Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, ∅ h7: 9,8 mm

Order data

Order number	123301 9,8
GTIN	4045197452511
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!
Convex 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.
Recommendation:
Maximum drilling depth:
flute length (see table) less 1.5×nominal ∅.
Note:
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.
Form **HB:** order with **No. 123302**.
Form **HE:** order with **No. 123301 + 129100HE**.
NEW GENERATION AVAILABLE!
Recommended successor products are No. 123225 and 123235.
Machining strategy: HPC
Norm: Manufacturer's standard
Tolerance nominal ∅: h7
Number of cutting edges Z: 2
Tolerance nominal ∅: h7
Flute length: 120 mm
Overall length L_{tot}: 162 mm
Shank ∅: 10 mm
Feed f in steel < 1100 N/mm^2: 0.2 mm/rev.

Technical description

Number of cutting edges Z	2
Feed f in steel < 1100 N/mm^2	0.2 mm/rev.
Flute length	120 mm
Nominal ∅	9.8 mm
Shank tolerance	h6
Tolerance nominal ∅	h7
Shank ∅	10 mm
Overall length L_{tot}	162 mm
Norm	Manufacturer's standard
recommended maximum drilling depth	105.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12×D
Point angle	135 degrees
Skaft	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	green

Services

Shank grinding Type HE	129100 HE