

## Garant

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 15,8mm**



### Order data

|              |               |
|--------------|---------------|
| Order number | 123212 15,8   |
| GTIN         | 4045197570499 |
| 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.

#### Recommendation:

##### Maximum drilling depth:

flute length (see table) less 1.5×nominal Ø.

#### 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  $L_2$ : 184.3 mm

Overall length L: 260 mm

Shank Ø  $D_s$ : 16 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.2 mm/rev.

### Technical description

|   |                         |
|---|-------------------------|
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0.2 mm/rev.             |
| Flute length L <sub>c</sub>                       | 208 mm                  |
| Number of cutting edges Z                         | 2                       |
| Nominal Ø D <sub>c</sub>                          | 15.8 mm                 |
| Shank tolerance                                   | h6                      |
| Tolerance nominal Ø                               | m6                      |
| Shank Ø D <sub>s</sub>                            | 16 mm                   |
| Overall length L                                  | 260 mm                  |
| Standard  | Manufacturer's standard |
| recommended maximum drilling depth L <sub>2</sub> | 184.3 mm                |
| Coating   | TiAlN                   |
| Tool material                                     | Solid carbide           |
|   | 12×D                    |
| 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 <sub>c</sub> | 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                  | suitable |          |   |

**Services**

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|