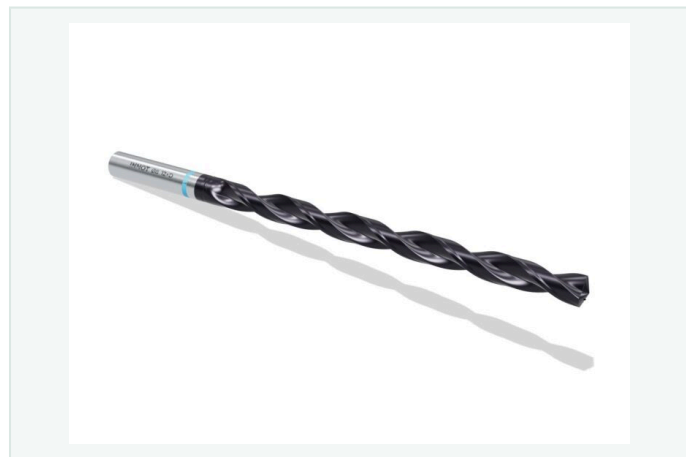


DRILLS · SOLID CARBIDE DRILLS

12xD solid carbide drill

Drill for deep holes up to 12 times the diameter, self-centring 135° point and internal coolant. A pilot hole is recommended.



KEY DATA

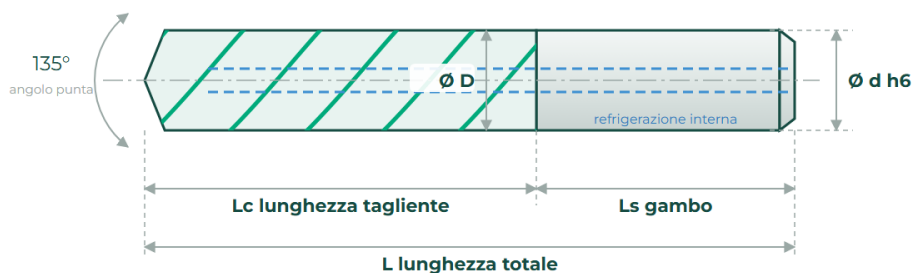
Product type	Drills
ISO materials	P steel M stainless K cast iron N aluminium S superalloys
Online page	innot-it.com/en/prodotto/punta-integrale-12xd

Technical drawing

Punta integrale in metallo duro 12xD

Foratura profonda in un solo passaggio

12xD



Ø 3-20 mm

angolo 135°

toll. h7

refrigerazione interna

INNOT

Reference dimensions

Drill Ø D	Ø d shank	L overall	Lc cutting length	Ls shank
Ø 3	6	90	50	36
Ø 4	6	102	64	36

Drill Ø D	Ø d shank	L overall	Lc cutting length	Ls shank
Ø 5	6	116	78	36
Ø 6	6	116	78	36
Ø 8	8	146	108	36
Ø 10	10	174	132	40
Ø 12	12	204	156	45
Ø 14	14	230	182	45
Ø 16	16	260	208	48
Ø 18	18	286	234	48
Ø 20	20	310	258	48

Dimensions in mm. All intermediate diameters are available, also to the hundredth (e.g. Ø6.8 for M8 or Ø10.2 for M12): shank and lengths follow the diameter range.

Features

Drilling depth	up to 12xD (12 times the diameter)
Diameters	Ø 3 - 20 mm, in 0.01 mm steps
Point angle	135° self-centring, double margin
Ø D tolerance	h7
Shank	Cylindrical h6 (DIN 6535 HA); with Weldon flat on request
Coolant	Internal, two helical channels
ISO materials	P steels, M stainless steels, K cast irons, N aluminium, S superalloys and titanium, H hardened: rod and coating are chosen for the material
Construction	Standard (deep-hole series) or custom made: lengths, steps, chamfers and angles to drawing

Consigli d'uso

- Drill a pilot hole 1.5-2xD deep with a short drill of the same diameter.
- Enter the pilot hole at low speed and without coolant, then start the coolant and the working speed.
- Recommended coolant pressure: at least 20 bar (better 40 bar or more beyond 20xD).

Coatings

All coatings are available on this tool, also in custom versions:

● TiN ● TiCN ● TiAlN ● AlTiN ● AlCrN ● TiSiN ● AlTiSiN ● AlCrSiN ● CrN ● ZrN ● TiB2 ● DLC ● ta-C
● CVD diamond ● Uncoated

[Compare coatings and carbide grades →](#)

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Cutting data are indicative starting values: adjust them to machine, clamping, tool overhang and workpiece material. Data and images may change without notice.