⚡ Hoffmann Group

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 11,5mm

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Order data

Order number	123110 11,5
GTIN	4045197357793
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 $L_c = L_2 + 1.5 \times D_c$.
Form HB and HE supplied at the same price as HA.
Form **HB:** order with **No. 123115**.
Form **HE:** order with **No. 123110 + 129100 HE**.

Technical description

Number of cutting edges Z	2
Feed f in stainless steel < 900 N/mm^2	0.15 mm/rev.
Flute length L_c	130 mm
Nominal Ø D_c	11.5 mm
Shank tolerance	h6
Tolerance nominal Ø	h7
Shank Ø D_s	12 mm

Overall length L	180 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	112.8 mm
Coating	TiAlN
Tool material	Solid carbide
Version	10×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	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
wet maximum	suitable		
wet minimum	suitable		

Services

Shank grinding Type HE

129100 HE