

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 3,8mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122505 3,8    |
| GTIN         | 4045197391193 |
| Item class   | 11E           |

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry. Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**Note:**

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 122426 and 122436.**

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

**Technical description**

|  |              |
|--|--------------|
| Number of cutting edges Z                | 2            |
| Shank tolerance                          | h6           |
| Flute length $L_c$                       | 24 mm        |
| Nominal $\varnothing D_c$                | 3.8 mm       |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.11 mm/rev. |
| Tolerance nominal $\varnothing$          | h7           |
| Shank $\varnothing D_s$                  | 6 mm         |
| Overall length L                         | 66 mm        |
| Standard                                 | DIN 6537 K   |
| recommended maximum drilling depth $L_2$ | 18.3 mm      |
| Coating                                  | TiAlN        |

|                    |                   |
|--------------------|-------------------|
| Tool material      | Solid carbide     |
| Version            | 4xD               |
| Point angle        | 140 degrees       |
| Shank              | DIN 6535 HB to h6 |
| Through-coolant    | yes, with 25 bar  |
| Machining strategy | HPC               |
| Colour ring        | green             |
| Type of product    | Jobber drill      |

### User data

|                                | Suitability                               | V <sub>c</sub> | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 500 N/mm <sup>2</sup>  | suitable only under restricted conditions | 120 m/min      | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable                                  | 100 m/min      | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable                                  | 85 m/min       | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable                                  | 65 m/min       | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable                                  | 35 m/min       | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable only under restricted conditions | 30 m/min       | M        |
| Ti > 850 N/mm <sup>2</sup>     | suitable only under restricted conditions | 35 m/min       | S        |
| GG(G)                          | suitable                                  | 70 m/min       | K        |
| Uni                            | suitable                                  |                |          |
| wet maximum                    | suitable                                  |                |          |
| wet minimum                    | suitable                                  |                |          |
| Air                            | suitable                                  |                |          |