



Solid carbide high performance drill, plain shank DIN 6535 HA, TiN, Ø DC h7 (mm or inch): 9,8 mm or inch



Order data

Order number	122340 9,8
GTIN	4045197044952
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 : 32.3 mm

Overall length L: 89 mm

Shank Ø D_s : 10 mm

Feed f in steel < 900 N/mm²: 0.22 mm/rev.

Technical description

Shank tolerance	h6
Feed f in steel < 900 N/mm ²	0.22 mm/rev.
Nominal Ø D _c	9.8 mm
Number of cutting edges Z	2
Flute length L _c	47 mm
Tolerance nominal Ø	h7
Shank Ø D _s	10 mm
Overall length L	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth L ₂	32.3 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
Type of product	Jobber drill