

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 30×D, TiAlN, \varnothing DC h7: 2,2 mm

Order data

Order number	123695 2,2
GTIN	4045197320377
Item class	11E

Description

Version:

Spiral fluted, with **4 guide chamfers** and internal cooling channels. New generation of high performance deep hole drills in the HPC range.

With 135° point angle and special h7 cutting edge tolerance for optimum generation of a deep hole.

High roundness and alignment accuracy of the deep 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 process reliability when using the $16\times D$ deep-hole drill, an initial centre drilling with No. 121068 - 121130 or $4\times D$ pilot drilling operation with pilot drill No. 122736 is necessary. For deep holes greater than $20\times D$, a $6\times D$ pilot hole with pilot drill No. 122736 is absolutely essential. **The generation of a pilot hole improves process reliability.** See also pages 129/130.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7 Number of cutting edges Z: 2 Tolerance nominal Ø: h7

recommended maximum drilling depth L₂: 66.7 mm

Overall length L: 115 mm

Shank Ø D_s: 4 mm

Feed f in steel < 900 N/mm²: 0.06 mm/rev.

Technical description

Number of cutting edges Z Nominal Ø D _C 2.2 mm Tolerance nominal Ø 5hank Ø D _s 4 mm Overall length L Standard Manufacturer's standard recommended maximum drilling depth L₂ Coating TiAIN Tool material Solid carbide Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Pilot drill required Colour ring 2.2 mm h7 A mm 66.7 mm 50lid carbide 135 degrees DIN 6535 HA to h6 Through-coolant Machining strategy HPC Pilot drill required Colour ring green	Feed f in steel < 900 N/mm ²	0.06 mm/rev.
Nominal Ø D _c Tolerance nominal Ø Shank Ø D _s Overall length L Standard Manufacturer's standard recommended maximum drilling depth L ₂ Coating TiAlN Tool material Solid carbide Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Pilot drill required Colour ring 172 mm A mm A mm A mm A mufacturer's standard Manufacturer's standard Manufacturer's standard Solid carbide 30×D TiAlN Tool material Solid carbide 135 degrees HPC yes, with 40 bar HPC yes, pilot drill Golour ring	Flute length L _c	70 mm
Tolerance nominal Ø Shank Ø D _s 4 mm Overall length L 115 mm Standard Manufacturer's standard recommended maximum drilling depth L ₂ 66.7 mm Coating TiAIN Tool material Solid carbide Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Pilot drill required Colour ring Shank Glour ring Piper Machining strategy Recommended maximum drilling depth L ₂ A maximum drilling depth L ₂ 66.7 mm Solid carbide TiAIN Solid carbide TiAIN Solid carbide The Machining strategy Recommended maximum drilling depth L ₂ 80 mm Solid carbide TiAIN Solid carbide The Machining strategy Recommended maximum drilling depth L ₂ 80 mm Solid carbide Solid carbide TiAIN Solid carbide The Machining strategy Recommended maximum drilling depth L ₂ 80 mm Solid carbide Solid carbide The Machining strategy Recommended maximum drilling depth L ₂ 80 mm Solid carbide Solid carbide The Machining strategy Recommended maximum drilling depth L ₂ 80 mm Solid carbide Solid carbide Solid carbide The Machining strategy Recommended maximum drilling depth L ₂ 80 mm Solid carbide S	Number of cutting edges Z	2
Shank Ø D₅ Overall length L Standard Manufacturer's standard recommended maximum drilling depth L₂ Coating TiAIN Tool material Solid carbide Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Pilot drill required Colour ring 115 mm Manufacturer's standard Manufacturer's standard Machining strategy HPC yes, pilot drill Green	Nominal Ø D _c	2.2 mm
Overall length L Standard Manufacturer's standard recommended maximum drilling depth L₂ 66.7 mm Coating TiAIN Tool material Solid carbide Drill depth up to 30×D Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Pilot drill required Colour ring Ti5 mm Manufacturer's standard Manufacturer's standard Manufacturer's standard Machining depth L₂ 66.7 mm TiAIN Tool material Solid carbide TiAIN Tool material Solid carbide Through-coolant Thr	Tolerance nominal Ø	h7
Standard Manufacturer's standard recommended maximum drilling depth L ₂ 66.7 mm Coating TiAIN Tool material Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Pilot drill required Colour ring Manufacturer's standard 66.7 mm TiAIN Solid carbide 30×D 135 degrees DIN 6535 HA to h6 yes, with 40 bar HPC yes, pilot drill	Shank Ø D _s	4 mm
recommended maximum drilling depth L ₂ Coating TiAIN Tool material Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy Pilot drill required Colour ring TiAIN 50lid carbide 30×D 135 degrees DIN 6535 HA to h6 yes, with 40 bar HPC yes, pilot drill green	Overall length L	115 mm
Coating TiAIN Tool material Solid carbide Drill depth up to 30×D Point angle 135 degrees Shank DIN 6535 HA to h6 Through-coolant yes, with 40 bar Machining strategy HPC Pilot drill required yes, pilot drill Colour ring green	Standard	Manufacturer's standard
Tool material Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy Pilot drill required Colour ring Solid carbide 30×D 135 degrees DIN 6535 HA to h6 Yes, with 40 bar HPC yes, pilot drill green	recommended maximum drilling depth L ₂	66.7 mm
Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy Pilot drill required Colour ring 30×D 135 degrees DIN 6535 HA to h6 yes, with 40 bar HPC yes, pilot drill green	Coating	TiAIN
Point angle 135 degrees Shank DIN 6535 HA to h6 Through-coolant yes, with 40 bar Machining strategy HPC Pilot drill required yes, pilot drill Colour ring green	Tool material	Solid carbide
Shank DIN 6535 HA to h6 Through-coolant Machining strategy Pilot drill required Colour ring DIN 6535 HA to h6 yes, with 40 bar HPC yes, pilot drill green	Drill depth up to	30×D
Through-coolant yes, with 40 bar Machining strategy HPC Pilot drill required yes, pilot drill Colour ring green	Point angle	135 degrees
Machining strategy HPC Pilot drill required Colour ring HPC yes, pilot drill green	Shank	DIN 6535 HA to h6
Pilot drill required yes, pilot drill Colour ring green	Through-coolant	yes, with 40 bar
Colour ring green	Machining strategy	HPC
-	Pilot drill required	yes, pilot drill
Type of product Jobber drill	Colour ring	green
	Type of product	Jobber drill