








# Explanation of the table

Solid carbide tools for drilling



F12

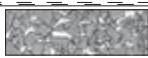


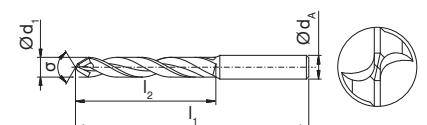
<b>UN</b>	Material group, e.g. UN = universal
	Drill for pilot hole
<b>h7</b>	Tolerance nominal diameter $d_1$
<b>≤ 12xD</b>	Drilling depth, for example up to 12xD
	without through coolant
	with through coolant
<b>E</b> 	Emulsion recommended

<b>HA</b> 	Shanks to DIN6535-HA
<b>HB</b> 	Shanks to DIN6535-HB
<b>HE</b> 	Shanks to DIN6535-HE
<b>HL</b>	Tool group, for example HL = high-performance twist drills
$\sigma$ <b>90°</b>	Point angle
$d_1 = h7$ $d_A = h6$	Tolerance cutting edge diameter Tolerance shank diameter

**UN**
**HPC**

$\lambda_s = 30^\circ$ 
 $d_1 = p6$   
 $d_A = h6$ 

**E**
**≤ 5xD**
 $\sigma$  140°

Application/  
geometry


Grade



Shank type

$d_1$ [mm]	Type, description	$d_A$ [mm]	$l_1$ [mm]	$l_2$ [mm]	<div>HA </div> <b>Material</b>
4.0	HPC.UN.1106.0400p6.5XD.140.IK.HA	6	74	36	W1106040340

Material short text

Dimensions

Material number