

## Garant

**Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC m6 (mm or inch): 6,8 mm or inch**



### Order data

Order number	123212 6,8
GTIN	4045197570277
Item class	11E

### Description

#### Version:

Cutting chisel edge with **high centring accuracy** due to **strong core and special point geometry**. High roundness and alignment accuracy of the deep hole, thanks to **4 guide chamfers**. Outstanding chip evacuation due to **4 internal cooling channels** from Ø 3.8 mm. Up to 3.7 mm Ø with 2 internal cooling channels. **Straight major cutting edges** with honed edges and special flute profile for **short chips**, even on long chipping materials.

#### Recommendation:

##### Maximum drilling depth:

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

#### Note:

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

For process reliability when using the 12×D drill, an initial centre drilling with NC spotting drills No. 121068– 121130 is necessary.

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

Order form **HB**: with **No. 123214**.

Order form **HE**: with **No. 123212 + 129100HE**.

Standard: Manufacturer's standard

Tolerance nominal Ø: m6

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: m6

recommended maximum drilling depth  $L_2$ : 97.8 mm

Overall length L: 146 mm

Shank Ø  $D_s$ : 8 mm

Feed f in stainless steel > 900 N/mm<sup>2</sup>: 0.12 mm/rev.

### Technical description

Nominal $\varnothing D_c$	6.8 mm
Feed f in stainless steel > 900 N/mm <sup>2</sup>	0.12 mm/rev.
Shank tolerance	h6
Number of cutting edges Z	2
Flute length L <sub>c</sub>	108 mm
Tolerance nominal $\varnothing$	m6
Shank $\varnothing D_s$	8 mm
Overall length L	146 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L <sub>2</sub>	97.8 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12×D
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	blue
Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
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