

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6: 11,8mm

Order data

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|--------------|---------------|
| Order number | 122430 11,8 |
| GTIN | 4045197536570 |
| 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 : 37.3 mm

Overall length L: 102 mm

Shank Ø D_s : 12 mm

Feed f in Inconel®: 0.12 mm/rev.

Technical description

| | |
|--------------------|--------------|
| Nominal Ø D_c | 11.8 mm |
| Feed f in Inconel® | 0.12 mm/rev. |

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|---|-------------------|
| Number of cutting edges Z | 2 |
| Flute length L _c | 55 mm |
| Shank tolerance | h6 |
| Tolerance nominal Ø | m6 |
| Shank Ø D _s | 12 mm |
| Overall length L | 102 mm |
| Standard | DIN 6537 K |
| recommended maximum drilling depth L ₂ | 37.3 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

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