

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 13,8 mm

Order data

Order number	122380 13,8
GTIN	4045197046062
Item class	11E

Description
Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. **Straight major cutting edges** with slightly honed edges and special flute profile produce **short chips**.

Recommendation:
Maximum drilling depth:

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

Note:

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

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

Form **HB**: order with **No. 122385**.

Form **HE**: order with **No. 122380 + 12900HE**.

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 39.3 mm

Overall length L: 107 mm

Shank Ø D_s : 14 mm

Feed f in stainless steel < 900 N/mm²: 0.18 mm/rev.

Technical description

Feed f in stainless steel < 900 N/mm ²	0.18 mm/rev.
Flute length L_c	60 mm

Nominal $\varnothing D_c$	13.8 mm
Shank tolerance	h6
Number of cutting edges Z	2
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	14 mm
Overall length L	107 mm
Standard	DIN 6537 K
recommended maximum drilling depth L_2	39.3 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4xD
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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