



## Solid carbide high performance drill plain shank DIN 6535 HA, TiN, Ø DC h7: 7,8 mm



### Order data

Order number	123306 7,8
GTIN	4045197448620
Item class	12E

### Description

#### Version:

**Strong core and special point geometry** –ensure the cutting chisel edges maintain **high self-centring accuracy**.

**Straight cutting edges** with slight edge hone and a special flute profile produce **short chips**.

#### Recommendation:

#### Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

#### Note:

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

For process reliability when using the 12×D drill, an initial centre drilling with NC spotting drills No. 121068 - 121130 or HOLEX Pro Steel No. 122501 is necessary.

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

Form **HB**: order with **No. 123307**.

Form **HE**: order with **No. 123308**.

#### **NEW GENERATION AVAILABLE!**

**Recommended successor product is No. 123303.**

Through-coolant: yes, with 25 bar

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 96.3 mm

Overall length L: 146 mm

Shank Ø  $D_s$ : 8 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.15 mm/rev.

### Technical description

Flute length $L_c$	108 mm
Feed $f$ in steel $< 1100 \text{ N/mm}^2$	0.15 mm/rev.
Nominal $\varnothing D_c$	7.8 mm
Shank tolerance	h6
Number of cutting edges $Z$	2
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	8 mm
Overall length $L$	146 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	96.3 mm
Coating	TiN
Tool material	Solid carbide
Drill depth up to	12×D
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Colour ring	green
Type of product	Jobber drill