Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, ⌀ DC h7: 2,1mm

Order data

Order number	122380 2,1
GTIN	4045197262615
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 + 12900H**E.

Technical description

Nominal ⌀ D_C	2.1 mm
Feed f in stainless steel < 900 N/mm^2	0.07 mm/rev.
Number of cutting edges Z	2
Flute length L_c	20 mm
Shank tolerance	h6
Tolerance nominal ⌀	h7
Shank ⌀ D_s	4 mm
Overall length L	55 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	16.9 mm

Coating	TiAlN
Tool material	Solid carbide
Version	4×D
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	245 m/min	N
Steel < 500 N/mm²	suitable	110 m/min	P
Steel < 750 N/mm²	suitable	90 m/min	P
Steel < 900 N/mm²	suitable	85 m/min	P
Steel < 1100 N/mm²	suitable	60 m/min	P
Steel < 1400 N/mm²	suitable only under restricted conditions	35 m/min	P
INOX < 900 N/mm²	suitable	55 m/min	M
INOX > 900 N/mm²	suitable	50 m/min	M
Ti > 850 N/mm²	suitable	35 m/min	S
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		