

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6: 8,6mm**

**Order data**

Order number	122430 8,6
GTIN	4045197537591
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  $L_2$ : 34.1 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in Inconel®: 0.12 mm/rev.

**Technical description**

Nominal Ø $D_c$	8.6 mm
Shank tolerance	h6

Number of cutting edges Z	2
Feed f in Inconel®	0.12 mm/rev.
Flute length L <sub>c</sub>	47 mm
Tolerance nominal Ø	m6
Shank Ø D <sub>s</sub>	10 mm
Overall length L	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	34.1 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
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