



## Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 13,8 mm



### Order data

Order number	122394 13,8
GTIN	4045197419743
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:

clamping slot length (see table) less  $1.5 \times \text{nominal } \varnothing$ .

#### Note:

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

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122396**.

Form **HE**: order with **No. 122398**.

Through-coolant: no

Standard: DIN 6537 K

Tolerance nominal  $\varnothing$ : m7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : m7

recommended maximum drilling depth  $L_2$ : 39.3 mm

Overall length L: 107 mm

Shank  $\varnothing D_s$ : 14 mm

Feed f in stainless steel  $< 900 \text{ N/mm}^2$ : 0.15 mm/rev.

### Technical description

Number of cutting edges Z	2
Shank tolerance	h6

Nominal $\varnothing D_c$	13.8 mm
Flute length $L_c$	60 mm
Feed $f$ in stainless steel $< 900 \text{ N/mm}^2$	0.15 mm/rev.
Tolerance nominal $\varnothing$	m7
Shank $\varnothing D_s$	14 mm
Overall length $L$	107 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	39.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	no
Colour ring	blue
Type of product	Jobber drill