

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

**Order data**

Order number	123301 5,5
GTIN	4045197452368
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

Tolerance nominal Ø: h7

recommended maximum drilling depth  $L_2$ : 69.8 mm

Overall length L: 116 mm

Shank Ø  $D_s$ : 6 mm

Feed f in steel < 1100 N/mm<sup>2</sup>: 0.1 mm/rev.

## Technical description

Flute length $L_c$	78 mm
Feed $f$ in steel < 1100 N/mm <sup>2</sup>	0.1 mm/rev.
Number of cutting edges $Z$	2
Shank tolerance	h6
Nominal $\varnothing D_c$	5.5 mm
Tolerance nominal $\varnothing$	h7
Shank $\varnothing D_s$	6 mm
Overall length $L$	116 mm
Standard	Manufacturer's standard
recommended maximum drilling depth $L_2$	69.8 mm
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
Semi-Standard	yes
Colour ring	green
Type of product	Jobber drill

## Services

Shank grinding Type HE	129100 HE
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