

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 1,9mm**

**Order data**

Order number	122440 1,9
GTIN	4045197047793
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**

Shank tolerance	h6
Number of cutting edges Z	2
Feed f in steel < 1100 N/mm <sup>2</sup>	0.05 mm/rev.
Nominal Ø D <sub>c</sub>	1.9 mm
Flute length L <sub>c</sub>	14 mm
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	4 mm
Overall length L	55 mm

Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	11.2 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 <sub>c</sub>	ISO code
Steel < 500 N/mm <sup>2</sup>	suitable only under restricted conditions	90 m/min	P
Steel < 750 N/mm <sup>2</sup>	suitable	80 m/min	P
Steel < 900 N/mm <sup>2</sup>	suitable	70 m/min	P
Steel < 1100 N/mm <sup>2</sup>	suitable	65 m/min	P
Steel < 1400 N/mm <sup>2</sup>	suitable	35 m/min	P
Ti > 850 N/mm <sup>2</sup>	suitable only under restricted conditions	35 m/min	S
GG(G)	suitable	70 m/min	K
Uni	suitable		
wet maximum	suitable		
dry	suitable		