

**Garant**
**Solid carbide HPC drill Weldon shank DIN 6535 HB, TiAlN, Ø DC h7: 12 mm**

**Order data**

Order number	123115 12
GTIN	4045197402080
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  $L_c = L_2 + 1.5 \times D_c$

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 112 mm

Overall length L: 180 mm

Shank Ø  $D_s$ : 12 mm

Feed f in stainless steel < 900 N/mm<sup>2</sup>: 0.15 mm/rev.

**Technical description**

Feed f in stainless steel < 900 N/mm <sup>2</sup>	0.15 mm/rev.
Nominal Ø $D_c$	12 mm

Shank tolerance	h6
Number of cutting edges Z	2
Flute length L <sub>c</sub>	130 mm
Tolerance nominal Ø	h7
Shank Ø D <sub>s</sub>	12 mm
Overall length L	180 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L <sub>2</sub>	112 mm
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	10×D
Point angle	135 degrees
Cutting direction	right-hand
Shank	DIN 6535 HB to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Semi-Standard	yes
Colour ring	blue
Type of product	Jobber drill