

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 19,5mm**


## Order data

Order number	122380 19,5
GTIN	4045197046215
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 $D_c$	19.5 mm
Feed $f$ in stainless steel < 900 N/mm <sup>2</sup>	0.23 mm/rev.
Number of cutting edges $Z$	2
Shank tolerance	h6
Flute length $L_c$	79 mm
Tolerance nominal Ø	h7
Shank Ø $D_s$	20 mm
Overall length $L$	131 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	49.8 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
------------------------	-----------

