

## Garant

### Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 12 mm



#### Order data

Order number	122690 12
GTIN	4045197597205
Item class	11E

#### Description

##### Version:

**3 guide chamfers** for particularly high accuracy and surface quality at tight hole tolerances.  
**Asymmetrical tip geometry** for **very high metal removal rates**. New generation of **innovative high-performance drills for cast iron** in the HPC field.

##### Advantage:

For HPC high performance drilling in castings. **Outstandingly suitable for bainite cast iron (ADI)**.

##### Recommendation:

##### Maximum drilling depth:

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

##### Note:

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

Form HB and HE supplied at the same price as HA.

Form **HB**: order with **No. 122690 + 129100HB** .

Form **HE**: order with **No. 122690 + 129100HE**.

Standard: DIN 6537

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 53 mm

Overall length L: 118 mm

Shank Ø  $D_s$ : 12 mm

Feed f in GJS ADI > 800 N/mm<sup>2</sup>: 0.35 mm/rev.

#### Technical description

Feed f in GJS ADI > 800 N/mm <sup>2</sup>	0.35 mm/rev.
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Nominal $\varnothing D_c$	12 mm
Shank tolerance	h6
Flute length $L_c$	71 mm
Number of cutting edges Z	2
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	12 mm
Overall length L	118 mm
Standard	DIN 6537
recommended maximum drilling depth $L_2$	53 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	6xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	white
Type of product	Jobber drill

## Services

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