



## Solid carbide high performance drill plain shank DIN 6535 HA, TiAlN, Ø DC m7: 12,8 mm



### Order data

Order number	122404 12,8
GTIN	4045197420800
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  $L_c = L_2 + 1.5 \times D_c$ .

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

Form **HB**: order with **No. 122406**.

Form **HE**: order with **No. 122408**.

Through-coolant: yes, with 25 bar

Standard: DIN 6537 K

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

Tolerance nominal Ø: m7

recommended maximum drilling depth  $L_2$ : 40.8 mm

Overall length L: 107 mm

Shank Ø  $D_s$ : 14 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.15 mm/rev.

### Technical description

Shank tolerance	h6
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Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.15 mm/rev.
Flute length L <sub>c</sub>	60 mm
Number of cutting edges Z	2
Nominal Ø D <sub>c</sub>	12.8 mm
Tolerance nominal Ø	m7
Shank Ø D <sub>s</sub>	14 mm
Overall length L	107 mm
Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	40.8 mm
Coating	TiAlN
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
Colour ring	blue
Type of product	Jobber drill