

## Garant

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



#### Order data

|              |               |
|--------------|---------------|
| Order number | 123110 5      |
| GTIN         | 4045197357403 |
| 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×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. 123115**.

Form **HE**: order with **No. 123110 + 129100 HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 54.5 mm

Overall length L: 100 mm

Shank Ø  $D_s$ : 6 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.08 mm/rev.

#### Technical description

|   |                         |
|---|-------------------------|
| Shank tolerance                                   | h6                      |
| Feed f in stainless steel < 900 N/mm <sup>2</sup> | 0.08 mm/rev.            |
| Flute length L <sub>c</sub>                       | 62 mm                   |
| Number of cutting edges Z                         | 2                       |
| Nominal Ø D <sub>c</sub>                          | 5 mm                    |
| Tolerance nominal Ø                               | h7                      |
| Shank Ø D <sub>s</sub>                            | 6 mm                    |
| Overall length L                                  | 100 mm                  |
| Standard  | Manufacturer's standard |
| recommended maximum drilling depth L <sub>2</sub> | 54.5 mm                 |
| Coating   | TiAlN                   |
| Tool material                                     | Solid carbide           |
| Drill depth up to                                 | 10×D                    |
| Point angle                                       | 135 degrees             |
| Cutting direction                                 | right-hand              |
| Shank   | DIN 6535 HA to h6       |
| Through-coolant                                   | yes, with 25 bar        |
| Machining strategy                                | HPC                     |
| Semi-Standard                                     | yes                     |
| Colour ring                                       | blue                    |
| Type of product                                   | Jobber drill            |

## Services

|                        |           |
|------------------------|-----------|
| Shank grinding Type HE | 129100 HE |
|------------------------|-----------|