Garant

Solid carbide drill plain shank DIN 6535 HA 180°, TiAlN, ⌀ DC m7: 4,65 mm



Order data

Order number	122506 4,65
GTIN	4062406090012
Item class	11E

Description

Version:
Special point geometry for generating **180° flat-bottomed holes.** Low radial forces even when spot drilling on faces with up to 45° slope. Flute geometry for optimum chip evacuation. With 4 guide chamfers to stabilise the drill in the hole.
Advantage:
The 180° point angle permits drilling and counterboring in a single operation.
Recommendation:
When using the solid carbide 180° drill it is absolutely essential for process reliability:
- **when spot drilling on flat surfaces to drill a pilot hole 1×D using pilot drill No. 122736.**
- **when spot drilling on sloping surfaces up to 15° : reduce the feed rate f to 50 %, up to 30°: reduce the feed rate f to 40 % and up to 45°: reduce the feed rate f to 25 % of the stated value. After spot drilling, the normal feed rate value can be used.**

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. 122506 + 129100HB** .
Form **HE:** order with **No. 122506 + 129100HE**.
180° solid carbide drills for machining aluminium available on request.
Not suitable for generating counterbores for socket-head screws to DIN974-1.
Standard: Manufacturer's standard
Tolerance nominal ⌀: m7
Number of cutting edges Z: 2
Semi-Standard: yes
Tolerance nominal ⌀: m7
recommended maximum drilling depth L_2: 17 mm
Overall length L: 66 mm
Shank ⌀ D_s: 6 mm
Feed f in steel < 900 N/mm^2: 0.08 mm/rev.

Technical description

Standard	Manufacturer's standard
Feed f in steel < 900 N/mm^2	0.08 mm/rev.
Shank tolerance	h6
Overall length L	66 mm
Shank ⌀ D_s	6 mm
Tolerance nominal ⌀	m7
Number of cutting edges Z	2
Flute length L_c	24 mm
Nominal ⌀ D_C	4.65 mm
recommended maximum drilling depth L_2	17 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	3×D
Point angle	180 degrees
Shank	DIN 6535 HA to h6
Use for drilling	limited convexity
Use for drilling	limited cross-drilling
Use for drilling	limited oblique spot drilling
Through-coolant	yes, with 25 bar
Pilot drill required	yes, pilot drill
Colour ring	green
Type of product	Jobber drill

Services

Shank grinding Type HB	129100 HB
Shank grinding Type HE	129100 HE