

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 4,1 mm



#### Order data

|              |               |
|--------------|---------------|
| Order number | 122440 4,1    |
| GTIN         | 4045197048011 |
| Item class   | 11E           |

#### Description

##### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry. Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

##### Recommendation:

##### Maximum drilling depth:

clamping slot length (see table) less  $1.5 \times \text{nominal } \varnothing$ .

##### Note:

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

Form **HB**: order with **No. 122445/122505**.

Form **HE**: order with **No. 122440/122500** and **129100HE**.

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

##### **NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 122415; 122425; 122435 and 122361, as well as 122371.**

Standard: DIN 6537 K

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 17.9 mm

Overall length L: 66 mm

Shank  $\varnothing D_s$ : 6 mm

Feed f in steel  $< 1100 \text{ N/mm}^2$ : 0.15 mm/rev.

#### Technical description

|                 |    |
|-----------------|----|
| Shank tolerance | h6 |
|-----------------|----|

|   |                   |
|---|-------------------|
| Number of cutting edges Z                         | 2                 |
| Feed f in steel < 1100 N/mm <sup>2</sup>          | 0.15 mm/rev.      |
| Nominal Ø D <sub>c</sub>                          | 4.1 mm            |
| Flute length L <sub>c</sub>                       | 24 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> | 17.9 mm           |
| Coating   | TiAlN             |
| Tool material                                     | Solid carbide     |
| Drill depth up to                                 | 4×D               |
| Point angle                                       | 140 degrees       |
| Shank   | DIN 6535 HA to h6 |
| Through-coolant                                   | no                |
| Machining strategy                                | HPC               |
| Semi-Standard                                     | yes               |
| Colour ring                                       | green             |
| Type of product                                   | Jobber drill      |

## Services

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