

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 3,8



#### Order data

Order number	123212 3,8
GTIN	4045197570154
Item class	11E

#### Description

##### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

##### Note:

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

For process reliability when using the 12×D drill, an initial centre drilling with NC spotting drills No. 121068– 121130 is necessary.

Form HB and HE are supplied at the same price as HA.

Order form **HB**: with **No. 123214**.

Order form **HE**: with **No. 123212 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 58.3 mm

Overall length L: 102 mm

Shank Ø  $D_s$ : 6 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.06 mm/rev.

#### Technical description

Flute length $L_c$	64 mm
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.06 mm/rev.

Number of cutting edges Z	2
Shank tolerance	h6
Nominal $\varnothing D_c$	3.8 mm
Tolerance nominal $\varnothing$	m6
Shank $\varnothing D_s$	6 mm
Overall length L	102 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	58.3 mm
Coating	TiAlN
Tool material	Solid carbide
Version	12xD
Point angle	135 °
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
Steel < 500 N/mm <sup>2</sup>	suitable	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	75 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	55 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	32 m/min	P
INOX < 900 N/mm <sup>2</sup>	suitable	70 m/min	M
INOX > 900 N/mm <sup>2</sup>	suitable	60 m/min	M
wet maximum	suitable		

wet minimum

**Services**

suitable

Shank grinding Type HE

129100 HE