



Solid carbide high performance drill Weldon shank DIN 6535 HB, TiN, Ø DC h7: 3,8 mm



Order data

Order number	123307 3,8
GTIN	4045197449900
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 $1.5 \times \text{nominal } \varnothing$.

Note:

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

For process reliability when using the $12 \times D$ deep-hole drill, an initial centre drilling with No. 121068 – 121130 or $3 \times D$ pilot drilling operation with No. 122736 is necessary.

Pilot drill required: yes, pilot drill

Standard: Manufacturer's standard

Tolerance nominal \varnothing : h7

Number of cutting edges Z: 2

Tolerance nominal \varnothing : h7

recommended maximum drilling depth L_2 : 58.3 mm

Overall length L: 102 mm

Shank $\varnothing D_s$: 6 mm

Feed f in steel $< 1100 \text{ N/mm}^2$: 0.1 mm/rev.

Technical description

Feed f in steel $< 1100 \text{ N/mm}^2$	0.1 mm/rev.
Shank tolerance	h6
Number of cutting edges Z	2

Flute length L_c	64 mm
Nominal $\varnothing D_c$	3.8 mm
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	6 mm
Overall length L	102 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	58.3 mm
Coating	TiN
Tool material	Solid carbide
Drill depth up to	12xD
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Pilot drill required	yes, pilot drill
Colour ring	green
Type of product	Jobber drill