



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



### Order data

Order number	122666 13,8
GTIN	4045197426031
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  $L_c = L_2 + 1.5 \times D_c$ .

Through-coolant: yes, with 25 bar

Standard: DIN 6537

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

Tolerance nominal Ø: m7

recommended maximum drilling depth  $L_2$ : 56.3 mm

Overall length L: 124 mm

Shank Ø  $D_s$ : 14 mm

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

### Technical description

Number of cutting edges Z	2
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.15 mm/rev.
Nominal Ø $D_c$	13.8 mm
Shank tolerance	h6

Flute length $L_c$	77 mm
Tolerance nominal $\varnothing$	m7
Shank $\varnothing D_s$	14 mm
Overall length L	124 mm
Standard	DIN 6537
recommended maximum drilling depth $L_2$	56.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6×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