

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 1,8 mm**

**Order data**

Order number	122440 1,8
GTIN	4045197047786
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.

**Recommendation:**
**Maximum drilling depth:**

clamping slot length (see table) less  $1.5 \times \text{nominal } \varnothing$ .

**Note:**

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**.

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

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 122415; 122425; 122435 and 122361, as well as 122371.**

Standard: DIN 6537 K

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 11.3 mm

Overall length L: 55 mm

Shank  $\varnothing D_s$ : 4 mm

Feed f in steel  $< 1100 \text{ N/mm}^2$ : 0.05 mm/rev.

**Technical description**

Flute length $L_c$	14 mm
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Nominal $\varnothing D_c$	1.8 mm
Shank tolerance	h6
Feed f in steel < 1100 N/mm <sup>2</sup>	0.05 mm/rev.
Number of cutting edges Z	2
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	4 mm
Overall length L	55 mm
Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	11.3 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
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