

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6: 12,7 mm or inch



#### Order data

Order number	123008 12,7
GTIN	4062406116095
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.

##### Recommendation:

##### Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

##### Note:

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

Form **HB**: order with **No. 123010**.

Form **HE**: order with **No. 123008 + 129100HE**.

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

Machining strategy: HPC

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 112 mm

Overall length L: 178 mm

Shank Ø  $D_s$ : 14 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.2 mm/rev.

#### Technical description

Overall length L	178 mm
Number of cutting edges Z	2
Shank $\varnothing D_s$	14 mm
Flute length $L_c$	131 mm
Inch nominal $\varnothing$ corresponds to	12.7 mm
Shank tolerance	h6
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.2 mm/rev.
Standard	Manufacturer's standard
Tolerance nominal $\varnothing$	m6
recommended maximum drilling depth $L_2$	112 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	8xD
Point angle	140 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	blue
Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
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