

Garant
Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 12mm

Order data

Order number	122505 12
GTIN	4045197392176
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
Flute length L_c	55 mm
Nominal Ø D_c	12 mm
Shank tolerance	h6
Feed f in steel < 1100 N/mm ²	0.32 mm/rev.
Tolerance nominal Ø	h7
Shank Ø D_s	12 mm
Overall length L	102 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	37 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 _c	ISO code
Steel < 500 N/mm ²	suitable only under restricted conditions	120 m/min	P
Steel < 750 N/mm ²	suitable	100 m/min	P
Steel < 900 N/mm ²	suitable	85 m/min	P
Steel < 1100 N/mm ²	suitable	65 m/min	P
Steel < 1400 N/mm ²	suitable	35 m/min	P
INOX < 900 N/mm ²	suitable only under restricted conditions	30 m/min	M
Ti > 850 N/mm ²	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		