

Garant**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 8,4mm**

Order data

Order number	122440 8,4
GTIN	4045197048448
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

Flute length L_c	47 mm
Shank tolerance	h6
Number of cutting edges Z	2
Nominal Ø D_c	8.4 mm
Feed f in steel < 1100 N/mm ²	0.2 mm/rev.
Tolerance nominal Ø	h7
Shank Ø D_s	10 mm
Overall length L	89 mm

Standard	DIN 6537 K
recommended maximum drilling depth L ₂	34.4 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		

Services

Shank grinding Type HE	129100 HE
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