Garant

Solid carbide drill plain shank DIN 6535 HA 180°, TiAlN, Ø DC m7: 13 mm

Order data

Order number	122506 13
GTIN	4045197744487
Item class	11E

Description

Version:
Special point geometry for generating **180° flat-bottomed holes.** Low radial forces even when spot drilling on faces with up to 45° slope. Flute geometry for optimum chip evacuation. With 4 guide chamfers to stabilise the drill in the hole.
Advantage:
The 180° point angle permits drilling and counterboring in a single operation.
Recommendation:
When using the solid carbide 180° drill it is absolutely essential for process reliability:

- **when spot drilling on flat surfaces to drill a pilot hole 1×D using pilot drill No. 122736.**
- **when spot drilling on sloping surfaces up to 15° : reduce the feed rate f to 50 %, up to 30°: reduce the feed rate f to 40 % and up to 45°: reduce the feed rate f to 25 % of the stated value. After spot drilling, the normal feed rate value can be used.**

Note:
Flute length $L_C = L_2 + 1.5 \times D_C$.
Form HB and HE supplied at the same price as HA.
Form **HB:** order with **No. 122506 + 129100HB** .
Form **HE:** order with **No. 122506 + 129100HE**.
180° solid carbide drills for machining aluminium available on request.
Not suitable for generating counterbores for socket-head screws to DIN974-1.
Standard: Manufacturer’s standard
Tolerance nominal Ø: m7
Number of cutting edges Z: 2
Tolerance nominal Ø: m7
recommended maximum drilling depth L_2: 38.5 mm
Overall length L: 105 mm
Shank Ø D_s: 14 mm
Feed f in steel < 900 N/mm^2: 0.16 mm/rev.

Technical description

Flute length L_c	58 mm
Overall length L	105 mm
Tolerance nominal ⌀	m7
Nominal ⌀ D_C	13 mm
Shank ⌀ D_s	14 mm
Standard	Manufacturer’s standard
Feed f in steel < 900 N/mm^2	0.16 mm/rev.
Shank tolerance	h6
Number of cutting edges Z	2
recommended maximum drilling depth L_2	38.5 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	3×D
Point angle	180 degrees
Shank	DIN 6535 HA to h6
Use for drilling	limited convexity
Use for drilling	limited cross-drilling
Use for drilling	limited oblique spot drilling
Through-coolant	yes, with 25 bar
Pilot drill required	yes, pilot drill
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

Services

Shank grinding Type HB	129100 HB
Shank grinding Type HE	129100 HE