

Garant

Solid carbide drill IC plain shank unidirectional DIN 6535 HA, Diamond, Ø DC m7: 12 mm



Order data

Order number	122532 12
GTIN	4045197506955
Item class	11Y

Description

Version:

With the latest generation of **crystalline diamond coating sp³**, for process reliability in machining **fibre-reinforced composites, CRP, GRP, and graphite. With 90° point angle** and special geometry to **avoid delamination.**

Under optimum conditions of use, the **double flute face** can generate high precision holes (**roundness < 15 µm to base tolerance IT 7**). Low heat generation due to **internal cooling** permits **higher speeds and feeds.**

Recommendation:

Maximum drilling depth:

Flute length (see table) less 1.5×nominal Ø.

Note:

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

Available in **1/100 sizes** and according to the table.

Tolerance nominal Ø: m7

Number of cutting edges Z: 2

recommended maximum drilling depth L_2 : 53 mm

Overall length L: 118 mm

Shank Ø D_s : 12 mm

Feed f in GRP CRP: 0.21 mm/rev.

Technical description

Flute length L_c	71 mm
Shank tolerance	h6
Number of cutting edges Z	2

Nominal $\varnothing D_c$	12 mm
Feed f in GRP CRP	0.21 mm/rev.
Tolerance nominal \varnothing	m7
Shank $\varnothing D_s$	12 mm
Overall length L	118 mm
recommended maximum drilling depth L_2	53 mm
Coating	Diamond
Tool material	Solid carbide
Standard	Manufacturer's standard
Drill depth up to	5×D
Point angle	90 degrees
Cutting direction	right-hand
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Colour ring	black
Type of product	Jobber drill