



Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC m7: 13,8 mm



Order data

Order number	122406 13,8
GTIN	4045197424976
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 : 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
Nominal $\varnothing D_c$	13.8 mm
Flute length L_c	60 mm
Shank tolerance	h6

Feed f in stainless steel < 900 N/mm ²	0.15 mm/rev.
Tolerance nominal Ø	m7
Shank Ø 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	4×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Colour ring	blue
Type of product	Jobber drill