

**Garant**
**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 14,5 mm**

**Order data**

|              |               |
|--------------|---------------|
| Order number | 123101 14,5   |
| GTIN         | 4045197452122 |
| Item class   | 11E           |

**Description**
**Version:**

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**.

Particularly high alignment accuracy due to **4 guide chamfers** which stabilise the drill even at extreme depths!

**Convex cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

**Advantage:**

**High process reliability and surface quality of the hole.**

**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. 123102**.

Form **HE**: order with **No. 123101 + 129100 HE**.

**NEW GENERATION AVAILABLE!**

**Recommended successor products are No. 123025 and 123035.**

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 130.3 mm

Overall length L: 203 mm

Shank Ø  $D_s$ : 16 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.26 mm/rev.

## Technical description

|  |                         |
|--|-------------------------|
| Nominal $\varnothing D_c$                | 14.5 mm                 |
| Shank tolerance                          | h6                      |
| Number of cutting edges Z                | 2                       |
| Feed f in steel < 1100 N/mm <sup>2</sup> | 0.26 mm/rev.            |
| Flute length $L_c$                       | 152 mm                  |
| Tolerance nominal $\varnothing$          | h7                      |
| Shank $\varnothing D_s$                  | 16 mm                   |
| Overall length L                         | 203 mm                  |
| Standard                                 | Manufacturer's standard |
| recommended maximum drilling depth $L_2$ | 130.3 mm                |
| Coating                                  | TiAlN                   |
| Tool material                            | Solid carbide           |
| Drill depth up to                        | 8xD                     |
| Point angle                              | 135 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 |
|------------------------|-----------|