

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC p6: 3,3 mm



Order data

Order number	122736 3,3
GTIN	4045197566997
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. With **140° point angle** and special **j6 cutting edge tolerance** for optimum generation of a pilot hole.

Recommendation:

Maximum drilling depth:

flute length (see table) less $1.5 \times \text{nominal } \emptyset$.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

For deep-hole drilling deeper than $12\times D$ a pilot hole is recommended, and for deep-hole drilling from $20\times D$ to $30\times D$ it is essential.

The generation of a pilot hole improves process reliability.

Form HB and HE supplied at the same price as HA.

Form HB: order with No. 122738.

Form **HE:** order with **No. 122736 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: p6

Number of cutting edges Z: 2

Tolerance nominal Ø: p6

recommended maximum drilling depth L₂: 23.1 mm

Overall length L: 66 mm Shank Ø D.: 6 mm

Feed f in steel < 1100 N/mm²: 0.08 mm/rev.

Technical description



Feed f in steel < 1100 N/mm² Flute length L _c Nominal Ø D _C 3.3 mm Shank tolerance h6 Number of cutting edges Z Tolerance nominal Ø Shank Ø D _s Overall length L Standard DIN 6537 recommended maximum drilling depth L ₂ Coating TiAIN Tool material Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Doug Smm/rev. 28 mm Annum Ann	Food fin stool 41100 N/mm²	0.08 mm/rev.
Nominal Ø Dc 3.3 mm Shank tolerance h6 Number of cutting edges Z 2 Tolerance nominal Ø p6 Shank Ø D₂ 6 mm Overall length L 66 mm Standard DIN 6537 recommended maximum drilling depth L₂ 23.1 mm Coating TiAIN Tool material Solid carbide Drill depth up to 6×D Point angle 140 degrees Shank DIN 6535 HA to h6	reed fin steel < 1100 N/mm	0.08 mm/rev.
Shank tolerance h6 Number of cutting edges Z 2 Tolerance nominal Ø p6 Shank Ø D₃ 6 mm Overall length L 66 mm Standard DIN 6537 recommended maximum drilling depth L₂ 23.1 mm Coating TiAIN Tool material Solid carbide Drill depth up to 6×D Point angle 140 degrees Shank DIN 6535 HA to h6	Flute length L _c	28 mm
Number of cutting edges Z 2 Tolerance nominal Ø p6 Shank Ø D₅ 6 mm Overall length L 66 mm Standard DIN 6537 recommended maximum drilling depth L₂ 23.1 mm Coating TiAIN Tool material Solid carbide Drill depth up to 6×D Point angle 140 degrees Shank DIN 6535 HA to h6	Nominal Ø D _c	3.3 mm
Tolerance nominal \varnothing p6Shank \varnothing D $_s$ 6 mmOverall length L66 mmStandardDIN 6537recommended maximum drilling depth L $_2$ 23.1 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6	Shank tolerance	h6
Shank Ø D₃6 mmOverall length L66 mmStandardDIN 6537recommended maximum drilling depth L₂23.1 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6	Number of cutting edges Z	2
Overall length L66 mmStandardDIN 6537recommended maximum drilling depth L223.1 mmCoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6	Tolerance nominal Ø	р6
Standard DIN 6537 recommended maximum drilling depth L ₂ 23.1 mm Coating TiAIN Tool material Solid carbide Drill depth up to 6×D Point angle 140 degrees Shank DIN 6535 HA to h6	Shank Ø D _s	6 mm
recommended maximum drilling depth L_2 23.1 mm Coating TiAlN Tool material Solid carbide Drill depth up to $6\times D$ Point angle 140 degrees Shank DIN 6535 HA to h6	Overall length L	66 mm
CoatingTiAINTool materialSolid carbideDrill depth up to6×DPoint angle140 degreesShankDIN 6535 HA to h6	Standard	DIN 6537
Tool material Drill depth up to 6×D Point angle 140 degrees Shank DIN 6535 HA to h6	recommended maximum drilling depth L ₂	23.1 mm
Drill depth up to 6×D Point angle 140 degrees Shank DIN 6535 HA to h6	Coating	TiAIN
Point angle 140 degrees Shank DIN 6535 HA to h6	Tool material	Solid carbide
Shank DIN 6535 HA to h6	Drill depth up to	6×D
	Point angle	140 degrees
Through-coolant yes, with 25 bar	Shank	DIN 6535 HA to h6
	Through-coolant	yes, with 25 bar
Machining strategy HPC	Machining strategy	HPC
Semi-Standard yes	Semi-Standard	yes
Colour ring green	Colour ring	green
Type of product Jobber drill	Type of product	Jobber drill

Services

Shank grinding Type HE 129100 HE