

Garant**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 4,5****Order data**

Order number	123212 4,5
GTIN	4045197570185
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**.

Technical description

Nominal Ø D_c	4.5 mm
Feed f in stainless steel > 900 N/mm ²	0.08 mm/rev.
Number of cutting edges Z	2
Flute length L_c	64 mm
Shank tolerance	h6
Tolerance nominal Ø	m6
Shank Ø D_s	6 mm

Data sheet

Overall length L	102 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L ₂	57.3 mm
Coating	TiAlN
Tool material	Solid carbide
Version	12×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
Steel < 500 N/mm ²	suitable	90 m/min	P
Steel < 750 N/mm ²	suitable	75 m/min	P
Steel < 900 N/mm ²	suitable	70 m/min	P
Steel < 1100 N/mm ²	suitable	55 m/min	P
Steel < 1400 N/mm ²	suitable	32 m/min	P
INOX < 900 N/mm ²	suitable	70 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M
wet maximum	suitable		
wet minimum	suitable		

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/123212-4,5>