

Garant

Solid carbide NC high performance drill FS, plain shank DIN 6535 HA, TiAlN, Ø DC h7: 9,8mm



Order data

| | |
|--------------|---------------|
| Order number | 122540 9,8 |
| GTIN | 4045197052353 |
| Item class | 11E |

Description

Version:

Particularly strong due to strengthened core and **special profile**. Special point geometry. **High concentricity** and **long tool life**. **High bore quality**.

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. 122545**.

Form **HE**: order with **No. 122540 + 129100HE**.

Technical description

| | |
|--|--------------|
| Number of cutting edges Z | 2 |
| Flute length L_c | 61 mm |
| Nominal $\varnothing D_c$ | 9.8 mm |
| Feed f in steel < 750 N/mm ² | 0.27 mm/rev. |
| Shank tolerance | h6 |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 10 mm |
| Overall length L | 103 mm |
| Standard | DIN 6537 |
| recommended maximum drilling depth L_2 | 46.3 mm |

| | |
|-----------------|-------------------|
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 6xD |
| Type | FS |
| Point angle | 140 degrees |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | no |
| Semi-Standard | yes |
| Colour ring | green |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Alu plastics | suitable | 190 m/min | N |
| Aluminium (short chipping) | suitable | 170 m/min | N |
| Alu > 10% Si | suitable | 140 m/min | N |
| Steel < 500 N/mm ² | suitable | 90 m/min | P |
| Steel < 750 N/mm ² | suitable | 85 m/min | P |
| Steel < 900 N/mm ² | suitable | 75 m/min | P |
| Steel < 1100 N/mm ² | suitable | 65 m/min | P |
| Steel < 1400 N/mm ² | suitable | 40 m/min | P |
| INOX < 900 N/mm ² | suitable only under restricted conditions | 40 m/min | M |
| INOX > 900 N/mm ² | suitable only under restricted conditions | 30 m/min | M |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 25 m/min | S |
| GG(G) | suitable only under restricted conditions | 70 m/min | K |

| | | | |
|------------------------|---|-----------|---|
| CuZn | suitable only under restricted conditions | 160 m/min | N |
| Uni | suitable | | |
| wet maximum | suitable | | |
| dry | suitable | | |
| Services | | | |
| Shank grinding Type HE | | 129100 HE | |