



Solid carbide high performance drill Whistle-Notch shank DIN 6535 HE, TiAlN, Ø DC m7: 4,2 mm



Order data

| | |
|--------------|---------------|
| Order number | 122398 4,2 |
| GTIN | 4045197426420 |
| 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 $L_c = L_2 + 1.5 \times D_c$.

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 : 17.7 mm

Overall length L: 66 mm

Shank $\varnothing D_s$: 6 mm

Feed f in stainless steel $< 900 \text{ N/mm}^2$: 0.07 mm/rev.

Technical description

| | |
|--|--------------|
| Feed f in stainless steel $< 900 \text{ N/mm}^2$ | 0.07 mm/rev. |
| Flute length L_c | 24 mm |
| Shank tolerance | h6 |
| Number of cutting edges Z | 2 |

| | |
|--|-------------------|
| Nominal $\varnothing D_c$ | 4.2 mm |
| Tolerance nominal \varnothing | m7 |
| Shank $\varnothing D_s$ | 6 mm |
| Overall length L | 66 mm |
| Standard | DIN 6537 K |
| recommended maximum drilling depth L_2 | 17.7 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Drill depth up to | 4xD |
| Point angle | 140 degrees |
| Shank | DIN 6535 HE to h6 |
| Through-coolant | no |
| Colour ring | blue |
| Type of product | Jobber drill |