

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 1mm

Order data

| | |
|--------------|---------------|
| Order number | 122440 1 |
| GTIN | 4045197047700 |
| Item class | 11E |

Description
Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry. Convex 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. 122445/122505**.

Form **HE**: order with **No. 122440/122500** and **129100HE**.

NEW GENERATION AVAILABLE!

Recommended successor products are No. 122415; 122425; 122435 and 122361, as well as 122371.

Technical description

| | |
|---|--------------|
| Feed f in steel $< 1100 \text{ N/mm}^2$ | 0.03 mm/rev. |
| Flute length L_c | 7 mm |
| Shank tolerance | h6 |
| Nominal $\varnothing D_c$ | 1 mm |
| Number of cutting edges Z | 2 |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 4 mm |
| Overall length L | 45 mm |

| | |
|---|-------------------|
| Standard | DIN 6537 K |
| recommended maximum drilling depth L ₂ | 5.5 mm |
| Coating | TiAlN |
| Tool material | Solid carbide |
| Version | 4×D |
| Point angle | 140 degrees |
| Shank | DIN 6535 HA to h6 |
| Through-coolant | no |
| Machining strategy | HPC |
| Semi-Standard | yes |
| Colour ring | green |
| Type of product | Jobber drill |

User data

| | Suitability | V _c | ISO code |
|--------------------------------|---|----------------|----------|
| Steel < 500 N/mm ² | suitable only under restricted conditions | 90 m/min | P |
| Steel < 750 N/mm ² | suitable | 80 m/min | P |
| Steel < 900 N/mm ² | suitable | 70 m/min | P |
| Steel < 1100 N/mm ² | suitable | 65 m/min | P |
| Steel < 1400 N/mm ² | suitable | 35 m/min | P |
| Ti > 850 N/mm ² | suitable only under restricted conditions | 35 m/min | S |
| GG(G) | suitable | 70 m/min | K |
| Uni | suitable | | |
| wet maximum | suitable | | |
| dry | suitable | | |