

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 1,5mm

Order data

| | |
|--------------|---------------|
| Order number | 123110 1,5 |
| GTIN | 4045197355775 |
| Item class | 11E |

Description
Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

Straight major cutting edges with honed edges and special flute profile for **short chips**, even on long chipping materials.

Advantage:

High process reliability and surface quality of the hole.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 123115**.

Form **HE**: order with **No. 123110 + 129100 HE**.

Technical description

| | |
|---|--------------|
| Flute length L_c | 20 mm |
| Nominal $\varnothing D_c$ | 1.5 mm |
| Number of cutting edges Z | 2 |
| Feed f in stainless steel < 900 N/mm ² | 0.05 mm/rev. |
| Shank tolerance | h6 |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 4 mm |

| | |
|---|-------------------------|
| Overall length L | 50 mm |
| Standard | Manufacturer's standard |
| recommended maximum drilling depth L ₂ | 17.8 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 10xD |
| Point angle | 135 degrees |
| 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 |
|-------------------------------|---|----------------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 200 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 180 m/min | N |
| Steel < 500 N/mm ² | suitable | 110 m/min | P |
| Steel < 750 N/mm ² | suitable | 80 m/min | P |
| Steel < 900 N/mm ² | suitable | 70 m/min | P |
| INOX < 900 N/mm ² | suitable | 65 m/min | M |
| INOX > 900 N/mm ² | suitable | 55 m/min | M |
| Ti > 850 N/mm ² | suitable | 25 m/min | S |
| wet maximum | suitable | | |
| wet minimum | suitable | | |

