

Garant**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch):
4****Order data**

Order number	123008 4
GTIN	4045197569349
Item class	11E

Description**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

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. 123010**.

Form **HE**: order with **No. 123008 + 129100HE**.

Technical description

Feed f in stainless steel > 900 N/mm ²	0.08 mm/rev.
Number of cutting edges Z	2
Flute length L_c	43 mm
Shank tolerance	h6
Nominal Ø D_c	4 mm
Tolerance nominal Ø	m6
Shank Ø D_s	6 mm
Overall length L	81 mm

Standard	Manufacturer's standard
recommended maximum drilling depth L_2	37 mm
Coating	TiAlN
Tool material	Solid carbide
Version	8×D
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill

User data

	Suitability	V_c	ISO code
Steel < 500 N/mm ²	suitable	90 m/min	P
Steel < 750 N/mm ²	suitable	75 m/min	P
Steel < 900 N/mm ²	suitable	70 m/min	P
Steel < 1100 N/mm ²	suitable	55 m/min	P
Steel < 1400 N/mm ²	suitable	32 m/min	P
INOX < 900 N/mm ²	suitable	70 m/min	M
INOX > 900 N/mm ²	suitable	60 m/min	M
wet maximum	suitable		
wet minimum	suitable		

Suitable products

<https://www.hoffmann-group.com/GB/en/hom/p/123008-4>