

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 6,8mm



Order data

Order number	123301 6,8
GTIN	4045197452429
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.

Note:

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

For process reliability when using the 12xD 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.

Technical description

Nominal Ø D_c	6.8 mm
Number of cutting edges Z	2
Flute length L_c	108 mm
Shank tolerance	h6
Feed f in steel < 1100 N/mm ²	0.15 mm/rev.

Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	8 mm
Overall length L	146 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	97.8 mm
Coating	TiAlN
Tool material	Solid carbide
Version	12xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Aluminium (short chipping)	suitable only under restricted conditions	180 m/min	N
Alu > 10% Si	suitable only under restricted conditions	140 m/min	N
Steel < 500 N/mm ²	suitable only under restricted conditions	110 m/min	P
Steel < 750 N/mm ²	suitable	90 m/min	P
Steel < 900 N/mm ²	suitable	80 m/min	P
Steel < 1100 N/mm ²	suitable	50 m/min	P
Steel < 1400 N/mm ²	suitable	35 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	40 m/min	M

INOX > 900 N/mm ²	suitable only under restricted conditions	35 m/min	M
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		
Services			
Shank grinding Type HE		129100 HE	