

Garant
Solid carbide HPC drill plain shank DIN 6535 HA, TiAlN, Ø DC h7: 12 mm

Order data

Order number	123301 12
GTIN	4045197452573
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 $L_c = L_2 + 1.5 \times D_c$.

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.

Form **HB**: order with **No. 123302**.

Form **HE**: order with **No. 123301 + 129100HE**.

NEW GENERATION AVAILABLE!

Recommended successor products are No. 123225 and 123235.

Standard: Manufacturer's standard

Tolerance nominal Ø: h7

Number of cutting edges Z: 2

Semi-Standard: yes

Tolerance nominal Ø: h7

recommended maximum drilling depth L_2 : 138 mm

Overall length L: 204 mm

Shank Ø D_s : 12 mm

Feed f in steel < 1100 N/mm²: 0.26 mm/rev.

Technical description

Nominal $\varnothing D_c$	12 mm
Feed f in steel < 1100 N/mm ²	0.26 mm/rev.
Shank tolerance	h6
Number of cutting edges Z	2
Flute length L_c	156 mm
Tolerance nominal \varnothing	h7
Shank $\varnothing D_s$	12 mm
Overall length L	204 mm
Standard	Manufacturer's standard
recommended maximum drilling depth L_2	138 mm
Semi-Standard	yes
Coating	TiAlN
Tool material	Solid carbide
Drill depth up to	12xD
Point angle	135 degrees
Shank	DIN 6535 HA to h6
Through-coolant	yes, with 25 bar
Machining strategy	HPC
Colour ring	green
Type of product	Jobber drill

Services

Shank grinding Type HE	129100 HE
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