

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6: 5/16 mm or inch**

**Order data**

Order number	123212 5/16
GTIN	4062406116293
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:**

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 Ø: m6

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 96.3 mm

Overall length L: 146 mm

Shank Ø  $D_s$ : 8 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.12 mm/rev.

## Technical description

Shank $\varnothing D_s$	8 mm
Overall length L	146 mm
Tolerance nominal $\varnothing$	m6
recommended maximum drilling depth $L_2$	96.3 mm
Shank tolerance	h6
Number of cutting edges Z	2
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.12 mm/rev.
Inch nominal $\varnothing$ corresponds to	7.94 mm
Flute length $L_c$	108 mm
Standard	Manufacturer's standard
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12xD
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
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