

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6: 4 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122430 4      |
| GTIN         | 4045197535900 |
| Item class   | 11E           |

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. Excellent chip evacuation due to **4 internal coolant channels**. **Straight cutting edges** with honed edges and special flute profile for **short chips**. **Special coating** for the **best tool life** and **high metal removal rates**.

**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. 122432**.

Form **HE**: order with **No. 122430 + 129100HE**.

Standard: DIN 6537 K

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 18 mm

Overall length L: 66 mm

Shank Ø  $D_s$ : 6 mm

Feed f in Inconel®: 0.04 mm/rev.

**Technical description**

|                 |      |
|-----------------|------|
| Nominal Ø $D_c$ | 4 mm |
| Shank tolerance | h6   |

|  |                   |
|--|-------------------|
| Flute length $L_c$                       | 24 mm             |
| Feed $f$ in Inconel®                     | 0.04 mm/rev.      |
| Number of cutting edges $Z$              | 2                 |
| Tolerance nominal $\varnothing$          | m6                |
| Shank $\varnothing D_s$                  | 6 mm              |
| Overall length $L$                       | 66 mm             |
| Standard                                 | DIN 6537 K        |
| recommended maximum drilling depth $L_2$ | 18 mm             |
| Coating                                  | TiAlN             |
| Tool material                            | Solid carbide     |
| Drill depth up to                        | 4xD               |
| Point angle                              | 140 degrees       |
| Shank                                    | DIN 6535 HA to h6 |
| Through-coolant                          | yes, with 25 bar  |
| Machining strategy                       | HPC               |
| Semi-Standard                            | yes               |
| Colour ring                              | pink              |
| Type of product                          | Jobber drill      |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|