

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 13,5



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123008 13,5   |
| GTIN         | 4045197569936 |
| 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.

##### Recommendation:

##### Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

##### Note:

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 123010**.

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

Flute length  $L_c = L_2 + 1.5 \times D_c$ .

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 110.8 mm

Overall length L: 178 mm

Shank Ø  $D_s$ : 14 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.2 mm/rev.

#### Technical description

|                 |    |
|-----------------|----|
| Shank tolerance | h6 |
|-----------------|----|

|   |                         |
|---|-------------------------|
| Nominal $\varnothing D_c$                         | 13.5 mm                 |
| Number of cutting edges Z                         | 2                       |
| Flute length $L_c$                                | 131 mm                  |
| Feed f in stainless steel > 900 N/mm <sup>2</sup> | 0.2 mm/rev.             |
| Tolerance nominal $\varnothing$                   | m6                      |
| Shank $\varnothing D_s$                           | 14 mm                   |
| Overall length L                                  | 178 mm                  |
| Standard  | Manufacturer's standard |
| recommended maximum drilling depth $L_2$          | 110.8 mm                |
| Coating   | TiAlN                   |
| Tool material                                     | Solid carbide           |
|   | 8xD                     |
| Point angle                                       | 140°                    |
| 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 <sup>2</sup>  | suitable    | 90 m/min | P        |
| Steel < 750 N/mm <sup>2</sup>  | suitable    | 75 m/min | P        |
| Steel < 900 N/mm <sup>2</sup>  | suitable    | 70 m/min | P        |
| Steel < 1100 N/mm <sup>2</sup> | suitable    | 55 m/min | P        |
| Steel < 1400 N/mm <sup>2</sup> | suitable    | 32 m/min | P        |
| INOX < 900 N/mm <sup>2</sup>   | suitable    | 70 m/min | M        |
| INOX > 900 N/mm <sup>2</sup>   | suitable    | 60 m/min | M        |

|             |          |
|-------------|----------|
| wet maximum | suitable |
| wet minimum | suitable |

**Services**

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|