



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



### Order data

Order number	122406 12,8
GTIN	4045197424945
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: yes, with 25 bar

Standard: DIN 6537 K

Tolerance nominal  $\varnothing$ : m7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : m7

recommended maximum drilling depth  $L_2$ : 40.8 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

Feed f in stainless steel $< 900 \text{ N/mm}^2$	0.15 mm/rev.
Number of cutting edges Z	2
Nominal $\varnothing D_c$	12.8 mm
Shank tolerance	h6

Flute length $L_c$	60 mm
Tolerance nominal $\varnothing$	m7
Shank $\varnothing D_s$	14 mm
Overall length L	107 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	40.8 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Colour ring	blue
Type of product	Jobber drill