

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 9,8 mm

Order data

| | |
|--------------|---------------|
| Order number | 122500 9,8 |
| GTIN | 4045197050595 |
| 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 : 32.3 mm

Overall length L: 89 mm

Shank $\varnothing D_s$: 10 mm

Feed f in steel $< 1100 \text{ N/mm}^2$: 0.27 mm/rev.

Technical description

| | |
|--------------------|-------|
| Flute length L_c | 47 mm |
|--------------------|-------|

| | |
|---|-------------------|
| Nominal $\varnothing D_c$ | 9.8 mm |
| Feed f in steel < 1100 N/mm ² | 0.27 mm/rev. |
| Number of cutting edges Z | 2 |
| Shank tolerance | h6 |
| Tolerance nominal \varnothing | h7 |
| Shank $\varnothing D_s$ | 10 mm |
| Overall length L | 89 mm |
| Standard | DIN 6537 K |
| recommended maximum drilling depth L ₂ | 32.3 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 | green |
| Type of product | Jobber drill |

Services

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