

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 3,9 mm**

**Order data**

Order number	122380 3,9
GTIN	4045197045379
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

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 18.2 mm

Overall length L: 66 mm

Shank Ø  $D_s$ : 6 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.09 mm/rev.

**Technical description**

Number of cutting edges Z	2
Shank tolerance	h6
Flute length $L_c$	24 mm

Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.09 mm/rev.
Nominal Ø D <sub>c</sub>	3.9 mm
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	6 mm
Overall length L	66 mm
Standard	DIN 6537 K
recommended maximum drilling depth L <sub>2</sub>	18.2 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	4×D
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
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