

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 13,8mm**

**Order data**

Order number	122760 13,8
GTIN	4045197058027
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:**

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

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122765**.

Form **HE**: order with **No. 122760 + 129100HE**.

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 122715; 122725 and 122651.**

**Technical description**

Nominal Ø D <sub>c</sub>	13.8 mm
Number of cutting edges Z	2
Feed f in steel < 1100 N/mm <sup>2</sup>	0.32 mm/rev.
Flute length L <sub>c</sub>	77 mm
Shank tolerance	h6
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	14 mm
Overall length L	124 mm

Standard	DIN 6537
recommended maximum drilling depth L <sub>2</sub>	56.3 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 <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
Steel < 55 HRC	suitable	28 m/min	H
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		
Air	suitable		

## Services

Shank grinding Type HE

129100 HE