Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, ∅ DC m6: 3/8 mm or inch

Order data

Order number	123212 3/8
GTIN	4062406116316
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 ∅ 3.8 mm. Up to 3.7 mm ∅ 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 ∅.
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**.
Machining strategy: HPC
Standard: Manufacturer's standard
Tolerance nominal ∅: m6
Number of cutting edges Z: 2
Semi-Standard: yes
Tolerance nominal ∅: m6
recommended maximum drilling depth L_2: 105.3 mm
Overall length L: 162 mm
Shank ∅ D_s: 10 mm
Feed f in stainless steel > 900 N/mm^2: 0.15 mm/rev.

Technical description

Flute length L_c	120 mm
Standard	Manufacturer's standard
Shank ⌀ D_s	10 mm
Inch nominal ⌀ corresponds to	9.53 mm
Shank tolerance	h6
Overall length L	162 mm
recommended maximum drilling depth L_2	105.3 mm
Number of cutting edges Z	2
Feed f in stainless steel > 900 N/mm^2	0.15 mm/rev.
Tolerance nominal ⌀	m6
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12×D
Point angle	135 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