5×nominal Ø.

Note:

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

NEW GENERATION AVAILABLE!

Recommended successor product is No. 122504.

Versions with HB and HE shank available at the same price as HA.

HB shank: use order **No. 122345**.

HE shank: use order **No. 122355**.

Semi-Standard: yes

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 41.7 mm

Overall length L: 107 mm

Shank Ø D_s : 14 mm

Feed f in steel < 900 N/mm²: 0.26 mm/rev.

Technical description

Nominal $\varnothing D_c$	12.2 mm
Flute length L_c	60 mm
Number of cutting edges Z	2
Feed f in steel < 900 N/mm ²	0.26 mm/rev.
Shank tolerance	h6
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	14 mm
Overall length L	107 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	41.7 mm
Coating	TiN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill