Garant

# Solid carbide HPC drill, plain shank DIN 6535 HB, TiAlN, ∅ DC h7: 12,2mm

## Order data

| | |
|---|---|
| Order number | 123115 12,2 |
| GTIN | 4045197402097 |
| Item class | 11E |

## Description

**Version:**
Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry.**
Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!
**Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.
**Advantage:**
**High process reliability and surface quality of the hole.**
**Note:**
Flute length $L_C = L_2 + 1.5 \times D_C$.

## Technical description

| | |
|---|---|
| Number of cutting edges Z | 2 |
| Nominal ∅ $D_C$ | 12.2 mm |
| Flute length $L_c$ | 160 mm |
| Shank tolerance | h6 |
| Feed f in stainless steel < 900 N/mm$^2$ | 0.2 mm/rev. |
| Tolerance nominal ∅ | h7 |
| Shank ∅ $D_s$ | 14 mm |
| Overall length L | 208 mm |
| Standard | Manufacturer's standard |

| | |
|---|---|
| recommended maximum drilling depth $L_2$ | 141.7 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 10×D |
| Point angle | 135 degrees |
| Shank | DIN 6535 HB 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 | 200 m/min | N |
| Alu > 10% Si | suitable only under restricted conditions | 180 m/min | N |
| Steel < 500 N/mm² | suitable | 110 m/min | P |
| Steel < 750 N/mm² | suitable | 80 m/min | P |
| Steel < 900 N/mm² | suitable | 70 m/min | P |
| INOX < 900 N/mm² | suitable | 65 m/min | M |
| INOX > 900 N/mm² | suitable | 55 m/min | M |
| Ti > 850 N/mm² | suitable | 25 m/min | S |
| Uni | suitable only under restricted conditions | | |
| wet maximum | suitable | | |
| wet minimum | suitable | | |