



Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 9,1 mm



Order data

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|--------------|---------------|
| Order number | 122394 9,1 |
| GTIN | 4045197419514 |
| 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×nominal Ø.

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 Ø: m7

Number of cutting edges Z: 2

Tolerance nominal Ø: m7

recommended maximum drilling depth L_2 : 33.4 mm

Overall length L: 89 mm

Shank Ø D_s : 10 mm

Feed f in stainless steel < 900 N/mm²: 0.12 mm/rev.

Technical description

| | |
|-----------------|--------|
| Nominal Ø D_c | 9.1 mm |
| Shank tolerance | h6 |

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|---|-------------------|
| Feed f in stainless steel < 900 N/mm ² | 0.12 mm/rev. |
| Number of cutting edges Z | 2 |
| Flute length L _c | 47 mm |
| Tolerance nominal Ø | m7 |
| Shank Ø D _s | 10 mm |
| Overall length L | 89 mm |
| Standard | DIN 6537 K |
| recommended maximum drilling depth L ₂ | 33.4 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 |