Garant

# Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, ∅ DC m6 (mm or inch): 9/32

## Order data

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|---|---|
| Order number | 123212 9/32 |
| GTIN | 4062406116286 |
| Item class | 11E |

## Description

**Version:**
Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry.** High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers.** Outstanding chip evacuation due to **4 internal cooling channels** from ∅ 3.8 mm. Up to 3.7 mm ∅ with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.
**Note:**
Flute length $L_C = L_2 + 1.5 \times D_C$.
For process reliability when using the 12×D drill, an initial centre drilling with NC spotting drills No. 121068– 121130 is necessary.
Form HB and HE are supplied at the same price as HA.
Order form **HB:** with **No. 123214**.
Order form **HE:** with **No. 123212 + 129100HE**.
Standard: Manufacturer's standard
Tolerance nominal ∅: m6
Number of cutting edges Z: 2
Tolerance nominal ∅: m6
recommended maximum drilling depth $L_2$: 97.5 mm
Overall length L: 146 mm
Shank ∅ $D_s$: 8 mm
Feed f in stainless steel > 900 N/mm$^2$: 0.12 mm/rev.

## Technical description

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|---|---|
| Number of cutting edges Z | 2 |
| Inch nominal ∅ corresponds to | 7.14 mm |

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|---|---|
| recommended maximum drilling depth $L_2$ | 97.5 mm |
| Shank ⌀ $D_s$ | 8 mm |
| Tolerance nominal ⌀ | m6 |
| Shank tolerance | h6 |
| Flute length $L_c$ | 108 mm |
| Overall length L | 146 mm |
| Feed f in stainless steel > 900 N/mm² | 0.12 mm/rev. |
| Standard | Manufacturer's standard |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 12×D |
| Point angle | 135 ° |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | yes, with 25 bar |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | blue |
| Type of product | Jobber drill |

## User data

| | Suitability | $V_c$ | ISO code |
|---|---|---|---|
| Steel < 500 N/mm² | suitable | 90 m/min | P |
| Steel < 750 N/mm² | suitable | 75 m/min | P |
| Steel < 900 N/mm² | suitable | 70 m/min | P |
| Steel < 1100 N/mm² | suitable | 55 m/min | P |
| Steel < 1400 N/mm² | suitable | 32 m/min | P |
| INOX < 900 N/mm² | suitable | 70 m/min | M |
| INOX > 900 N/mm² | suitable | 60 m/min | M |
| wet maximum | suitable | | |

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|---|---|
| wet minimum | suitable |

## Services

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| Shank grinding Type HE | 129100 HE |