

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

**Order data**

Order number	122445 4
GTIN	4045197389497
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  $L_2$ : 18 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**

Number of cutting edges Z	2
Nominal Ø $D_c$	4 mm
Shank tolerance	h6

Feed f in steel < 1100 N/mm <sup>2</sup>	0.15 mm/rev.
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>	18 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