

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6: 6,5mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122430 6,5    |
| GTIN         | 4045197536310 |
| 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  $L_2$ : 24.3 mm

Overall length L: 79 mm

Shank Ø  $D_s$ : 8 mm

Feed f in Inconel®: 0.08 mm/rev.

**Technical description**

|                 |        |
|-----------------|--------|
| Shank tolerance | h6     |
| Nominal Ø $D_c$ | 6.5 mm |

|   |                   |
|---|-------------------|
| Number of cutting edges Z                         | 2                 |
| Feed f in Inconel®                                | 0.08 mm/rev.      |
| Flute length L <sub>c</sub>                       | 34 mm             |
| Tolerance nominal Ø                               | m6                |
| Shank Ø D <sub>s</sub>                            | 8 mm              |
| Overall length L                                  | 79 mm             |
| Standard  | DIN 6537 K        |
| recommended maximum drilling depth L <sub>2</sub> | 24.3 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 <sub>c</sub> | 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 |
|------------------------|-----------|