

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 1/4



Order data

Order number	123212 1/4
GTIN	4062406116224
Item class	11E

Description

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.

Note:

Flute length $L_c = L_2 + 1.5 \times D_c$.

For process reliability when using the 12×D drill, an initial centre drilling with NC spotting drills No. 121068– 121130 is necessary.

Form HB and HE are supplied at the same price as HA.

Order form **HB**: with **No. 123214**.

Order form **HE**: with **No. 123212 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth L_2 : 69 mm

Overall length L: 146 mm

Shank Ø D_s : 8 mm

Feed f in stainless steel > 900 N/mm²: 0.12 mm/rev.

Technical description

Flute length L_c	108 mm
Standard	Manufacturer's standard

recommended maximum drilling depth L_2	69 mm
Feed f in stainless steel $> 900 \text{ N/mm}^2$	0.12 mm/rev.
Number of cutting edges Z	2
Shank $\varnothing D_s$	8 mm
Tolerance nominal \varnothing	m6
Shank tolerance	h6
Overall length L	146 mm
Inch nominal \varnothing corresponds to	6.35 mm
Coating	TiAlN
Tool material	Solid carbide
Version	12xD
Point angle	135 °
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 $< 500 \text{ N/mm}^2$	suitable	90 m/min	P
Steel $< 750 \text{ N/mm}^2$	suitable	75 m/min	P
Steel $< 900 \text{ N/mm}^2$	suitable	70 m/min	P
Steel $< 1100 \text{ N/mm}^2$	suitable	55 m/min	P
Steel $< 1400 \text{ N/mm}^2$	suitable	32 m/min	P
INOX $< 900 \text{ N/mm}^2$	suitable	70 m/min	M
INOX $> 900 \text{ N/mm}^2$	suitable	60 m/min	M
wet maximum	suitable		

wet minimum

Services

suitable

Shank grinding Type HE

129100 HE