

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 6,1mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122440 6,1    |
| GTIN         | 4045197048219 |
| 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 N/mm <sup>2</sup> | 0.2 mm/rev. |
| Shank tolerance                          | h6          |
| Flute length $L_c$                       | 34 mm       |
| Nominal Ø $D_c$                          | 6.1 mm      |
| Number of cutting edges Z                | 2           |
| Tolerance nominal Ø                      | h7          |
| Shank Ø $D_s$                            | 8 mm        |
| Overall length L                         | 79 mm       |

|   |                   |
|---|-------------------|
| Standard  | DIN 6537 K        |
| recommended maximum drilling depth L <sub>2</sub> | 24.9 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                                  |                |          |

## Services

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

