

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 6,8mm**

**Order data**

Order number	122380 6,8
GTIN	4045197045676
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**

Nominal Ø $D_c$	6.8 mm
Number of cutting edges Z	2
Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.12 mm/rev.
Shank tolerance	h6
Flute length $L_c$	34 mm
Tolerance nominal Ø	h7
Shank Ø $D_s$	8 mm
Overall length L	79 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	23.8 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
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