Garant

Solid carbide HPC drill plain shank DIN 6535 HA, TiAIN, Ø DC h7: 4,8 mm



Order data

Order number	123110 4,8
GTIN	4045197357397
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!

Straight major 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 $1.5 \times nominal \emptyset$.

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. 123115**. Form **HE**: order with **No. 123110 + 129100 HE**. Standard: Manufacturer's standard Tolerance nominal \emptyset : h7 Number of cutting edges Z: 2 Tolerance nominal \emptyset : h7 recommended maximum drilling depth L_2 : 54.8 mm Overall length L: 100 mm Shank \emptyset D_s: 6 mm Feed f in stainless steel < 900 N/mm²: 0.08 mm/rev.

Technical description

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Data sheet

Shank toleranceh6Feed f in stainless steel < 900 N/mm²0.08 mm/rev.Nominal Ø Dc4.8 mmFlute length Lc62 mmTolerance nominal Øh7Shank Ø D,6 mmOverall length L100 mmStandardManufacturer's standardrecommended maximum drilling depth L254.8 mmCoatingTiAINTool materialSolid carbideDrill depth up to10×DPoint angle135 degreesCutting directionright-handShankDIN 6535 HA to h6Though-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesTop of productJobber drill	Number of cutting edges Z	2
Nominal Ø Dc4.8 mmFlute length Lc62 mmTolerance nominal Øh7Shank Ø Ds6 mmOverall length L100 mmStandardManufacturer's standardrecommended maximum drilling depth L254.8 mmCoatingTiAINTool materialSolid carbideDrill depth up to10×DPoint angle135 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardJoueColour ringblue	Shank tolerance	h6
Flute length L,62 mmTolerance nominal Øh7Shank Ø D,6 mmOverall length L100 mmStandardManufacturer's standardrecommended maximum drilling depth L254.8 mmCoatingTiAlNTool materialSolid carbideDrill depth up to10xDPoint angle135 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Feed f in stainless steel < 900 N/mm ²	0.08 mm/rev.
Tolerance nominal Øh7Shank Ø Ds6 mmOverall length L100 mmStandardManufacturer's standardrecommended maximum drilling depth L254.8 mmCoatingTiAlNTool materialSolid carbideDrill depth up to10×DPoint angle10×DCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Nominal Ø D _c	4.8 mm
Shank Ø D,6 mmOverall length L100 mmStandardManufacturer's standardrecommended maximum drilling depth L254.8 mmCoatingTiAlNCoatingSolid carbideTool materialSolid carbideDrill depth up to10×DPoint angle135 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Flute length L _c	62 mm
Overall length L100 mmStandardManufacturer's standardrecommended maximum drilling depth L254.8 mmCoatingTiAINTool materialSolid carbideDrill depth up to10×DPoint angle135 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Tolerance nominal Ø	h7
StandardManufacturer's standardStandardManufacturer's standardrecommended maximum drilling depth L254.8 mmCoatingTiAINTool materialSolid carbideDrill depth up to10×DPoint angle1135 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Shank Ø D _s	6 mm
recommended maximum drilling depth L254.8 mmCoatingTiAINCoatingSolid carbideTool materialSolid carbideDrill depth up to10×DPoint angle135 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Overall length L	100 mm
CoatingTiAINTool materialSolid carbideDrill depth up to10×DPoint angle135 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Standard	Manufacturer's standard
Tool materialSolid carbideDrill depth up to10×DPoint angle135 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	recommended maximum drilling depth L ₂	54.8 mm
Drill depth up to10×DPoint angle135 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Coating	TiAIN
Point angle135 degreesCutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Tool material	Solid carbide
Cutting directionright-handShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Drill depth up to	10×D
ShankDIN 6535 HA to h6Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Point angle	135 degrees
Through-coolantyes, with 25 barMachining strategyHPCSemi-StandardyesColour ringblue	Cutting direction	right-hand
Machining strategyHPCSemi-StandardyesColour ringblue	Shank	DIN 6535 HA to h6
Semi-StandardyesColour ringblue	Through-coolant	yes, with 25 bar
Colour ring blue	Machining strategy	HPC
5	Semi-Standard	yes
Type of product Jobber drill	Colour ring	blue
	Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE