

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 9,8 mm**

**Order data**

Order number	122380 9,8
GTIN	4045197045904
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  $L_2$ : 32.3 mm

Overall length L: 89 mm

Shank Ø  $D_s$ : 10 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.15 mm/rev.

**Technical description**

Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.15 mm/rev.
Number of cutting edges Z	2
Flute length $L_c$	47 mm

Nominal $\varnothing D_c$	9.8 mm
Shank tolerance	h6
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	10 mm
Overall length L	89 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	32.3 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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