

Garant

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (Ø DC X = h7)
(mm or inch): 12,02-X**



Order data

Order number	122659 12,02-X
GTIN	4062406078836
Item class	11E

Description

IMPORTANT: item is configurable

Ø range: 12.03 - 14.02 mm, Intervall: 0,010

Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

Attention:

Sizes **ending with X** = cutter Ø tolerance **h7**.

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. 122661**.

Form **HE**: order with **No. 122659 + 129100HE**. 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 $\pm 10\%$ (minimum 1 piece).

Standard: DIN 6537

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

Overall length L: 124 mm

Shank Ø D_s : 14 mm

Feed f in stainless steel > 900 N/mm²: 0.15 mm/rev.

Technical description

Number of cutting edges Z	2
Shank $\varnothing D_s$	14 mm
Feed f in stainless steel > 900 N/mm ²	0.15 mm/rev.
Overall length L	124 mm
Tolerance nominal \varnothing	m6
Standard	DIN 6537
Flute length L _c	77 mm
\varnothing range	12.03 - 14.02 mm
Coating	TiAlN
Tool material	Solid carbide
Version	6xD
Point angle	140°
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
Steel < 500 N/mm ²	suitable	170 m/min	P
Steel < 750 N/mm ²	suitable	140 m/min	P
Steel < 900 N/mm ²	suitable	130 m/min	P
Steel < 1100 N/mm ²	suitable	110 m/min	P
Steel < 1400 N/mm ²	suitable	70 m/min	P

INOX < 900 N/mm ²	suitable	90 m/min	M
INOX > 900 N/mm ²	suitable	80 m/min	M
GG(G)	suitable	95 m/min	K
wet maximum	suitable		
wet minimum	suitable		
Air	suitable		