

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 4,2 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 122445 4,2    |
| GTIN         | 4045197389619 |
| 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×nominal Ø.

**Note:**

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

**NEW GENERATION AVAILABLE!**

**Recommended successor product is No. 122416.**

Machining strategy: HPC

Standard: DIN 6537 K

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 17.7 mm

Overall length L: 66 mm

Shank Ø  $D_s$ : 6 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.15 mm/rev.

**Technical description**

|  |              |
|--|--------------|
| Nominal Ø $D_c$                          | 4.2 mm       |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.15 mm/rev. |
| Shank tolerance                          | h6           |

|  |                   |
|--|-------------------|
| Flute length $L_c$                       | 24 mm             |
| Number of cutting edges Z                | 2                 |
| Tolerance nominal $\varnothing$          | h7                |
| Shank $\varnothing D_s$                  | 6 mm              |
| Overall length L                         | 66 mm             |
| Standard                                 | DIN 6537 K        |
| recommended maximum drilling depth $L_2$ | 17.7 mm           |
| Coating                                  | TiAlN             |
| Tool material                            | Solid carbide     |
| Drill depth up to                        | 4×D               |
| Point angle                              | 140 degrees       |
| Shank                                    | DIN 6535 HB to h6 |
| Through-coolant                          | no                |
| Machining strategy                       | HPC               |
| Colour ring                              | green             |
| Type of product                          | Jobber drill      |