

# Solid carbide high performance drill, plain shank DIN 6535 HA, TiN, $\varnothing$ DC h7 (mm or inch): 7,4 mm or inch



#### **Order data**

Order number	122340 7,4
GTIN	4045197044754
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  $1.5 \times nominal \emptyset$ .

#### 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<sub>2</sub>: 29.9 mm

Overall length L: 79 mm Shank Ø D<sub>s</sub>: 8 mm

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

## **Technical description**

## Ab Hoffmann Group

Flute length L <sub>c</sub> Feed f in steel < 900 N/mm²  Nominal Ø D <sub>c</sub> 7.4 mm  Tolerance nominal Ø h7  Shank Ø D <sub>s</sub> 8 mm  Overall length L 79 mm  Standard DIN 6537 K recommended maximum drilling depth L <sub>2</sub> 29.9 mm  Coating TiN  Tool material Solid carbide Drill depth up to 4×D  Point angle Shank DIN 6535 HA to h6 Through-coolant Semi-Standard yes	Shank tolerance	h6
Feed f in steel < $900 \text{ N/mm}^2$ $0.18 \text{ mm/rev.}$ Nominal Ø $D_c$ $7.4 \text{ mm}$ Tolerance nominal Ø $h7$ Shank Ø $D_s$ $8 \text{ mm}$ Overall length L $79 \text{ mm}$ StandardDIN 6537 Krecommended maximum drilling depth $L_2$ $29.9 \text{ mm}$ CoatingTiNTool materialSolid carbideDrill depth up to $4 \times D$ Point angle $140 \text{ degrees}$ ShankDIN 6535 HA to h6Through-coolantyes, with 25 barSemi-StandardyesColour ringgreen	Number of cutting edges Z	2
Nominal Ø D <sub>c</sub> Tolerance nominal Ø h7 Shank Ø D <sub>s</sub> 8 mm Overall length L 79 mm Standard DIN 6537 K recommended maximum drilling depth L₂ 29.9 mm Coating TiN Tool material Solid carbide Drill depth up to 4×D Point angle 140 degrees Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Semi-Standard Colour ring green	Flute length L <sub>c</sub>	41 mm
Tolerance nominal $\varnothing$ h7Shank $\varnothing$ Ds8 mmOverall length L79 mmStandardDIN 6537 Krecommended maximum drilling depth L229.9 mmCoatingTiNTool materialSolid carbideDrill depth up to $4 \times D$ Point angle $140$ degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barSemi-StandardyesColour ringgreen	Feed f in steel < 900 N/mm <sup>2</sup>	0.18 mm/rev.
Shank Ø D₅       8 mm         Overall length L       79 mm         Standard       DIN 6537 K         recommended maximum drilling depth L₂       29.9 mm         Coating       TiN         Tool material       Solid carbide         Drill depth up to       4×D         Point angle       140 degrees         Shank       DIN 6535 HA to h6         Through-coolant       yes, with 25 bar         Semi-Standard       yes         Colour ring       green	Nominal Ø D <sub>c</sub>	7.4 mm
Overall length L79 mmStandardDIN 6537 Krecommended maximum drilling depth L₂29.9 mmCoatingTiNTool materialSolid carbideDrill depth up to4×DPoint angle140 degreesShankDIN 6535 HA to h6Through-coolantyes, with 25 barSemi-StandardyesColour ringgreen	Tolerance nominal Ø	h7
Standard  recommended maximum drilling depth L2  29.9 mm  Coating  TiN  Tool material  Solid carbide  Drill depth up to  4×D  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Semi-Standard  yes, with 25 bar  Semi-Standard  Golour ring  green	Shank Ø D <sub>s</sub>	8 mm
recommended maximum drilling depth L <sub>2</sub> Coating  TiN  Tool material  Drill depth up to  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Semi-Standard  yes  Colour ring  29.9 mm  TiN  Solid carbide  4×D  140 degrees  DIN 6535 HA to h6  yes, with 25 bar  yes	Overall length L	79 mm
Coating TiN  Tool material Solid carbide  Drill depth up to 4×D  Point angle 140 degrees  Shank DIN 6535 HA to h6  Through-coolant yes, with 25 bar  Semi-Standard yes  Colour ring green	Standard	DIN 6537 K
Tool material  Drill depth up to  Point angle  Shank  DIN 6535 HA to h6  Through-coolant  Semi-Standard  Colour ring  Solid carbide  4×D  140 degrees  140 degrees  yes  yes, with 25 bar  yes  green	recommended maximum drilling depth L <sub>2</sub>	29.9 mm
Drill depth up to 4×D  Point angle 140 degrees  Shank DIN 6535 HA to h6  Through-coolant yes, with 25 bar  Semi-Standard yes  Colour ring green	Coating	TiN
Point angle 140 degrees  Shank DIN 6535 HA to h6  Through-coolant yes, with 25 bar  Semi-Standard yes  Colour ring green	Tool material	Solid carbide
Shank  DIN 6535 HA to h6  Through-coolant  Semi-Standard  Colour ring  green	Drill depth up to	4×D
Through-coolant yes, with 25 bar  Semi-Standard yes  Colour ring green	Point angle	140 degrees
Semi-Standard yes Colour ring green	Shank	DIN 6535 HA to h6
Colour ring green	Through-coolant	yes, with 25 bar
	Semi-Standard	yes
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill