

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6: 9,1mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122430 9,1    |
| GTIN         | 4045197537737 |
| 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  $L_2$ : 33.4 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in Inconel®: 0.12 mm/rev.

**Technical description**

|                           |              |
|---------------------------|--------------|
| Number of cutting edges Z | 2            |
| Feed f in Inconel®        | 0.12 mm/rev. |

|                                          |                   |
|------------------------------------------|-------------------|
| Flute length $L_c$                       | 47 mm             |
| Nominal $\varnothing D_c$                | 9.1 mm            |
| Shank tolerance                          | h6                |
| Tolerance nominal $\varnothing$          | m6                |
| Shank $\varnothing D_s$                  | 10 mm             |
| Overall length L                         | 89 mm             |
| Standard                                 | DIN 6537 K        |
| recommended maximum drilling depth $L_2$ | 33.4 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 <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 |
|------------------------|-----------|