

Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6: 8,1 mm



Order data

| | |
|--------------|---------------|
| Order number | 122430 8,1 |
| GTIN | 4045197537553 |
| 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 : 34.9 mm

Overall length L: 89 mm

Shank Ø D_s : 10 mm

Feed f in Inconel®: 0.12 mm/rev.

Technical description

| | |
|---------------------------|-------|
| Number of cutting edges Z | 2 |
| Flute length L_c | 47 mm |

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|--|-------------------|
| Nominal $\varnothing D_c$ | 8.1 mm |
| Shank tolerance | h6 |
| Feed f in Inconel® | 0.12 mm/rev. |
| Tolerance nominal \varnothing | m6 |
| Shank $\varnothing D_s$ | 10 mm |
| Overall length L | 89 mm |
| Standard | DIN 6537 K |
| recommended maximum drilling depth L_2 | 34.9 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

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