

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6: 4,5mm**

**Order data**

Order number	122430 4,5
GTIN	4045197535955
Item class	11E

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. Excellent chip evacuation due to **4 internal coolant channels**. **Straight cutting edges** with honed edges and special flute profile for **short chips**. **Special coating** for the **best tool life** and **high metal removal rates**.

**Recommendation:**
**Maximum drilling depth:**

Flute length (see table) less 1.5×nominal Ø.

**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. 122432**.

Form **HE**: order with **No. 122430 + 129100HE**.

Standard: DIN 6537 K

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 17.3 mm

Overall length L: 66 mm

Shank Ø  $D_s$ : 6 mm

Feed f in Inconel®: 0.04 mm/rev.

**Technical description**

Shank tolerance	h6
Number of cutting edges Z	2

Flute length $L_c$	24 mm
Feed $f$ in Inconel®	0.04 mm/rev.
Nominal $\varnothing D_c$	4.5 mm
Tolerance nominal $\varnothing$	m6
Shank $\varnothing D_s$	6 mm
Overall length $L$	66 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	17.3 mm
Coating	TiAlN
Tool material	Solid carbide
Version	4xD
Point angle	140°
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	pink
Type of product	Jobber drill

## User data

	Suitability	$V_c$	ISO code
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	40 m/min	S
Inconel	suitable	35 m/min	S
wet maximum	suitable		

## Services

Shank grinding Type HE	129100 HE
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