

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 3,9mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122380 3,9    |
| GTIN         | 4045197045379 |
| Item class   | 11E           |

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Straight major cutting edges** with slightly honed edges and special flute profile produce **short chips**.

**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. 122385**.

Form **HE**: order with **No. 122380 + 12900HE**.

**Technical description**

|   |              |
|---|--------------|
| Number of cutting edges Z                         | 2            |
| Shank tolerance                                   | h6           |
| Flute length $L_c$                                | 24 mm        |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.09 mm/rev. |
| Nominal Ø $D_c$                                   | 3.9 mm       |
| Tolerance nominal Ø                               | h7           |
| Shank Ø $D_s$                                     | 6 mm         |
| Overall length L                                  | 66 mm        |
| Standard  | DIN 6537 K   |
| recommended maximum drilling depth $L_2$          | 18.2 mm      |

|                    |                   |
|--------------------|-------------------|
| Coating            | TiAlN             |
| Tool material      | Solid carbide     |
| Version            | 4xD               |
| 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 <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping)     | suitable only under restricted conditions | 245 m/min      | N        |
| Steel < 500 N/mm <sup>2</sup>  | suitable                                  | 110 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 90 m/min       | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 85 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 60 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable only under restricted conditions | 35 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable                                  | 55 m/min       | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable                                  | 50 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable                                  | 35 m/min       | S        |
| wet maximum                    | suitable                                  |                |          |
| wet minimum                    | suitable                                  |                |          |
| Air                            | suitable                                  |                |          |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|

