

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 5,8mm


Order data

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|--------------|---------------|
| Order number | 122380 5,8 |
| GTIN | 4045197045584 |
| 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

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|---|--------------|
| Feed f in stainless steel < 900 N/mm ² | 0.09 mm/rev. |
| Flute length L_c | 28 mm |
| Number of cutting edges Z | 2 |
| Shank tolerance | h6 |
| Nominal Ø D_c | 5.8 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 | 19.3 mm |

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|--------------------|-------------------|
| 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 _c | ISO code |
|--------------------------------|---|----------------|----------|
| Aluminium (short chipping) | suitable only under restricted conditions | 245 m/min | N |
| Steel < 500 N/mm ² | suitable | 110 m/min | P |
| Steel < 750 N/mm ² | suitable | 90 m/min | P |
| Steel < 900 N/mm ² | suitable | 85 m/min | P |
| Steel < 1100 N/mm ² | suitable | 60 m/min | P |
| Steel < 1400 N/mm ² | suitable only under restricted conditions | 35 m/min | P |
| INOX < 900 N/mm ² | suitable | 55 m/min | M |
| INOX > 900 N/mm ² | suitable | 50 m/min | M |
| Ti > 850 N/mm ² | suitable | 35 m/min | S |
| wet maximum | suitable | | |
| wet minimum | suitable | | |
| Air | suitable | | |

Services

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