

## Garant

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



#### Order data

Order number	123214 12,7
GTIN	4062406121297
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:

clamping slot 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 No. 121068 – 121130 is necessary.

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  $L_2$ : 162.95 mm

Overall length L: 230 mm

Shank Ø  $D_s$ : 14 mm

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

#### Technical description

Standard	Manufacturer's standard
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Overall length L	230 mm
recommended maximum drilling depth L <sub>2</sub>	162.95 mm
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.2 mm/rev.
Tolerance nominal Ø	m6
Nominal Ø D <sub>c</sub>	12.7 mm
Number of cutting edges Z	2
Flute length L <sub>c</sub>	182 mm
Shank Ø D <sub>s</sub>	14 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12xD
Point angle	135 degrees
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	blue
Type of product	Jobber drill