

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 6,4 mm**


## Order data

Order number	122440 6,4
GTIN	4045197048240
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.**

Machining strategy: HPC

Standard: DIN 6537 K

Tolerance nominal  $\varnothing$ : h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal  $\varnothing$ : h7

recommended maximum drilling depth  $L_2$ : 24.4 mm

Overall length L: 79 mm

Shank  $\varnothing D_s$ : 8 mm

Feed f in steel  $< 1100 \text{ N/mm}^2$ : 0.2 mm/rev.

## Technical description

Flute length $L_c$	34 mm
Nominal $\varnothing D_c$	6.4 mm
Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.2 mm/rev.
Shank tolerance	h6
Number of cutting edges $Z$	2
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	8 mm
Overall length $L$	79 mm
Standard	DIN 6537 K
recommended maximum drilling depth $L_2$	24.4 mm
Semi-Standard	yes
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
Colour ring	green
Type of product	Jobber drill

## Services

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