

Garant

Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 4,2mm



Order data

Order number	122445 4,2
GTIN	4045197389619
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 $L_c = L_2 + 1.5 \times D_c$.

NEW GENERATION AVAILABLE!

Recommended successor product is No. 122416.

Technical description

Nominal Ø D_c	4.2 mm
Feed f in steel $< 1100 \text{ N/mm}^2$	0.15 mm/rev.
Shank tolerance	h6
Flute length L_c	24 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Shank Ø D_s	6 mm
Overall length L	66 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	17.7 mm
Coating	TiAlN

Tool material	Solid carbide
Version	4×D
Point angle	140 degrees
Shank	DIN 6535 HB to h6
Through-coolant	no
Machining strategy	HPC
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		