

Garant
Solid carbide jobber drill extra short, TiAlN, Ø DC h7: 12mm

Order data

Order number	122151 12
GTIN	4045197748874
Item class	11E

Description
Version:

Similar to DIN 6539 (extra short).

Nominal Ø and shank Ø equal.

TiAlN coating for even better performance.

Note:

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

Non slip clamping in drill chuck No. 341050 with diamond coated jaws.

Technical description

Nominal Ø D_c	12 mm
Tolerance nominal Ø	h7
Flute length L_c	51 mm
Feed f in steel < 1100 N/mm ²	0.18 mm/rev.
Number of cutting edges Z	2
Standard	DIN 6539
Shank tolerance	h7
Shank Ø D_s	12 mm
Overall length L	102 mm
recommended maximum drilling depth L_2	33 mm
Coating	TiAlN
Tool material	solid carbide

Type	N
Point angle	118 degrees
Helix angle	30 degrees
Shank	Parallel shank to h7
Through-coolant	no
Colour ring	without
Type of product	Jobber drill

User data

	Suitability	V _c	ISO code
Alu plastics	suitable only under restricted conditions	260 m/min	N
Aluminium (short chipping)	suitable	180 m/min	N
Alu > 10% Si	suitable	180 m/min	N
Steel < 500 N/mm ²	suitable	90 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 N/mm ²	suitable	80 m/min	P
Steel < 1100 N/mm ²	suitable	60 m/min	P
Steel < 1400 N/mm ²	suitable	35 m/min	P
INOX < 900 N/mm ²	suitable	35 m/min	M
INOX > 900 N/mm ²	suitable	25 m/min	M
Ti > 850 N/mm ²	suitable	25 m/min	S
GG(G)	suitable	90 m/min	K
CuZn	suitable	180 m/min	N
Uni	suitable		
Oil	suitable		
wet maximum	suitable		
dry	suitable only under restricted conditions		

