

Solid carbide HPC deep-hole drill plain shank DIN 6535 HA 30×D, TiAlN, \varnothing DC h7: 3,5 mm

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Order data

Order number	123695 3,5
GTIN	4045197320469
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: 129.8 mm

Overall length L: 185 mm

Shank Ø D_s: 6 mm

Feed f in steel < 900 N/mm²: 0.08 mm/rev.

Technical description

Flute length L_c 135 mm

Feed f in steel < 900 N/mm² Tolerance nominal Ø Shank Ø D₃ Overall length L Standard Standard Feed f in steel < 900 N/mm² Find the mean of the	Nominal Ø D _c	3.5 mm
Tolerance nominal Ø Shank Ø D _s 6 mm Overall length L Standard Manufacturer's standard recommended maximum drilling depth L ₂ 129.8 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 Machining strategy HPC Pilot drill required Colour ring green	Number of cutting edges Z	2
Shank Ø D₅ 6 mm Overall length L 185 mm Standard Manufacturer's standard recommended maximum drilling depth L₂ 129.8 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	Feed f in steel < 900 N/mm ²	0.08 mm/rev.
Overall length L185 mmStandardManufacturer's standardrecommended maximum drilling depth L₂129.8 mmCoatingTiAINTool materialSolid carbideDrill depth up to30×DPoint angle135 degreesShankDIN 6535 HA to h6Through-coolantyes, with 40 barMachining strategyHPCPilot drill requiredyes, pilot drillColour ringgreen	Tolerance nominal Ø	h7
Standard Manufacturer's standard recommended maximum drilling depth L2 129.8 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 Machining strategy HPC Pilot drill required Colour ring Manufacturer's standard 129.8 mm Nouther to the solid carbide Solid carbide Solid carbide DIN 6535 HA to h6 yes, with 40 bar HPC yes, pilot drill green	Shank Ø D _s	6 mm
recommended maximum drilling depth L2 129.8 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	Overall length L	185 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 30×D Point angle Solid carbide 30×D 135 degrees Shank DIN 6535 HA to h6 Through-coolant Machining strategy HPC Pilot drill required Colour ring Solid carbide 30×D 135 degrees HA to h6 yes, with 40 bar HPC yes, pilot drill green	recommended maximum drilling depth L ₂	129.8 mm
Drill depth up to Point angle Shank DIN 6535 HA to h6 Through-coolant Machining strategy Pilot drill required Colour ring Through Through	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 HPC 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 Yes, pilot drill Golour ring 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
21 1	Type of product	Jobber drill