

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6: 8,4mm



Order data

Order number	122430 8,4
GTIN	4045197537584
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 : 34.4 mm

Overall length L: 89 mm

Shank Ø D_s : 10 mm

Feed f in Inconel®: 0.12 mm/rev.

Technical description

Flute length L_c	47 mm
Shank tolerance	h6

Number of cutting edges Z	2
Nominal $\varnothing D_c$	8.4 mm
Feed f in Inconel®	0.12 mm/rev.
Tolerance nominal \varnothing	m6
Shank $\varnothing D_s$	10 mm
Overall length L	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	34.4 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 ²	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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