

Solid carbide HPC drill plain shank DIN 6535 HA, TiAIN,  $\varnothing$  DC m6 ( $\varnothing$  DC X = h7) (mm or inch): 5,2 mm or inch



### **Order data**

Order number	122659 5,2
GTIN	4045197455956
Item class	11E

## **Description**

#### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry.** High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers.** Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

### **Recommendation:**

### Maximum drilling depth:

Flute length (see table) less  $1.5 \times nominal \emptyset$ .

### Attention:

Sizes **ending with X** = cutter  $\varnothing$  tolerance **h7.** 

#### 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. 122661.

Form **HE**: order with **No. 122659 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: m6 Number of cutting edges Z: 2 Tolerance nominal Ø: m6

recommended maximum drilling depth L<sub>2</sub>: 36.2 mm

Overall length L: 82 mm Shank Ø D<sub>s</sub>: 6 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.12 mm/rev.

# **Technical description**



Nominal Ø D <sub>c</sub> Flute length L <sub>c</sub> Shank tolerance  Number of cutting edges Z  Tolerance nominal Ø  Shank Ø D <sub>c</sub> Shank Ø D <sub>c</sub> 6 mm  Overall length L  Standard  DIN 6537  recommended maximum drilling depth L  Coating  TiAlN  Tool material  Solid carbide  Drill depth up to  Point angle  Cutting direction  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  Solow  Solow  Solow  Solow  HPC  Semi-Standard  Jobber drill	Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.12 mm/rev.
Flute length L₂ 44 mm  Shank tolerance h6  Number of cutting edges Z 2  Tolerance nominal Ø m6  Shank Ø D₃ 6 mm  Overall length L 82 mm  Standard DIN 6537  recommended maximum drilling depth L₂ 36.2 mm  Coating TiAIN  Tool material Solid carbide  Drill depth up to 6×D  Point angle 140 degrees  Cutting direction right-hand  Shank DIN 6535 HA to h6  Through-coolant yes, with 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring blue		
Shank tolerance       h6         Number of cutting edges Z       2         Tolerance nominal Ø       m6         Shank Ø D₃       6 mm         Overall length L       82 mm         Standard       DIN 6537         recommended maximum drilling depth L₂       36.2 mm         Coating       TiAIN         Tool material       Solid carbide         Drill depth up to       6xD         Point angle       140 degrees         Cutting direction       right-hand         Shank       DIN 6535 HA to h6         Through-coolant       yes, with 25 bar         Machining strategy       HPC         Semi-Standard       yes         Colour ring       blue	Nominal Ø D <sub>c</sub>	5.2 mm
Number of cutting edges Z  Tolerance nominal Ø  Shank Ø D₃  Overall length L  Standard  DIN 6537  recommended maximum drilling depth L₂  Coating  TiAIN  Tool material  Drill depth up to  Point angle  Cutting direction  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  Colour ring  Din 6535 HA to h6  The Colour ring  Din 6535 HA to h6  The Colour ring  Din 6535 HA to h6  The Colour ring  Din 6535 HA to h6  Din 6535	Flute length L <sub>c</sub>	44 mm
Tolerance nominal Ø m6  Shank Ø D₅ 6 mm  Overall length L 82 mm  Standard DIN 6537  recommended maximum drilling depth L₂ 36.2 mm  Coating TiAlN  Tool material Solid carbide  Drill depth up to 6×D  Point angle 140 degrees  Cutting direction right-hand  Shank DIN 6535 HA to h6  Through-coolant yes, with 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring blue	Shank tolerance	h6
Shank Ø D₃6 mmOverall length L82 mmStandardDIN 6537recommended maximum drilling depth L₂36.2 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Number of cutting edges Z	2
Overall length L82 mmStandardDIN 6537recommended maximum drilling depth L₂36.2 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Tolerance nominal Ø	m6
Standard  DIN 6537  recommended maximum drilling depth L2  36.2 mm  Coating  TiAIN  Tool material  Solid carbide  Drill depth up to  6×D  Point angle  140 degrees  Cutting direction  right-hand  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  yes  Colour ring  DIN 6537	Shank Ø D <sub>s</sub>	6 mm
recommended maximum drilling depth L2 36.2 mm  Coating TiAIN  Tool material Solid carbide  Drill depth up to 6×D  Point angle 140 degrees  Cutting direction right-hand  Shank DIN 6535 HA to h6  Through-coolant yes, with 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring blue	Overall length L	82 mm
CoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Standard	DIN 6537
Tool material  Drill depth up to  6×D  Point angle  140 degrees  Cutting direction  right-hand  Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  yes  Colour ring  blue	recommended maximum drilling depth L <sub>2</sub>	36.2 mm
Drill depth up to6×DPoint angle140 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Coating	TiAIN
Point angle 140 degrees Cutting direction right-hand Shank DIN 6535 HA to h6 Through-coolant yes, with 25 bar Machining strategy HPC Semi-Standard yes Colour ring blue	Tool material	Solid carbide
Cutting direction right-hand  Shank DIN 6535 HA to h6  Through-coolant yes, with 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring blue	Drill depth up to	6×D
Shank  DIN 6535 HA to h6  Through-coolant  Machining strategy  HPC  Semi-Standard  yes  Colour ring  blue	Point angle	140 degrees
Through-coolant yes, with 25 bar  Machining strategy HPC  Semi-Standard yes  Colour ring blue	Cutting direction	right-hand
Machining strategy HPC Semi-Standard yes Colour ring blue	Shank	DIN 6535 HA to h6
Semi-Standard yes Colour ring blue	Through-coolant	yes, with 25 bar
Colour ring blue	Machining strategy	HPC
	Semi-Standard	yes
Type of product Jobber drill	Colour ring	blue
	Type of product	Jobber drill

# Services

Shank grinding Type HE 129100 HE