

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC m6: 12,7mm



Order data

Order number	123010 12,7
GTIN	4062406121150
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 Ø 3.8 mm. Up to 3.7 mm Ø 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 $L_c = L_2 + 1.5 \times D_c$.

Technical description

recommended maximum drilling depth L_2	111.95 mm
Standard	Manufacturer's standard
Nominal Ø D_c	12.7 mm
Feed f in stainless steel > 900 N/mm ²	0.2 mm/rev.
Shank Ø D_s	14 mm
Tolerance nominal Ø	m6
Overall length L	178 mm
Flute length L_c	131 mm
Number of cutting edges Z	2
Coating	TiAlN
Tool material	Solid carbide

Version	8xD
Point angle	140 degrees
Shank	DIN 6535 HB 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/mm ²	suitable	90 m/min	P
Steel < 750 N/mm ²	suitable	75 m/min	P
Steel < 900 N/mm ²	suitable	70 m/min	P
Steel < 1100 N/mm ²	suitable	55 m/min	P
Steel < 1400 N/mm ²	suitable	32 m/min	P
INOX < 900 N/mm ²	suitable	70 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		