Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 12,06-Xmm

Order data

Order number	122380 12,06-X
GTIN	4062406076788
Item class	11E

Description

Version:
Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry. Straight major cutting edges** with slightly honed edges and special flute profile produce **short chips.**
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. 122385**.
Form **HE:** order with **No. 122380 + 12900H**E. Delivery time: 12 working weeks
Minimum order quantity: 3 pcs
Items made to order for a specific customer:
Cancellation only up to a maximum of 3 working days after receipt of order acknowledgement. Items cannot be returned. We reserve the right to over-deliver or under-deliver by ±10% (minimum 1 piece).

Technical description

Standard	DIN 6537 K
Feed f in stainless steel < 900 N/mm^2	0.18 mm/rev.
Shank Ø D_s	14 mm
Overall length L	107 mm
Number of cutting edges Z	2
Tolerance nominal Ø	h7
Flute length L_c	60 mm

∅ range	12.06 - 14.05 mm
Coating	TiAlN
Tool material	Solid carbide
Version	4×D
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill

User data

	Suitability	**V_c**	**ISO code**
Aluminium (short chipping)	suitable only under restricted conditions	245 m/min	N
Steel < 500 N/mm^2	suitable	110 m/min	P
Steel < 750 N/mm^2	suitable	90 m/min	P
Steel < 900 N/mm^2	suitable	85 m/min	P
Steel < 1100 N/mm^2	suitable	60 m/min	P
Steel < 1400 N/mm^2	suitable only under restricted conditions	35 m/min	P
INOX < 900 N/mm^2	suitable	55 m/min	M
INOX > 900 N/mm^2	suitable	50 m/min	M
Ti > 850 N/mm^2	suitable	35 m/min	S
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		