Data sheet Hoffmann Group

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, ∅ DC p6: 2,8mm

Order data

Order number	122736 2,8
GTIN	4045197566966
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 ∅ 3.8 mm. Up to 3.7 mm ∅ with 2 internal cooling channels. With **140° point angle** and special **j6 cutting edge tolerance** for optimum generation of a pilot hole.
Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
For deep-hole drilling deeper than 12×D a pilot hole is recommended, and for deep-hole drilling from 20×D to 30×D it is essential.
The generation of a pilot hole improves process reliability.
Form HB and HE supplied at the same price as HA.
Form **HB:** order with **No. 122738**.
Form **HE:** order with **No. 122736 + 129100HE**.

Technical description

Nominal ∅ D_C	2.8 mm
Feed f in steel < 1100 N/mm^2	0.08 mm/rev.
Shank tolerance	h6
Number of cutting edges Z	2
Flute length L_c	21 mm
Tolerance nominal ∅	p6
Shank ∅ D_s	4 mm

Overall length L	57 mm
Standard	DIN 6537
recommended maximum drilling depth L_2	16.8 mm
Coating	TiAlN
Tool material	Solid carbide
Version	6×D
Point angle	140 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
Steel < 500 N/mm^2	suitable	170 m/min	P
Steel < 750 N/mm^2	suitable	130 m/min	P
Steel < 900 N/mm^2	suitable	120 m/min	P
Steel < 1100 N/mm^2	suitable	110 m/min	P
Steel < 1400 N/mm^2	suitable	65 m/min	P
INOX < 900 N/mm^2	suitable	75 m/min	M
INOX > 900 N/mm^2	suitable	70 m/min	M
GG(G)	suitable	95 m/min	K
Uni	suitable		
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		