



## Solid carbide high performance drill, Weldon shank DIN 6535 HB, TiAlN, Ø DC m7: 4,7 mm



### Order data

|              |               |
|--------------|---------------|
| Order number | 122406 4,7    |
| GTIN         | 4045197424297 |
| 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  $L_2$ : 17 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

|  |              |
|--|--------------|
| Flute length $L_c$                               | 24 mm        |
| Feed f in stainless steel $< 900 \text{ N/mm}^2$ | 0.07 mm/rev. |
| Number of cutting edges Z                        | 2            |
| Nominal $\varnothing D_c$                        | 4.7 mm       |

|  |                   |
|--|-------------------|
| Shank tolerance                          | h6                |
| 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 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      |